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[54] **ADJUSTABLE COATING AND PRINTING APPARATUS**

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[51] Int. Cl.⁴ B05C 11/00

[52] U.S. Cl. 118/46; 118/262;
101/177

[58] Field of Search 118/46, 262, 249;
101/177

[56] **References Cited**

U.S. PATENT DOCUMENTS

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OTHER PUBLICATIONS

Gregory J. Lindner; "Nonflammable Aqueous Overcoatings Serve to Speed Ink Drying, Add Gloss to Printed Sheet"; Graphic Arts Monthly, Oct. 1977, pp. 66-69.

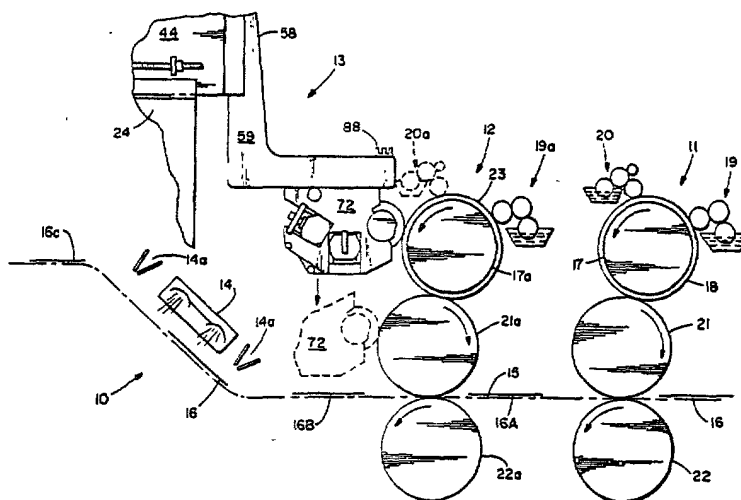
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[57] **ABSTRACT**

An offset lithographic printing machine having a plurality of in-line liquid application stations, at least one of which is an ink image printing station for printing lithographic ink images onto suitable receptive copy sheets, and the final downstream liquid-application station being a coating application station for printing a protective, and/or aesthetic coating over selected portions of, or over the entire ink image-printed surface of the copy sheets. The coating application station comprises a plate cylinder adapted to print liquid coating composition onto predetermined selected areas of the ink image-printed copy sheets by offset-transfer to an intermediate blanket cylinder, a said blanket cylinder adapted to receive said liquid coating composition from the plate cylinder for retransfer onto predetermined selected image-printed areas of the image-printed copy sheets, and also adapted to receive a continuous liquid coating composition for retransfer as a continuous overall coating over the image printed areas of the image printed copy sheets. An adjustable coating-application carriage is supported for movement into coating association with either the plate cylinder blanket cylinder desired, for the application of a printed coating over either preselected limited areas or over the entire image-printed surface of the copy sheets.

23 Claims, 4 Drawing Sheets



0335796-DEDD

FIG. 1

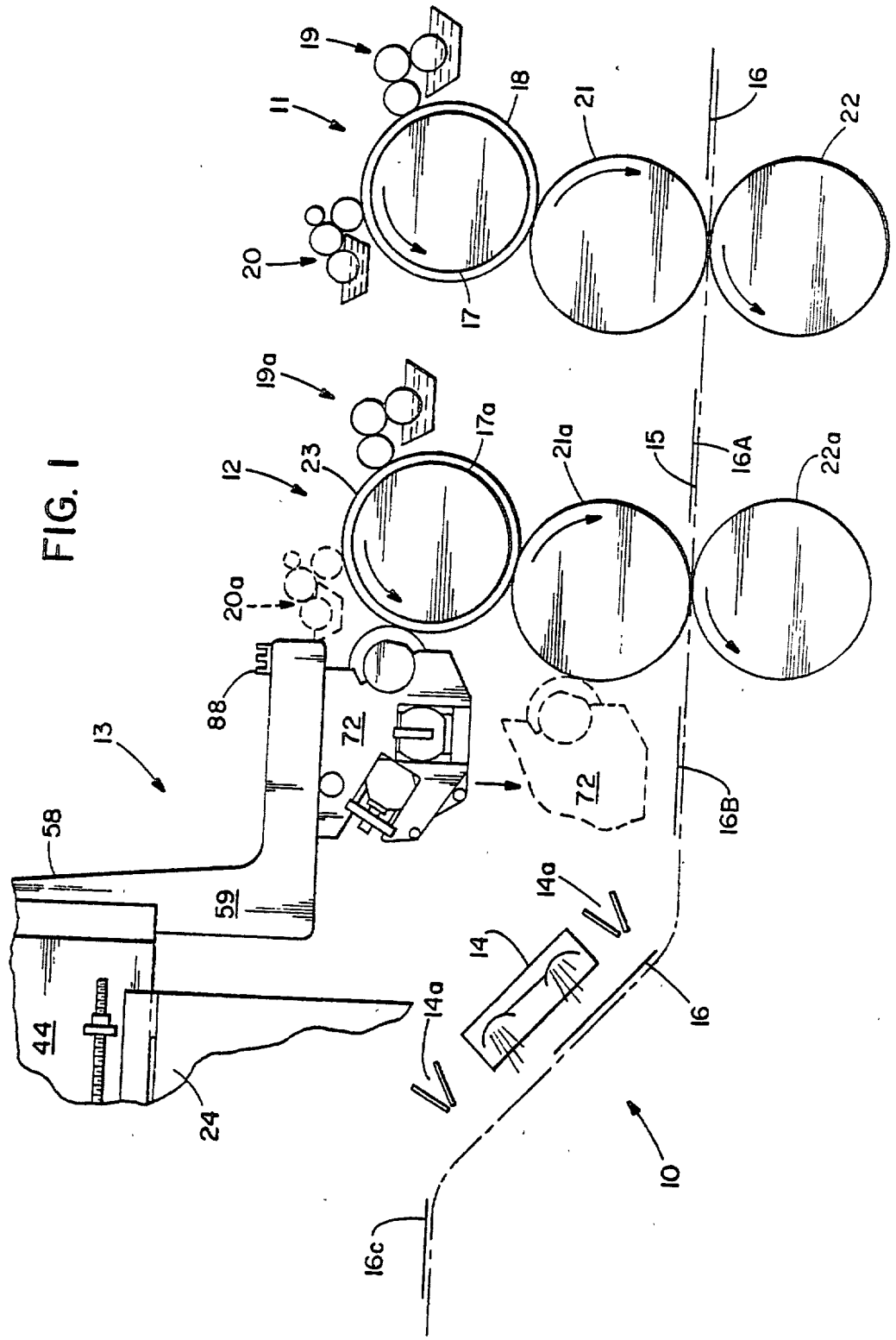
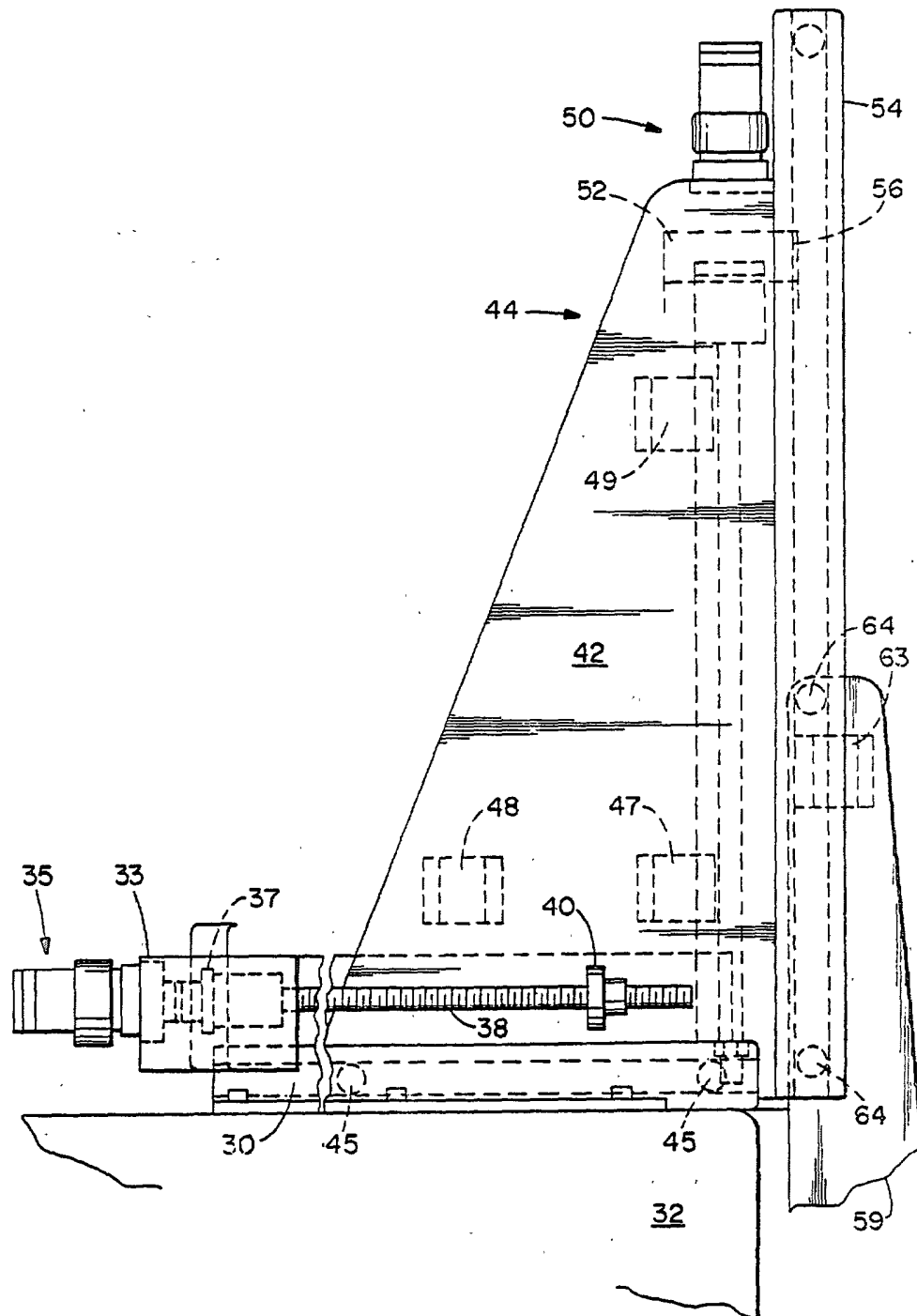


FIG. 2A



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FIG. 2B

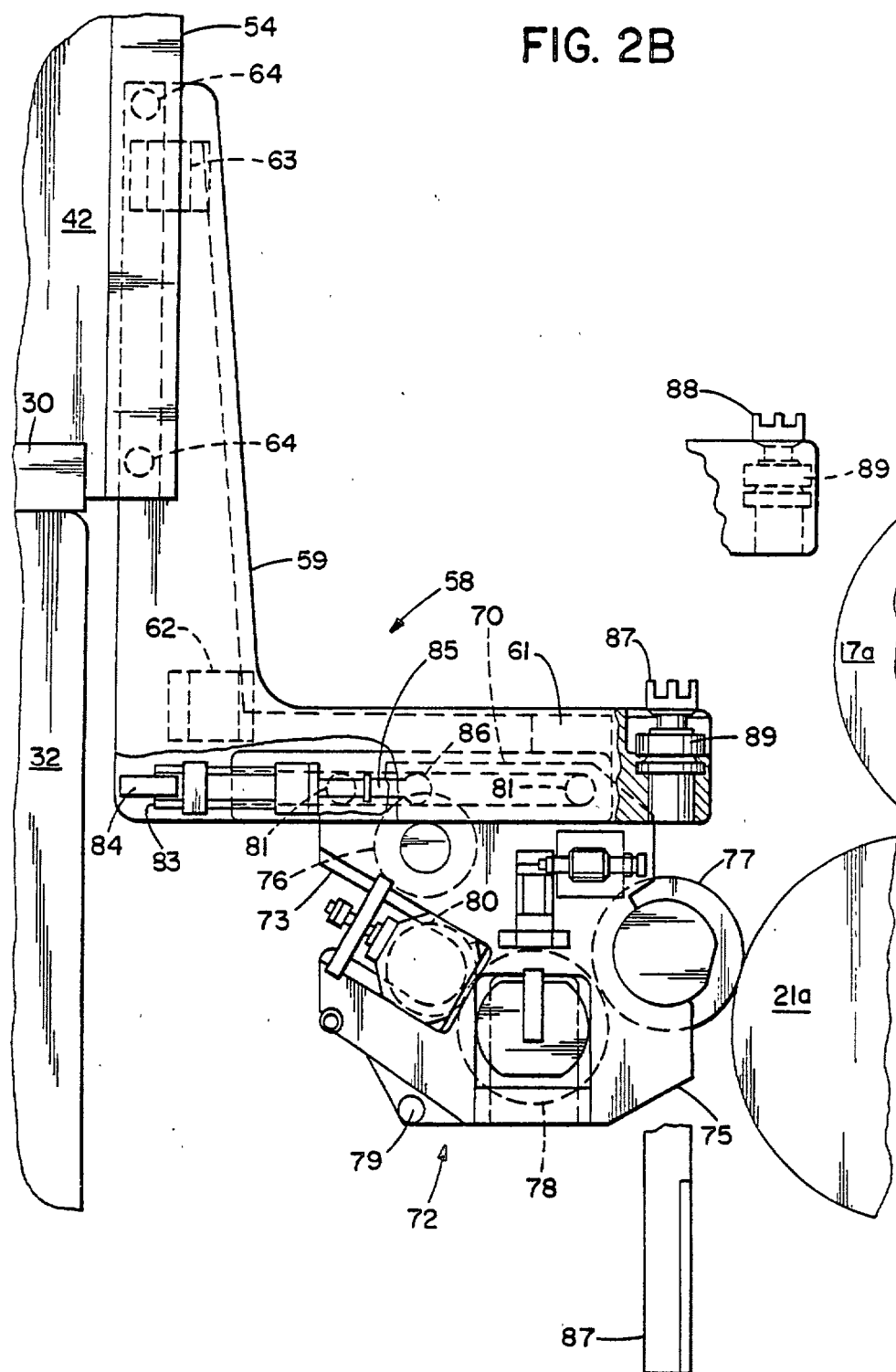


FIG. 3

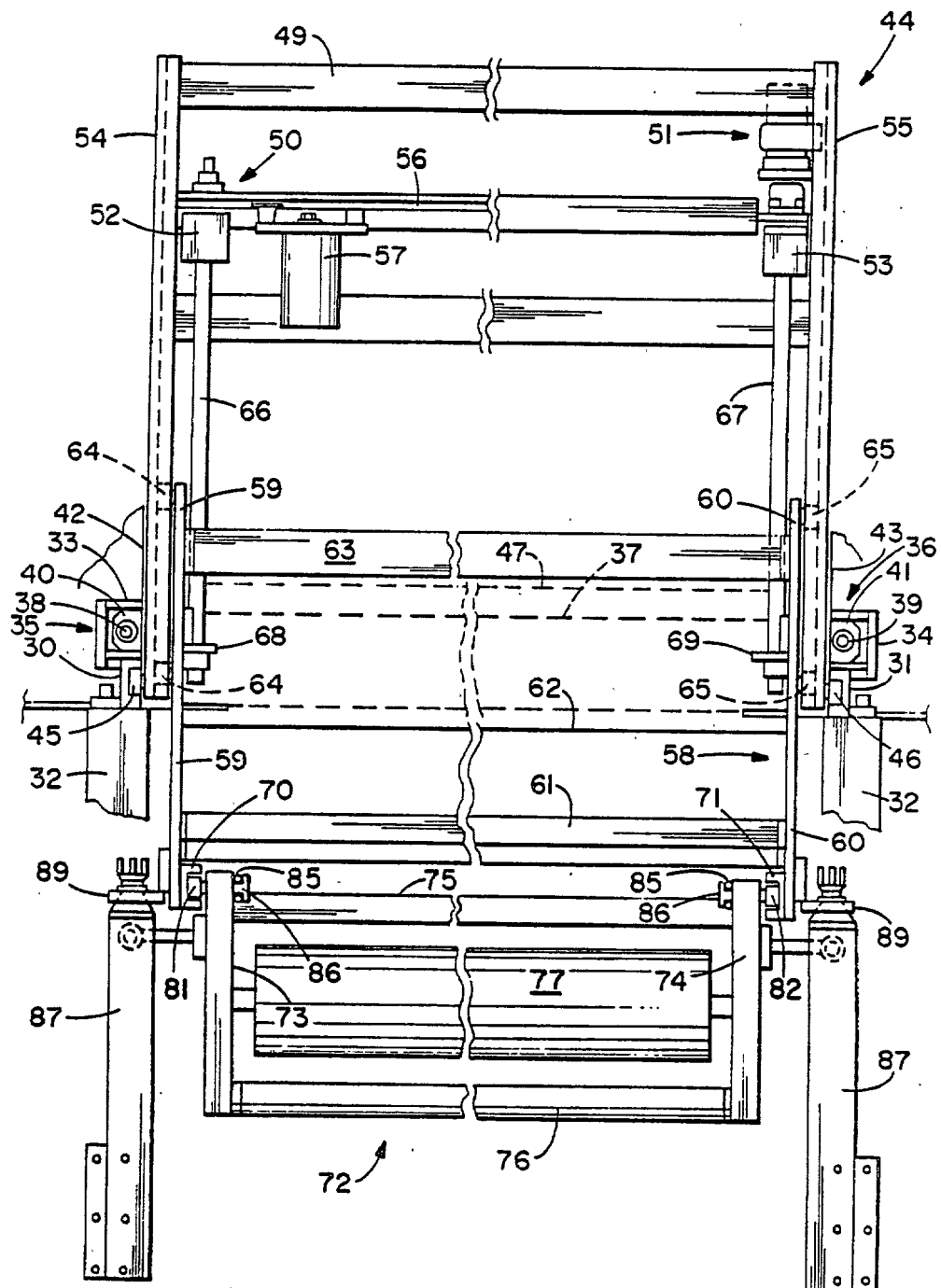


FIG. 3

ADJUSTABLE COATING AND PRINTING APPARATUS

BACKGROUND OF THE INVENTION

Conventional lithographic offset printing machines or presses comprise one or more image printing stations each having a printing roll (sometimes referred to as a plate cylinder) to which is fastened a thin hydrophilic, oleophobic printing plate having image areas which are oleophilic and hydrophobic and background areas which are oleophobic and hydrophilic. The plate surface is continuously wetted with aqueous damping solution which adheres only to the background areas, and inked with oleoresinous ink which adheres only to the image areas of the plate as wet ink. The ink is offset transferred to the rubber surface of a contacting blanket roll (sometimes referred to as a blanket cylinder), and then retransferred to the receptive surface of a copy web or a succession of copy sheets, such as of paper, where the ink air-dries by oxidation and curing after passing through a drying station.

Since image-drying is gradual, it is conventional to spray the printed copies with starch or other "stinting" powder before the copies are stacked. This prevents sticking of the ink images to adjacent copies and also permits the circulation of air for the oxidation curing process.

In cases where cost is not a factor and/or where the aesthetic advantages of a protective supercoating are desired, it is known to provide the printing machine with a downstream coating station having a blanket roll associated with a coating application unit for the application of an overall protective coating over the entire printed area of the copy sheets or web. This also avoids the necessity of powdering the printed images. Reference is made to U.S. Pat. No. 4,270,483 for its disclosure of such an apparatus. The coating unit of U.S. Pat. No. 4,270,483 is pivotally-associated with the blanket roll for movement between coating and noncoating or retracted positions.

It is known to apply pattern coatings of protective composition by means of blanket rolls by cutting into the rubber surface of the blanket to leave raised or relief surface islands which selectively receive the coating composition from the application roll for retransfer to selected areas of the copy sheets in the form of pattern coatings. This procedure has several disadvantages. The make-ready time required for the preparation of such relief blanket rolls is excessive and the procedure requires the tedious, precision efforts of an expert in order to approximate the required registration, whereas precise relief printing plates used on a printing roll can be produced photographically in a short period of time with a minimum of effort and expertise. Moreover, the attachment of a relief printing plate to a plate cylinder provides some degree of adjustability, axially as well as circumferentially, to provide better registration if necessary, whereas no adjustment of the relief portions is possible relative to the blanket roll or cylinder.

Protective coating compositions also improve the appearance of printed documents, particularly high quality, multi-color copies such as posters, record jackets, product brochures, etc., by providing glossy or matte finishes over the entire image-printed surface or over selected image-printed portions thereof such as photographs, product illustrations, etc. Selected area coating, spot coating or perfect registration over prede-

termined limited printed areas of the copies is advantageous from a cost standpoint since the coating compositions are relatively expensive and the volume required is reduced if the coating is only printed in registration where desired. Also, spot coating is frequently used as a means for highlighting certain portions of the printed copies such as company name or logo, product illustrations, photographs, etc.

While the cost of the protective coating compositions is an important factor, a more important cost factor is the necessity of removing the printed copies from an offset printing press and then running them a second time through a coating machine to print either a full protective coating or a spot protective coating, as desired. This problem is overcome by U.S. Pat. No. 4,270,483 with respect to the in-line printing of overall or continuous protective coatings but the problem of providing in-line spot printing of protective coatings with a minimum of make-ready time and a high degree of precision thickness remains.

SUMMARY OF THE INVENTION

An essential objective of the present invention is to provide a printing machine or press for the printing of imaged subject matter onto a receptive substrate, such as a copy web or a succession of copy sheets, said printing machine having a downstream coating station designed for the application of either continuous or spot coatings, as desired, over the image-printed copies in a continuous in-line process.

Another object of the present invention is to provide a coating apparatus designed to be mounted at the final downstream ink-application station of a conventional offset printing machine or press having a plurality of ink-application stations to convert said machine or press, intermittently if desired, to the in-line application of either continuous or spot coatings, as desired.

Yet another object of this invention is the provision of a single coating application apparatus mounted in association with the final downstream liquid application station of a printing press having a plurality of liquid application stations, each having a plate cylinder, a blanket cylinder and an impression cylinder, the coating application apparatus comprising a coating carriage which is adjustable between one coating position in which it coats the plate cylinder and another coating position in which it coats the blanket cylinder of the final downstream station to convert said station to a coating station for the application of either spot or continuous coatings to the surface of the image-printed copies.

The novel apparatus of the present invention comprises a coating application apparatus for an offset printing machine and a printing machine containing such an apparatus, the coating application apparatus having a movable carriage designed for operative association in one position with the plate cylinder and in another position with the blanket cylinder of the final liquid application station of the offset printing machine, the coating carriage being adjustably supported for automatic movement between said two different coating positions. One coating position brings the coating application roll of the carriage into coating association with the plate cylinder for the offset formation of predetermined printed spot coatings onto predetermined image-printed areas of the copy sheets. The other coating position brings the coating application roll of the car-

riage into coating association with the blanket cylinder for the offset formation of a continuous coating onto the entire image-printed surface of the copy sheets. This enables the printing machine to image-print and coat-print the copy web or sheets in a continuous in-line operation, the apparatus being adjustable in simple fashion with a minimum make-ready time to adapt the coat-print step to the application of either spot coatings or continuous coatings depending upon the requirements of the printing operation. This increases the versatility of the offset printing machine, avoids the need for separate printing machines or for separate runs of the printed stock and enables the in-line precise printing of spot coatings in tight register and adjustable thickness, which was not possible with any prior-known offset printing machine.

The novel apparatus of the present invention enables the final downstream liquid application station of the printing machine to be used as either an ink-printing station or as a coating-application station and permits simple and rapid conversion between such utilities.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a vertical cross-sectional view through two downstream liquid application stations of an offset printing machine, illustrating a coating-application unit according to one embodiment of the present invention;

FIGS. 2A and 2B are segmented, detailed side views of coating application unit of FIG. 1 and

FIG. 3 is a horizontal front view of the coating application unit of FIG. 2.

DETAILED DESCRIPTION OF THE INVENTION

Referring to the drawings, FIG. 1 illustrates a downstream portion of an offset printing machine 10 comprising two liquid application stations 11 and 12, the latter including a coating apparatus 13 comprising a coating carriage 58, a radiation drying station 14 including air knives 14a, and a continuous copy sheet gripper system 15 which moves a succession of copy sheets 16 through the printing machine.

The first liquid application station 11 is a conventional offset image printing station comprising a plate cylinder 17, to which is clamped an imaged lithographic printing plate 18 carrying oleophilic image areas, such as words, photographs, etc. on an oleophilic background. The conventional clamping means permits some degree of lateral or axial adjustment and some degree of wrap-around or circumferential adjustment of the plate 18 relative to the plate cylinder 17. Plate cylinder 17 is associated with a dampening system 19 for wetting the entire background surface of plate 18 with aqueous dampening fluid, and with an inking system 20 for inking the imaged areas of the plate 18 with liquid oleoresinous ink.

The inked plate 18 is rotated against the ink receptive surface of a blanket cylinder 21, to which the wet ink images are offset or transferred, and the blanket cylinder 21 is rotated against a copy sheet 16, passed in the nip between the blanket cylinder 21 and an impression cylinder 22, to transfer the wet ink images to the copy sheet 16 and form an image-printed copy sheet 16A which is conveyed to the last liquid application station 12 which includes the coating application apparatus of the present apparatus.

The coating application station 12 can be similar to the inking station 11 with respect to the plate cylinder

17a supporting a printing plate dampening system 19a, blanket cylinder 21a and impression cylinder 22a since in a conventional offset printing machine having a plurality of liquid application stations, all of the stations are generally similar but use different printing plates to image different areas of the same copy sheet with different colored inks. The present apparatus modifies the final downstream inking station to convert it permanently or intermittently to a versatile coating station.

Plate 23 is an offset relief printing plate, preselected areas of which are raised above the background, generally referred to as "relief spots". Such spots are sized and positioned to correspond to areas of the image-printed copy sheets 16a which it is desired to selectively coat.

The essential novelty of the apparatus of FIG. 1 resides in the adjustable coating apparatus 13 which is mounted onto the frame 24 of the printing machine for extension of the coating carriage 58 into the liquid application station 12 for adjustable coating association with either the coating plate cylinder 17a or the coating blanket cylinder 21a, as desired.

The coating application apparatus 13, shown in greater detail in FIGS. 2 and 3, comprises a preferred embodiment of the present invention in that it includes a coating carriage 58 which is horizontally adjustably, in the machine direction, for movement between retracted or passive position and extended or active position, and also vertically adjustable for movement between the levels of the plate cylinder and the blanket cylinder. Moreover, the coating carriage 58 comprises a horizontally adjustable coating applicator unit 72 which is movable in the machine direction between different extended coating positions to accommodate plate and blanket cylinders which are not in vertical alignment, as shown by FIGS. 1 and 2B.

The coating application apparatus 13 of FIGS. 2A and 3 comprises a spaced pair of parallel, horizontal support rails 30 and 31 or legs designed to be bolted to frame portions 32 of the printing machine beyond station 12, rails 30 and 31 each being fastened to a gear housing 33, 34 of a hydraulic horizontal screw drive member 35, 36 connected to each other for simultaneous operation by a drive chain 37. The screw drive members 35 and 36 comprise reversible drive screws 38, 39 which threadably engage nuts 40, 41 which are fixed to the spaced vertical walls 42, 43 of the vertical lift housing 44.

Housing 44 is provided adjacent the bases of walls 42 and 43 with outward projecting cam follower or wheel pairs 45, 46 which are engaged within the horizontal tracks of the rails 30 and 31 to support the vertical lift housing 44 for horizontal movement between extended or active position, illustrated by FIGS. 1 and 2B, and retracted or passive position under the effects of hydraulic activation of the screw drive members 35 and 36. Walls 42 and 43 of housing 44 are fastened together and reinforced by cross-beams 47, 48 and 49.

Vertical or height adjustment of the coating application carriage 58 is made possible by a second pair of associated vertical screw drive members 50 and 51, shown most clearly in FIG. 3, each having a gear housing 52, 53 attached to the upper end of a vertical rail member, 54, 55 of the housing 44, and being connected to each other for simultaneous reversible operation by means of a drive chain 56 through a hydraulic motor 57.

Vertical lift housing 44 supports the vertically adjustable carriage 58 which comprises a spaced pair of L-

shaped side wall members 59 and 60 fastened together by cross-beams 61, 62 and 63. The vertical extensions of wall members 59 and 60 are provided with cam follower or wheel pairs 64, 65 which ride within the vertical tracks of rail members 54 and 55 on the inside of housing walls 42, 43 to raise and lower the vertical carriage section 58 under the activation of the screw drive members 50 and 51 since the drive screws 66 and 67 thereof threadably engage nuts 68 and 69, respectively, which are fastened to the lower ends of the vertical extensions of the L-shaped wall members 59 and 60.

The horizontal extensions of the L-shaped wall members 59 and 60 of the carriage 58 comprise lower horizontal track members 70 and 71 which support the coating application unit 72 of the carriage for horizontal adjustment therewithin.

Coating application unit 72 of carriage 58 comprises spaced, parallel side frames 73 and 74 fastened together by cross members 75 and 76 and supporting coating applicator roll 77, pick-up roll 78 positioned to pick up liquid coating composition from the coating pan 79, and adjustable metering roll 80 positioned to control the amount of coating composition passed by the pick-up roll 78 to the applicator roll 77. The outer surfaces of the side frames 73 and 74 are provided adjacent the top edge of each with a spaced pair of cam followers or wheels 81, 82 which ride within the horizontal tracks of the track members 70, 71 of the L-shaped wall members 59 and 60, to support the coating applicator unit 72 for adjustable horizontal movement within the carriage 58.

As shown by FIG. 2, movement of the coating unit 72 is controlled by a pair of hydraulic cylinders 83 each attached by a bracket 84 to an L-shaped wall member 59, 60 in horizontal alignment with the track members 70 and 71, and having their rod end 85 attached to the inside wall of side frames 73, 74 at posts 86. Activation of the hydraulic cylinders causes the coating unit 72 to move horizontally along track members 70 and 71 to position the leading edge of the applicator roll 77 for coating association with either the coating blanket cylinder 21a, as shown in FIG. 2B, or the coating plate cylinder 17a, as shown in FIG. 1. Preferably the printing machine frame is provided with spaced pairs of latch posts 87 and 88 or support brackets associated with the location of the blanket cylinder 21a and the plate cylinder 17a for engagement within latch brackets 89 attached to the outer surfaces of the horizontal extensions of the L-shaped wall members 59 and 60 in the area of the forward end of the track members 70 and 71. The engagement of the fixed latch post pair 87 within the latch brackets 89 secures the coating applicator carriage 72 in one position for coating the blanket cylinder 21a, as shown in FIGS. 2B and 3, while the engagement of the fixed latch post pair 88, shown by broken lines in FIG. 2B, within the same latch brackets 89 secures the coating applicator carriage 72 in another position, shown in FIG. 1, for coating the plate cylinder 17a. Such engagement requires a presetting of the sequence and duration of operation of the various hydraulic mechanisms. Engagement and disengagement of the latch brackets 89 on posts 87 and 88 requires vertical movement of the carriage 58 within the vertical lift housing 44 by predetermined directional and timed activation of the vertical screw drive members 50 and 51. Vertical alignment of the latch brackets 89 with the latch post pairs 87 and 88 must first be accomplished. This requires horizontal movement of the vertical lift housing 44 supporting the carriage 58 including the

coating applicator unit 72, and is accomplished by predetermined directional and timed activation of the horizontal screw drive members 35 and 36, for movement of the vertical lift housing 44 from retracted, non-coating position to extended, aligned position. Movement of the coating applicator unit 72 into coating position requires predetermined directional and timed activation of the horizontal hydraulic cylinders 83. Adjustable stop members may be incorporated to limit the various movements.

As will be clear to those skilled in the offset printing art, the novel printing and coating apparatus of the present invention enables the modification of a conventional offset printing machine having a plurality of liquid application stations to convert it to a printing and coating apparatus which is adjustable in simple manner for the alternative application of either full coatings or spot coatings. Moreover, such modification may be temporary, if desired, so that the final downstream liquid application station may be used for its intended purpose for the application of printed ink images or for its modified purpose for printing overall or spot coatings. The conversion from printing use to spot coating use merely requires retracting or disengaging the ink applicator roll of unit 20a to position shown by broken lines in FIG. 1, replacing the image printing plate on plate cylinder 17a with a relief coating plate 23, cleaning the surface of the blanket cylinder 21a and moving the coating application unit 13 horizontally from retracted position to extended position. If overall or complete coatings are desired it is only necessary to retract or disengage the plate cylinder 17a from coating association with the blanket cylinder 21a, without any alteration of the plate cylinder 17a or its printing plate 23 or ink application unit 20a.

The present coating applicator roll 77 has a substantially smaller diameter than that of the plate cylinder 17a or the blanket cylinder 21a, the diameters of which are equal. The speed of rotation of the applicator roll 77 is adjustable so that its surface speed may be the same as or slower or faster than the surface speed of cylinders 17a and 21a, or in reverse rotation thereto, to provide a brushing action relative thereto, if desired. Such brushing action provides a shearing of the coating composition in the nip therebetween, and a relatively heavy or thick direct deposit of coating composition on cylinders 17a and 21a in cases where the surface speed of roll 77 is faster than that of roll 17a or 21a. This is desirable particularly for the application of spot coatings, since the coating thickness is always split to about one-half as the spot coating is transferred from the relief plate 23 of plate cylinder 17a to the blanket cylinder 21a, and further, split to about one quarter when the spot coating is transferred from the blanket cylinder 21a to the printed copy sheets 16A. The effect of such inherent splitting is reduced by increasing the coating thickness on the relief areas of plate 23.

In cases where the coating composition is applied directly to the blanket cylinder 21a, for the application of continuous coatings to the printed copy sheets 16A, the plate cylinder 17a is retracted from contact with the blanket cylinder 21a so that the only coating split occurs during transfer from the blanket cylinder 21a to the imaged copy sheets 16A.

The offset printing machines to which the present invention applies are conventional machines and therefore the present disclosure does not include details regarding the support structure for the various rolls,

dampening units, inking units, sheet conveyor system, drying station, or copy sheet supplying and stacking stations. In most modern printing machines, the sheet conveyor system is not a gripper belt or chain but rather comprises automatic grippers on a series of contacting impression cylinders and transfer cylinders.

Also, the present coating compositions and systems for providing continuous supplies thereof to the coating applicator unit are conventional in the art.

The terms "vertically" and "horizontally" are used herein and in the appended claims to define general directions of movement, including angular vertical movement from one level to another and/or angular movement in the machine direction. For example, on printing machines where the coating plate cylinder is not in perfect vertical alignment above the blanket cylinder it may be preferable that the vertical rail or track of the vertical lift housing is inclined at an angle similar to the angle from vertical formed by a straight line contacting the surfaces of the plate cylinder and the blanket cylinder to be contacted by the coating applicator roll. Movement of the coating carriage along such an inclined vertical rail is both generally vertical and generally horizontal. Similarly the horizontal track members for the support legs of the apparatus and/or for the coating applicator unit may also be angular to provide some degree of vertical movement in cases where the design of the printing machine frame supporting the present apparatus makes it necessary or advantageous.

It is to be understood that the above described embodiments of the invention are illustrative only and that modifications throughout may occur to those skilled in the art. Accordingly, this invention is not to be regarded as limited to the embodiments disclosed herein, but is to be limited as defined by the appended claims.

What is claimed is:

1. An adjustable in-line coating application apparatus for attachment in association with a downstream liquid application station of an offset printing machine having a plurality of liquid application stations, for converting said downstream liquid application station to a coating application station for applying either continuous or spot coatings over the printed surface of a succession of copy sheets carrying ink images printed thereon at one or more upstream liquid application stations, said downstream liquid application station containing a blanket cylinder positioned to contact said plurality of printed copy sheets and an offset plate cylinder in vertical elevation above said blanket cylinder and supported for adjustment into and out of coating association therewith, said coating application apparatus having vertical guide means, a coating carriage attached to said support for substantially vertical movement along said guide means, said carriage comprising a coating application unit, including a container for a supply of liquid coating composition and an elongate coating applicator roll supported to receive a uniform supply of said composition on the surface thereof and to transfer a uniform supply of said composition to the surface of either a plate cylinder or a blanket cylinder in coating association therewith, and mechanical adjustment means for moving said carriage on said guide means relative to said support vertically between elevations corresponding to the locations of the blanket cylinder and the plate cylinder of an offset printing machine in order to move said coating applicator roll into coating

association with either said blanket cylinder or said plate cylinder, as desired.

2. An apparatus according to claim 1 in which the support for said coating application apparatus comprises a spaced pair of parallel elongate horizontal leg members designed to be fastened relative to the frame of an offset printing machine.

3. An apparatus according to claim 2 in which said support comprises a parallel pair of spaced vertical wall members which are fastened to each other to form a vertical guide means on a vertical lift housing for said coating carriage.

4. An apparatus according to claim 3 in which said horizontal leg members comprise horizontal tracks, and said vertical wall members are movably attached to said horizontal tracks to permit horizontal adjustment of the position of said vertical lift housing.

5. An apparatus according to claim 4 in which said coating carriage comprises a parallel pair of vertical side members which are fastened to each other to form said carriage, each said side member being supportingly-engaged by a vertical guide means on a wall member of the vertical lift housing for vertical movement of said carriage relative to said housing.

6. An apparatus according to claim 5 in which each of the vertical side members of the carriage includes a lower, horizontal support extension to which the coating application unit is attached.

7. An apparatus according to claim 6 in which the horizontal support extensions comprise horizontal tracks to which the coating applicator unit is attached to permit horizontal adjustment of the coating applicator unit on the carriage relative to the vertical lift housing.

8. An apparatus according to claim 1 in which said coating carriage comprises releasable latching means for securing the unit relative to the frame of an offset printing machine when the carriage is positioned for movement of the applicator unit into coating association with either the blanket cylinder or the plate cylinder.

9. An apparatus according to claim 5 comprising automatic mechanical means for moving said carriage vertically relative to said vertical lift housing, said means comprising a vertical screw drive assembly one end of which is fastened to a vertical side wall of said housing and the other end of which is fastened to an adjacent vertical side member of said carriage.

10. An apparatus according to claim 4 in which said horizontal adjustment of the position of the vertical lift housing is provided by at least one horizontal screw drive assembly one end of which is fastened to a horizontal leg member and the other end of which is fastened to an adjacent wall member of the vertical lift housing.

11. An assembly according to claim 7 which further comprises means for causing horizontal movement of the coating applicator unit relative to the coating carriage, said means comprising at least one horizontal drive member one end of which is fastened to the applicator unit and the other end of which is fastened to the horizontal support extension of the carriage.

12. An offset printing machine having a frame supporting a plurality of in-line liquid application stations, each station comprising a blanket cylinder positioned to contact a succession of copy sheets to apply liquid thereto, and an offset plate cylinder in printing association with said blanket cylinder to apply liquid to prede-

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terminated areas thereof for transfer to said blanket cylinder and retransfer to said copy sheets, the final downstream liquid application station comprising a liquid coating station for the application of continuous or spot coatings over areas of the copy sheets which are image-printed with ink in at least one upstream liquid application station which is an ink printing station, said liquid coating station having said plate cylinder and said blanket cylinder in vertical elevation relative to each other and comprising a coating application carriage including a coating applicator unit having a container for liquid coating composition and a coating applicator roll which receives a continuous supply of said liquid coating composition from said container, and vertical guide means for supporting said coating application carriage for mechanically-adjustable vertical movement along said guide means between a first coating elevation position in which said coating applicator roll is in coating association with said blanket cylinder and a second coating elevation position in which said coating applicator roll is in coating association with said plate cylinder, whereby said carriage can be moved mechanically to said first position to cause the application of a continuous liquid coating to the image printed surface of the copy sheets, and can be moved mechanically to said second position to cause the application of spot liquid coatings to predetermined limited areas of the image printed surface of the copy sheets.

13. A machine according to claim 12 in which said carriage is movable out of coating association with said blanket and/or plate cylinders and said final downstream liquid application station is adapted for alternative use as another ink printing station.

14. A machine according to claim 12 in which the means for supporting said coating application carriage includes a spaced pair of horizontal leg members designed to support the coating application carriage in association with final downstream liquid application station.

15. A machine according to claim 12 in which the means for supporting said coating application carriage includes a parallel pair of vertical wall members which are fastened to each other and to said guide means to form a vertical lift housing for said carriage.

16. A machine according to claim 15 in which said vertical wall members are movably attached to horizontal track members to permit horizontal adjustment of the position of said vertical lift housing relative to the blanket and plate cylinders.

17. A machine according to claim 16 in which said coating carriage comprises a parallel pair of vertical side members which are fastened to each other to form said carriage each said side member being supportingly engaged by a vertical guide means on a wall member of the vertical lift housing for vertical movement of said carriage relative to said housing and between at least said first and second coating positions.

18. A machine according to claim 17 in which each of said vertical side members of the carriage includes a lower horizontal support extension to which the coating applicator unit is attached.

19. A machine according to claim 18 in which said horizontal support extensions comprise horizontal tracks to which the coating applicator unit is attached to permit horizontal adjustment of the coating applicator unit relative to the coating carriage and the blanket and plate cylinders.

20. A machine according to claim 12 in which the frame of said machine includes first position latching means associated with the blanket cylinder, and second position latching means associated with the plate cylinder in said coating application station, and said coating carriage includes mating latching means which engage said position latching means when the carriage is moved into said first coating position and into said second coating position.

21. A machine according to claim 17 comprising automatic mechanical means for moving said carriage vertically relative to said vertical lift housing, said means comprising at least one vertical screw drive assembly one end of which is fastened to a vertical side wall of said housing and the other end of which is fastened to an adjacent vertical side member of said carriage.

22. A machine according to claim 16 which comprises automatic means for providing horizontal adjustment of the position of the vertical lift housing comprising at least one horizontal screw drive assembly one end of which is fastened to a horizontal track member and the other end of which is fastened to an adjacent wall member of the vertical lift housing.

23. A machine according to claim 19 which further comprises means for causing horizontal adjustment of the coating applicator unit relative to the coating carriage, said means comprising at least one horizontal drive member one end of which is fastened to the applicator unit and the other end of which is fastened to the horizontal support extension of the coating carriage.

* * * * *

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	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100		
1	1.0000	0.9999	0.9998	0.9997	0.9996	0.9995	0.9994	0.9993	0.9992	0.9991	0.9990	0.9989	0.9988	0.9987	0.9986	0.9985	0.9984	0.9983	0.9982	0.9981	0.9980	0.9979	0.9978	0.9977	0.9976	0.9975	0.9974	0.9973	0.9972	0.9971	0.9970	0.9969	0.9968	0.9967	0.9966	0.9965	0.9964	0.9963	0.9962	0.9961	0.9960	0.9959	0.9958	0.9957	0.9956	0.9955	0.9954	0.9953	0.9952	0.9951	0.9950	0.9949	0.9948	0.9947	0.9946	0.9945	0.9944	0.9943	0.9942	0.9941	0.9940	0.9939	0.9938	0.9937	0.9936	0.9935	0.9934	0.9933	0.9932	0.9931	0.9930	0.9929	0.9928	0.9927	0.9926	0.9925	0.9924	0.9923	0.9922	0.9921	0.9920	0.9919	0.9918	0.9917	0.9916	0.9915	0.9914	0.9913	0.9912	0.9911	0.9910	0.9909	0.9908	0.9907	0.9906	0.9905	0.9904	0.9903	0.9902	0.9901	0.9900	
2	0.9999	1.0000	0.9999	0.9998	0.9997	0.9996	0.9995	0.9994	0.9993	0.9992	0.9991	0.9990	0.9989	0.9988	0.9987	0.9986	0.9985	0.9984	0.9983	0.9982	0.9981	0.9980	0.9979	0.9978	0.9977	0.9976	0.9975	0.9974	0.9973	0.9972	0.9971	0.9970	0.9969	0.9968	0.9967	0.9966	0.9965	0.9964	0.9963	0.9962	0.9961	0.9960	0.9959	0.9958	0.9957	0.9956	0.9955	0.9954	0.9953	0.9952	0.9951	0.9950	0.9949	0.9948	0.9947	0.9946	0.9945	0.9944	0.9943	0.9942	0.9941	0.9940	0.9939	0.9938	0.9937	0.9936	0.9935	0.9934	0.9933	0.9932	0.9931	0.9930	0.9929	0.9928	0.9927	0.9926	0.9925	0.9924	0.9923	0.9922	0.9921	0.9920	0.9919	0.9918	0.9917	0.9916	0.9915	0.9914	0.9913	0.9912	0.9911	0.9910	0.9909	0.9908	0.9907	0.9906	0.9905	0.9904	0.9903	0.9902	0.9901	0.9900
3	0.9998	0.9999	1.0000	0.9999	0.9998	0.9997	0.9996	0.9995	0.9994	0.9993	0.9992	0.9991	0.9990	0.9989	0.9988	0.9987	0.9986	0.9985	0.9984	0.9983	0.9982	0.9981	0.9980	0.9979	0.9978	0.9977	0.9976	0.9975	0.9974	0.9973	0.9972	0.9971	0.9970	0.9969	0.9968	0.9967	0.9966	0.9965	0.9964	0.9963	0.9962	0.9961	0.9960	0.9959	0.9958	0.9957	0.9956	0.9955	0.9954	0.9953	0.9952	0.9951	0.9950	0.9949	0.9948	0.9947	0.9946	0.9945	0.9944	0.9943	0.9942	0.9941	0.9940	0.9939	0.9938	0.9937	0.9936																																			

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[54] COATING AND PRINTING APPARATUS INCLUDING AN INTERSTATION DRYER

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[73] Assignee: Birow, Inc., Westport, Conn.

[21] Appl. No.: 65,914

[22] Filed: Jun. 24, 1987

[51] Int. Cl.⁴ B05C 11/00

[52] U.S. Cl. 118/46; 101/201; 101/217; 118/66; 118/258; 118/262; 118/264; 118/602; 427/258; 427/382; 427/411

[58] Field of Search 118/46, 66, 602, 258, 118/264, 262; 101/201, 217; 427/382; 258, 411

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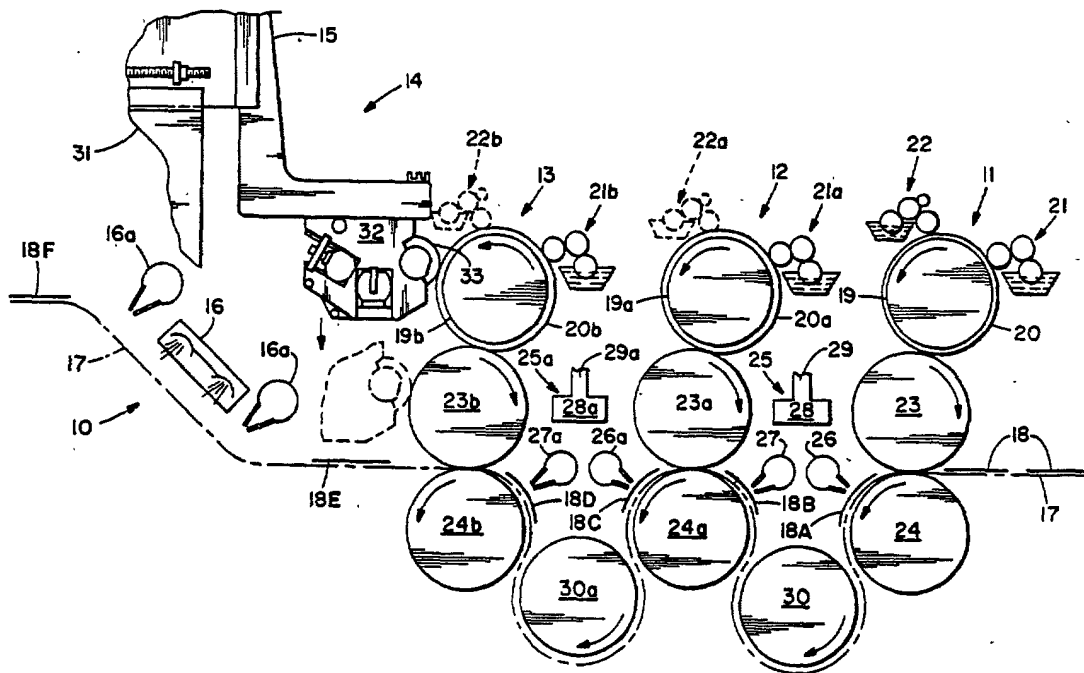
Primary Examiner—Bernard Pianalto

Attorney, Agent, or Firm—Perman & Green

[57] ABSTRACT

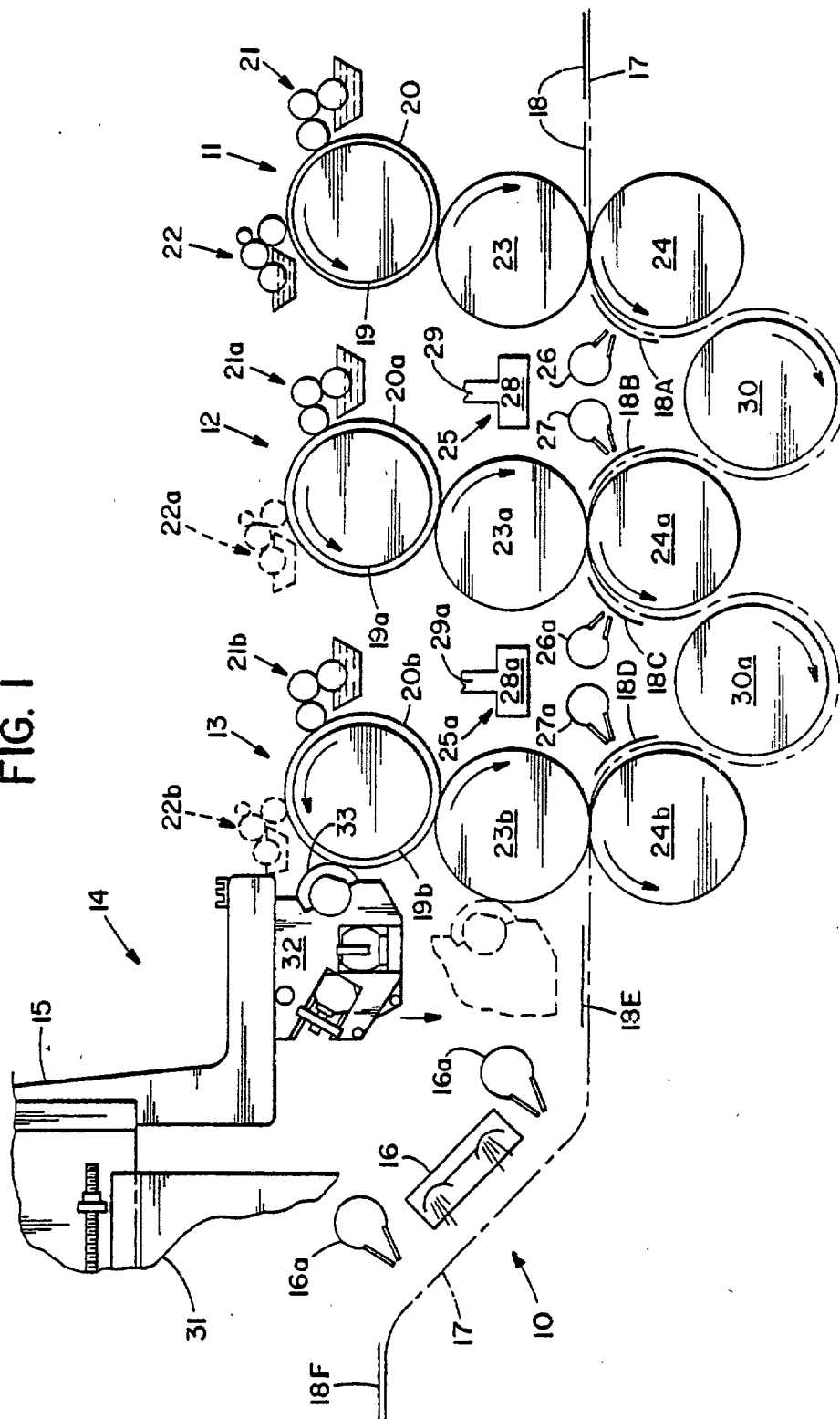
An offset lithographic printing method and machine having a plurality of in-line liquid application stations, at least one of which is an ink image-printing station for printing lithographic ink images on a suitable receptive copy sheet, and at least the final downstream liquid-application station is a coating application station for printing a protective, and/or aesthetic coating over selected portions of, or over the entire ink image-printed surface of the copy sheet. The present method and apparatus involves the placement of a drying station between liquid application stations to evaporate volatile solvent or vehicle from the ink images and/or to solidify the liquid coating applied at upstream stations before the application of a continuous or spot coating thereover at the next downstream coating station.

5 Claims, 1 Drawing Sheet



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FIG. 1



COATING AND PRINTING APPARATUS INCLUDING AN INTERSTATION DRYER

BACKGROUND OF THE INVENTION

Conventional lithographic offset printing machines or presses comprise one or more image-printing stations each having a plate cylinder to which is fastened a thin hydrophilic, oleophobic printing plate having image areas which are oleophilic and hydrophobic and background areas which are oleophobic and hydrophilic. The plate surface is continuously wetted with aqueous damping solution, which adheres only to the background areas, and is then inked with oleoresinous ink composition which adheres only to the image areas of the plate as wet ink. The ink is offset-transferred to the rubber surface of a contacting blanket cylinder, and then retransferred to the receptive surface of a copy web or a succession of copy sheets, such as of paper, where the ink gradually hardens or cures by oxidation after passing through a final drying station located downstream of the final liquid application station where the volatile solvent is evaporated from the ink composition of the images.

Since image-curing is gradual, it is conventional to spray the printed copies with starch or other "stinting" powder before the copies are stacked. This prevents sticking of the uncured ink images to adjacent copies and also permits the circulation of air for the oxidation-curing process.

In cases where cost is not a factor and/or where the aesthetic advantages of a protective supercoating are desired, it is known to provide the printing machine with a downstream coating station having a blanket cylinder associated with a coating application unit for the application of an overall protective coating over the entire printed area of the copy sheets or web.

This also avoids the necessity of powdering the printed images. Reference is made to U.S. Pat. No. 4,270,483 for its disclosure of such an apparatus. The coating unit of U.S. Pat. No. 4,270,483 is pivotally-associated with the blanket cylinder for movement between coating and non-coating or retracted positions. Reference is also made to my copending U.S. patent application, Serial No. 65,954, filed on even date herewith.

Protective coating compositions also improve the appearance of printed documents, particularly high quality, multi-color copies such as posters, product brochures, etc., by providing glossy or matte finishes over the entire image-printed surface or over selected image-printed portions thereof such as photographs, product illustrations, etc. Selected area coating, spot coating or perfect registration over predetermined limited printed areas of the copies is advantageous from a cost standpoint since the coating compositions are relatively expensive and the volume required is reduced if the coating is only printed in registration where desired. Also, spot coating is frequently used as a means for highlighting certain portions of the printed copies such as company name or logo, product illustrations, photographs, etc.

While the in-line application of a protective or aesthetic coating over the offset-printed images on a succession of copy sheets will prevent the dried but uncured printed images from sticking to adjacent copy sheets, the relatively wet condition of the printing ink composition and its solvent and/or diluent content, at

the time that the coating composition is applied thereover, and the presence of water from the dampening system in the copy sheets, produces a visible change in the appearance of the portions of the coating overlying the printed images during the evaporation of the solvent, diluent, water, etc., whereby, for example, a glossy-surfaced protective coating acquires a flat, matte or non-glossy surface, particularly in areas overlying the dried and cured printed images, and even the affected areas are not uniform in appearance depending upon the colors and/or surface areas of the underlying printed images. For example, printed colored photographs, half-tone illustrations, and the like, which are intended to be emphasized or heightened in appearance, such as by the application of glossy spot coatings thereover, undergo loss or degradation in the uniformity of their appearance and their color during the drying of the copy sheets.

Also, in cases where the protective or aesthetic coating is only spot-applied, such as over printed photographs, product illustrations, etc., the images printed on other surface areas of the copy sheets remain exposed and can stick to adjacent copy sheets unless stiling powder is applied, as discussed herein before.

The speed of operation of conventional offset printing and coating machines makes it impossible to apply successive continuous and spot coatings to a succession of copy sheets because the second coating will not adhere properly to the first coating while the latter is still wet, and/or the second coating will undergo degradation or loss of gloss during drying of the underlying coating.

These defects are of substantial importance in cases where the additional expense of one or more coatings is justified by the desired results, i.e., promotional posters, artwork, product containers, record jackets, videocassette boxes, etc. The defects, i.e., uneven surface appearance of the coating(s), detract from the appearance of the underlying images or photographs, particularly in the case of multi-colored images or photographs and are due to the presence of residual volatile solvents, diluents, water, etc., within the oleoresinous inks of the images or photographs, and the presence of water in the copy sheets, at the time that the first coating is applied thereover, and/or to the presence of volatile solvents, diluents or water within the first coating or undercoating at the time that the second coating is applied thereover. The application of a top coating over the printed images and/or over a first coating retards the volatile solvent, diluent or water against escape in the final drying station, but it eventually migrates into the top coating during the final drying and gradual curing of the ink images over a period of several hours time, resulting in a loss of perfection in the surface finish of the top coating.

SUMMARY OF THE INVENTION

It is an object of the present invention to provide a novel printing and coating method and apparatus for the in-line application of one or more protective or aesthetic coatings over imaged subject matter offset-printed onto each of a succession of copy sheets while avoiding the usual degradation or loss of uniformity of the surface appearance of areas of the coating(s) applied over the printed images and/or over underlying coated areas.

It is another objective of the present invention to enable the in-line application of a second protective or aesthetic coating, such as a glossy-finish spot coating, over a first protective coating, such as a continuous matte-finish coating, while avoiding the problems of poor adhesion and degradation or loss of glossy surface appearance of the second coating.

Essentially, the present invention is concerned with providing unblemished coated lithographic copies of the types desired in cases where the additional expense of supercoatings is justified by the desired results.

The present method and apparatus provides for the in-line drying of lithographic ink images, including photographic multi-color reproductions, and/or the drying of first continuous or spot coatings, printed or applied at one liquid application station before the application of a continuous or spot coating over said ink images or over said continuous spot coating at the next downstream liquid application station by interposing an in-line drying station between said one and next liquid application stations in order to more completely dry the ink images or first coating prior to the application of a final coating thereover, whereby the eventual drying of said final coating results in a substantially perfect surface finish.

The oleoresinous inks conventionally used to print lithographic copies generally comprise a mixture of oxidizable drying oils, such as safflower oil or linseed oil, a compatible resin binder material, such as a phenolic resin or a varnish, pigment such as carbon black, drying agents, and a volatile solvent such as mineral spirits, or other solvent for the resin and oil. The printed copy sheets also contain some water from the dampening system. Drying of the images occurs in two stages, namely evaporation of the volatile solvent in the first stage to form the relatively dry, tacky printed images, and oxidation-curing of the oleoresinous printed composition which requires several hours time and results in the final non-sticky, smear-resistant printed images. The present invention is concerned with first-stage drying or solvent/water evaporation prior to the application of a supercoating over the printed images.

The coating compositions conventionally-used to apply protective or aesthetic coatings over printed lithographic images are aqueous solutions, dispersions or emulsions of water-dispersible or water-soluble film-forming binder materials, such as acrylic resins, hydrophilic colloids, vinyl alcohol, etc. Also, coating compositions free of volatile solvents or vehicles are commonly used, such as resin precursor compositions which are polymerizable or curable by exposure to ultraviolet or other radiation. Such compositions are based upon liquid acrylic monomers or pre-polymers, or photopolymers and photoinitiators, cross-linking agents and/or other conventional ingredients. Both solvent-applied and solvent-free coating compositions can produce microporous coatings which are permeable to oxygen to hasten the curing of the oleoresinous inks. While they are also permeable to the volatile ink solvents, diluents and water, the escape of these volatiles mars the appearance of the surface finish of the coatings, as discussed supra.

The second problem, pertinent to the embodiment of drying between coating stations, relates to the reduced receptivity of wet undercoatings for supercoatings applied thereover, producing uneven, discontinuous or spotty supercoatings having "holidays" or areas which have not accepted the supercoating.

The novel method and apparatus of the present invention overcomes these problems by drying the ink-imaged and/or undercoated copy sheets prior to the application of the undercoating over the ink-printed images and/or prior to the application of the supercoating over the undercoating, whereby substantially-perfect coatings having excellent surface properties, such as gloss, are produced.

DESCRIPTION OF THE DRAWING

FIG. 1 is a vertical cross-sectional view, through the final three liquid application stations of an offset printing machine, illustrating the interposition of in-line drying stations between the last two liquid application stations and a final downstream liquid application station which is a coating-application station.

DETAILED DESCRIPTION OF THE DRAWING

Referring to the drawing, FIG. 1 illustrates a downstream portion of an offset printing machine 10 comprising three liquid application stations 11, 12 and 13, a coating apparatus 14 according to aforementioned co-pending application Serial No. 65,954 filed June 24, 1987, comprising a coating carriage 15, a final radiation drying station 16 including air knives 16a, and a continuous copy sheet conveyor means 17 which moves a succession of copy sheets 18 through the printing machine.

The first liquid application station 11 is a conventional offset image printing station comprising a plate cylinder 19, to which is clamped an imaged lithographic printing plate 20 carrying oleophilic image areas, such as words, photographs, etc. on an oleophobic, hydrophilic background. The conventional clamping means permits some degree of lateral or axial adjustment and some degree of wrap-around or circumferential adjustment of the plate 20 relative to the plate cylinder 19. Plate cylinder 19 is associated with a dampening system 21 for wetting the entire hydrophilic background surface of plate 20 with aqueous dampening fluid, and with an inking system 22 for selectively inking the image areas of the plate 20 with liquid oleoresinous ink composition containing a volatile organic solvent.

The inked plate 20 is rotated against the ink-receptive surface of a blanket cylinder 23, to which the wet ink images are offset or transferred, and the blanket cylinder 23 is rotated against a copy sheet 18, passed in the nip between the blanket cylinder 23 and an impression cylinder 24, to transfer the wet ink images to the copy sheet 18 and form an image-printed copy sheet 18A. Some water from the dampening system is also transferred to the surface of the copy sheet 18A. Sheet 18A is conveyed, imaged face up, through a first drying interstation 25, comprising a pair of spaced, elongate air knives 26 and 27 and a vapor-extraction unit 28 containing an intake fan and a outlet conduit 29 which conveys the volatile vehicle vapors to a recovery unit, to the atmosphere or for other safe disposal.

As illustrated, the printed copy sheets 18A, are conveyed by grippers past the first air knife 26, under transfer cylinder 30 and past the second air knife 27, to form dried printed copy sheets 18B which move into the next liquid application station 12.

The air knives 26 and 27 and the extraction unit 28 are conventional elements normally used as final drying elements on printing and coating machines of different types. Knives 26 and 27 are elongate tubular elements provided with an elongate narrow slot formed by op-

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posed, converging walls. Heated air is circulated through the tubular elements under pressure and is expelled from the elongate slot as a concentrated narrow band of high speed hot air which is directed against the ink-printed copy sheets 18A to evaporate the volatile solvent and water therefrom to release solvent and water vapor which is withdrawn by the extraction unit 28. Substantial drying is produced by the first air knife 26, and the second air knife 27 preferably is included, as illustrated, to insure complete drying prior to the entry of the copy sheets 18B to the next liquid application station.

In the apparatus of FIG. 1, the second liquid application station 12 can be either another ink printing station, such as for printing ink of a second color, or it can be a first coating station. Thus the various elements of station 12 are numbered similarly to those of station 11 but including the suffix a.

Where station 12 is another ink printing station, the first drying interstation 25, upstream therefrom, functions only as a supplemental drying station and can be excluded or disconnected.

Where station 12 is a first coating application station, the first drying interstation 25 is a critical component of the present invention. In such case, the inking system 22a of station 12 is withdrawn, as shown by means of broken lines, and the dampening system 21a is converted to a dampener coater system by providing a continuous supply of the desired coating composition to the supply pan thereof, i.e., an aqueous dispersion of a film-forming binder material containing in the case of matte-finish coatings, a diffusion filler such as silica or the like.

Generally, where the station 12 is a first coating station, the top roll 19a will be a plate cylinder having a full plate 20a for the application of continuous coatings to the intermediate blanket cylinder 23a or transfer cylinder and then to the dried ink-printed copy sheets 18B to form continuous coated printed copy sheets 18c. However, if desired, plate-cylinder 19a may have a spot-receptive plate or relief plate 20a for the transfer of spot coatings to the intermediate blanket cylinder 23a and then to predetermined areas of the printed copy sheets 18B to form spot-coated printed copy sheets 18C.

Most commonly, the first coating will be a complete or continuous coating of a composition providing a matte non-glossy finish or a utility (semi-gloss) finish, and the second coating will be a spot coating of a composition providing a glossy finish to highlight predetermined areas of the printed, coated copies.

The coated printed copy sheets 18C exiting the first coating station 12 are conveyed by grippers, coated side up, through the second drying interstation 25 which is similar to the first drying station 25 and comprises a similar pair of spaced elongate air knives 26a and 27a and a similar extraction unit 28a and exhaust outlet conduit 29a.

The line of forced hot air from the first knife 26a, across the width of the copy sheets, substantially dries the first coating by evaporating the water vehicle therefrom, after which the dried, coated copy sheets 19D are conveyed by transfer roll 30a to the second air knife 27a to insure complete drying of the first coating prior to the entry of the coated printed copy sheets 18D into the final coating station 13 which includes the coating-application apparatus of the copending application, in the illustrated embodiment, but which may be a conventional coating station.

In cases where the first and/or second coating composition is free of volatiles and solidifies by polymerization curing, the drying interstation 25a and/or downstream drying station 16 will contain a suitable radiation source such as ultraviolet lamps.

The coating application station 13 also can be similar to the inking station 11 and first coating station 12 with respect to the plate cylinder 19b supporting a printing plate dampening system 21b, inking system 22b, blanket cylinder 23b and impression cylinder 24b since, in a conventional offset printing machine having a plurality of liquid application stations, all of the stations are generally similar but use different printing plates to image different areas of the same copy sheet with different colored inks. The present apparatus, requiring at least one coating-application station, and modifies at least the final downstream inking station to convert it permanently or intermittently to a coating-application station as shown by FIG. 1 or, alternatively, as illustrated by U.S. Pat. No. 4,270,483-discussed hereinbefore.

Plate 20b is an offset relief printing plate, preselected areas of which are raised above the background, generally referred to as "relief spots". Such spots are sized and positioned to correspond to areas of the image-printed copy sheets 18D which it is desired to selectively coat.

The adjustable coating apparatus 14 is mounted onto the frame 31 of the printing machine for extension of the coating carriage 15 into the liquid application station 13 for adjustable coating association with either the coating plate cylinder 19b or the coating blanket cylinder 23b, as desired.

The preferred coating application apparatus 14 includes a coating carriage 15 which is horizontally adjustably, in the machine direction, for movement between retracted or passive position and extended or active position, and also vertically adjustable for movement between the levels of the plate cylinder and the blanket cylinder as shown by means of broken lines. Moreover, the coating carriage 15 comprises a horizontally-adjustable coating applicator unit 32 which is movable in the machine direction between different extended coating positions to move the coating applicator roll 33 into coating association with printing and blanket cylinders which are not in vertical alignment, as disclosed in detail in my aforementioned copending application.

Thus, the coating carriage 15 and the applicator unit 32 are adjusted in the final coating station 13 to associate applicator roll 33 with either the spot relief plate 20b on printing roll 19b, for the printing of spot coatings, or with the blanket roll 23b, for the application of continuous coatings onto the dried, coated, printed copy sheets 18D, to form double-coated printed copies 18E. Copies 18E are transported by grippers past a final downstream radiant dryer 16 and air knives 16a, to evaporate the water vehicle from the second coating and form final copies 18F which are stacked to permit final curing of the oleoresinous printing ink.

The essential novelty of the present invention resides in the interposition of a drying station, such as 25 and 25a, between an ink printing station and a coating station, and preferably also between coating stations on machines having a plurality of coating stations, in order to substantially completely evaporate the volatile solvent or vehicle from the printed ink images, and evaporate any residual dampening water from the printed copy sheets, before the application of a spot or continuous coating thereover, and preferably to substantially

completely solidify and dry the first coating such as by irradiating to polymerize or by evaporating the volatile solvent, vehicle and/or water from the coated, printed copy sheets before the in-line application of a second spot or continuous coating over the first-applied coating, as illustrated.

In operation, a succession of copy sheets 18 is automatically gripped by the conveyor means 17 and transported through one or more ink printing stations 11 into printing contact with one or more ink blanket rolls 23 to print images, such as of different colors, on predetermined areas of each copy sheet, using conventional oleoresinous inks containing volatile organic solvent(s). At each ink-printing station 11, an offset printing plate 20 is fastened to a plate cylinder 19, moistened with water/chemical dampening fluid by means of dampening unit 21 and inked by means of inking unit 22. The ink is selectively received by the image areas of the plate 20, where some water dampening solution is picked up by the ink, transferred to the surface of the blanket cylinder 23 and re-transferred to the upper surface of a copy sheet 18 passed in the nip of cylinder 23 and impression cylinder 24. At this point, the ink images on each imaged copy sheet 18A still contain the volatile organic solvent and some water dampening solution which migrates into the copy paper.

Rather than moving the inked copy sheets 18A directly from a printing station 11 to a coating station 12, as is conventional in the art, the present method and apparatus provides for intermediate or interstation drying of the inked copies to evaporate the volatile organic solvent and water dampening solution from the ink images and copy paper to form solvent-free copies 18B prior to the application of a protective and/or aesthetic coating thereover.

In the embodiment of FIG. 1 the ink-printed copies 18A are moved through an interstation drying station 25 by directing the path of the copy sheets down under a transfer cylinder 30 and up over the coating impression cylinder 24a of the coating station 12. The drying of the copy sheets is accomplished by one or more high velocity hot air knife drying elements, such as 26 and 27 shown in FIG. 1, which heat the ink image, sufficiently lowering the solvent vapor pressure while the high velocity air scrubs the vapor from the surface to evaporate substantially all of the volatile organic solvent and water and form substantially solvent-free copies 18B before the copies 18B pass in the coating nip at coating station 12.

The evaporated solvent and moisture is drawn into the solvent extraction unit 28 by an exhaust fan 31 and removed from the ambient atmosphere by conduit 29 for safety purposes.

On machines having a single coating application station, such as station 12 or station 13 of FIG. 1, the solvent-free copies 18B are moved through said coating station 12 or 13 to receive either a continuous or a spot coating to form coated, printed copy sheets 18C which are transported to the final downstream drying station 16, 16a. On machines having two coating stations 12 and 13 used for the application to two superposed coatings, either of which may be spot or continuous, matte or glossy, the dried, printed copy sheets 18B are moved through the first coating station 12 to form coated, printed copy sheets 18C which are moved through the second interstation drying station 25a to form dried coated copy sheets 18D. Sheets 18D are moved through

the second coating station 13 and on through the downstream drying station 16, 16a.

After curing for several hours, the coated, printed copies 18F are found to be free of the surface defects of copy sheets printed and coated in similar manner but in the absence of interstation drying.

While the present specification and drawing refer to a continuous copy sheet conveyor means 17 carrying automatic grippers, it will be clear to those skilled in the art that most printing and coating machines convey the copy sheets by means of automatic grippers present on each of a series of contacting cylinders, such as the impression cylinders 24, 24a and 24b and the interposed transfer cylinders 30 and 30a of FIG. 1.

It is to be understood that the above described embodiments of the invention are illustrative only and that modifications throughout may occur to those skilled in the art. Accordingly, this invention is not to be regarded as limited to the embodiments disclosed herein, but is to be limited as defined by the appended claims.

What is claimed is:

1. In a continuous in-line offset lithographic printing machine for printing and coating a continuous succession of receptive copy paper sheets, comprising a plurality of liquid application stations, each comprising a plate cylinder for supporting a lithographic printing plate and including means for supplying oleous printing composition to oleophilic image areas on the water-coated surface of a said printing plate supported thereon, a blanket cylinder for receiving said printing composition and water from said plate cylinder and for transferring said printing composition and water to a succession of individual receptive copy paper sheets, and an impression cylinder forming a nip with said blanket cylinder through which said individual receptive copy paper sheets are passed to receive printing composition and water from said blanket cylinder, at least one said liquid application station being an upstream ink printing station for the transfer of printing composition in the form of ink images containing a volatile vehicle onto said succession of copy sheets, and at least one said liquid application station being a downstream coating station for the application of a printing composition in the form of a continuous or spot coating of liquid composition over the ink-imaged surface of said copy sheets, means for feeding said succession of individual receptive copy paper sheets through the nips of said blanket and impression cylinders of said liquid application stations, and a final downstream drying station for drying or otherwise solidifying said coated copy paper sheets, the improvements which comprises an intermediate in-line drying station positioned after each of said liquid application stations, each said drying station comprising means for directing forced hot air against the ink printed copy paper sheets to effect the evaporation of water and the volatile vehicle from the ink images printed on said copy paper sheets prior to the entry of the ink-imaged copy paper sheets into the next liquid application station including into said coating station.

2. A printing machine according to claim 1 having two adjacent downstream coating stations, characterized by the presence of another intermediate in-line drying station positioned in-line therebetween to effect the solidification of the coating applied at the first coating station prior to the entry of the coated copy sheets into the second coating station.

3. A printing machine according to claim 1 in which said coating station comprises a coating application assembly which is adjustably supported for coating association with either the plate cylinder, for the application of spot coatings, or the blanket cylinder, for the application of continuous coatings, to said copy sheets.

4. A printing machine according to claim 1 in which

said intermediate drying station also comprises a vapor extraction means.

5. A printing machine according to claim 1 in which said means comprises an air knife.

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TOP SECRET

[54] LIQUID TRANSFER ASSEMBLY AND METHOD

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[73] Assignee: Birow, Incorporated, Westport, Conn.

[21] Appl. No.: 217,412

[22] Filed: Jul. 11, 1988

[51] Int. Cl.⁴ B41L 23/00

[52] U.S. Cl. 101/148; 101/216;
101/349; 101/367; 118/46

[58] Field of Search 101/348, 349, 147, 148,
101/350, 152, 153, 174, 216, 367; 118/46

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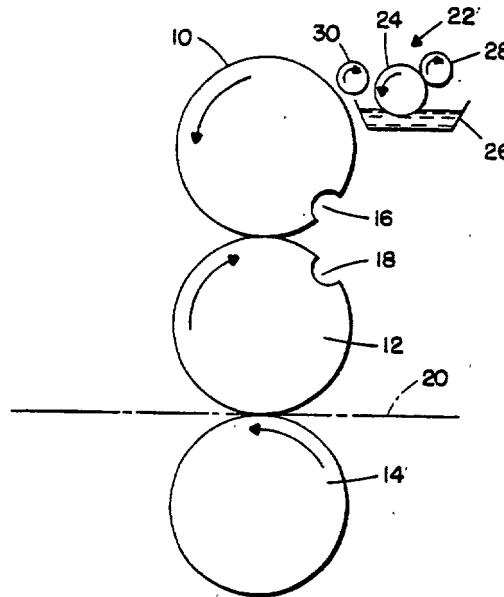
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Primary Examiner—Eugene H. Eickholt
Attorney, Agent, or Firm—Perman & Green

[57] ABSTRACT

A liquid transfer assembly is shown which transfers a predetermined thickness of liquid to a moving surface, the assembly employing a shearing action to achieve the predetermined thickness. The system includes a supply means for providing a source of the liquid; a first arcuately shaped surface which moves at a first speed and is adapted to contact the supply means so as to obtain a coating of liquid on its surface. A second surface is juxtaposed to the first surface but not in contact therewith, moves at a second speed different from the first speed; and the distance between the two surfaces is sufficiently close that the liquid on the first surface comes in contact with the second surface at their nearest point of proximity. Thus, by virtue of the different surface velocities, the liquid is subjected to a shearing action at the nearest point of proximity with a determined amount thereof being transferred to the second surface.

4 Claims, 1 Drawing Sheet



TOP SECRET

FIG. 1.

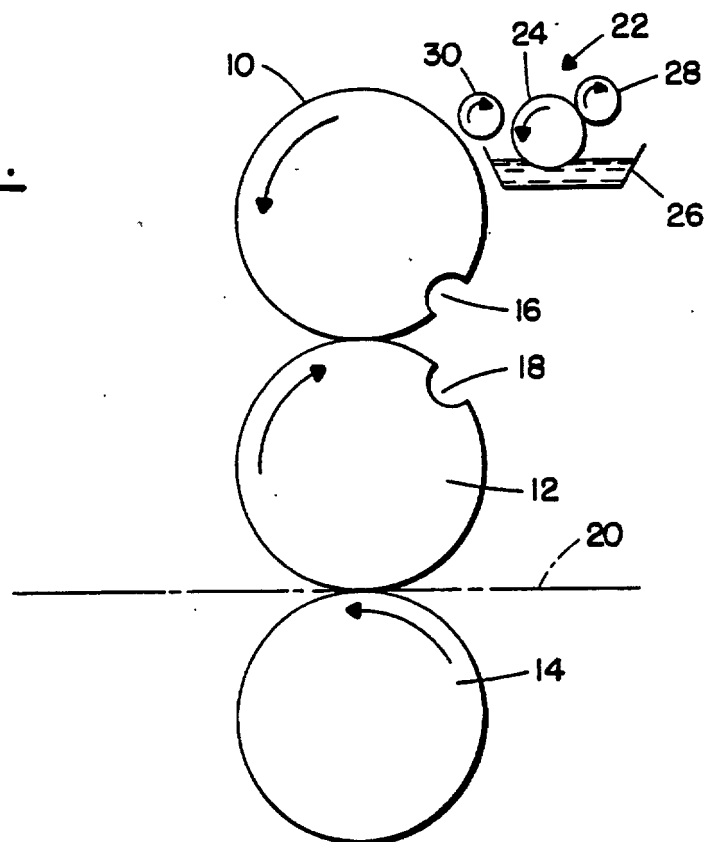
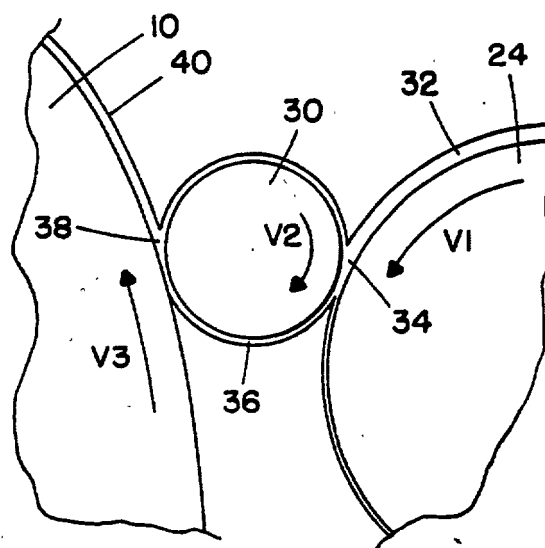


FIG. 2.



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LIQUID TRANSFER ASSEMBLY AND METHOD

FIELD OF THE INVENTION

This invention relates to offset lithographic printing and more particularly to a means and method for transferring liquid from a reservoir to an offset lithographic plate cylinder.

BACKGROUND OF THE INVENTION

In offset lithographic printing, each printing stage includes a plate cylinder, to which printing plates are tightly fastened around its circumference. The plate cylinder is equipped with inking and dampening mechanisms. The plate includes both image and non-image areas which are substantially coplanar, the image portions being hydrophobic and the non-image areas being hydrophilic. The dampening system applies an aqueous solution to the non-image areas and the inking system applies a greasy ink to the image areas. The plate cylinder transfers its image to an intermediate blanket cylinder which has a specially composed smooth rubber blanket surface. Printing stock in either sheet or webbed form is fed against the blanket cylinder by an impression cylinder and the ink (and dampening solution), is transferred to the printing stock thus completing the printing operation.

In applicator roll assemblies used with conventional lithographic printing cylinders, a pick-up roll is partially immersed in a trough containing a continuous supply of liquid. The liquid may be water, ink or a coating composition. The surface of the pick-up roll "picks up" a relatively thick coating of the liquid and rotates it into contact with a metering roll which controls or meters the thickness of the coating which is to remain on the surface of the pick-up roll. Excess liquid is returned to the trough. Further rotation of the pick-up roll brings it into pressure contact with an applicator roll whereby the applicator roll obtains a coating of the liquid from the pick-up roll. Finally, the applicator roll rotates into pressure contact with the plate cylinder (or in some instances the blanket cylinder) which is coated with the liquid by the pressure/rolling action of the applicator roll.

As the applicator roll moves about the outer periphery of the plate cylinder, it comes into contact with a plate clamp aperture where plates are secured to the outer periphery of the plate cylinder. Unless the applicator roll/plate cylinder contact pressure is very closely controlled, the clamp aperture will often cause the applicator roll to slightly move away from the periphery of the plate cylinder as the plate clamp aperture passes beneath it. This can create an interruption in the application of the liquid to the plate with resulting nonuniformities in the printed product.

Accordingly, it is an object of this invention to provide an improved liquid transfer assembly for offset lithographic printing apparatus.

It is another object of this invention to provide an improved liquid transfer assembly for offset lithographic printing apparatus wherein uniform layers of applied liquid result from the action of the transfer assembly.

SUMMARY OF THE INVENTION

A liquid transfer assembly is shown which transfers a predetermined thickness of liquid to a moving surface, the assembly employing a shearing action to achieve the

predetermined thickness. The system includes a supply means for providing a source of the liquid; a first arcuately shaped surface which moves at a first speed and is adapted to contact the supply means so as to obtain a coating of liquid on its surface. A second surface is juxtaposed to the first surface but not in contact therewith; moves at a second speed different from the first speed; and the distance between the two surfaces is sufficiently close that the liquid on the first surface comes in contact with the second surface at their nearest point of proximity. Thus, by virtue of the different surface velocities, the liquid is subjected to a shearing action at the point of proximity with a determined amount thereof being transferred to the second surface.

DESCRIPTION OF THE DRAWINGS

FIG. 1 is a side, schematic view of an offset lithographic printing apparatus showing the relationship of the liquid transfer assembly thereto.

FIG. 2 is an expanded view of the contact surfaces of liquid transfer assembly.

DETAILED DESCRIPTION OF THE INVENTION

Reference is made to the following copending applications, all of which describe further details of an offset lithographic printing apparatus useful in conjunction with the invention hereof. The disclosure of each is incorporated herein expressly by reference: U.S. patent application, Ser. No. 65,914 filed June 24, 1987 and entitled "Coating and Printing Method and Apparatus Including An Interstation Dryer"; and U.S. Pat. No. 4,796,556 entitled "Adjustable Coating and Print Apparatus"; all to John W. Bird.

Referring now to FIG. 1, plate cylinder 10, blanket cylinder 12 and impression cylinder 14 are all of the conventional variety normally found in offset lithographic printing machines. Plate cylinder 10 is provided with a plate clamp aperture 16 wherein the print plate (not shown) is clamped to the external circumference of plate cylinder 10. In a similar manner, blanket cylinder 12 is provided with a blanket clamp aperture 18 where the blanket is secured. As is well known, a continuous conveyer belt, schematically shown at 20, feeds sheets to be imprinted between blanket cylinder 12 and impression cylinder 14.

A dampening system 22 includes a pick-up roll 24 which has a part of its circumference immersed in liquid bath 26 (e.g. water). A metering roll 28 is positioned to co-act with pick-up roll 24 to remove excess and otherwise assure a continuous film of liquid on pick-up roll 24. An applicator roll 30 is positioned so as to be close to, but not in contact with pick-up roll 24 as well as the outer surface of plate cylinder 10. In this preferred embodiment, pick-up roll 24, metering roll 28 and applicator roll 30 are each individually driven by separate motors so as to enable the speed of each to be individually adjusted. While not shown, additional coating stations for the purpose of applying inking solutions or coating solutions may also be emplaced about the periphery of plate cylinder 10 in the normal manner. It is here emphasized that the liquid transfer principle to be hereinafter discussed with respect to the dampening system, applies, in substance, to other coating applications.

Referring now to FIG. 2 in conjunction with FIG. 1, an expanded view of applicator roll 30 is shown in con-

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junction with portions of plate cylinder 10 and pick-up roll 24. After the surface of pick-up roll 24 leaves the vicinity of metering roll 28, a layer of liquid 32 (e.g. water) resides on its surface. The peripheral velocity of pick-up roll 24 is adjusted so that it exhibits a character-
 5 istically constant velocity V1. The distance between the surfaces of applicator role 30 and pick-up roll 24, at their nearest point of proximity 34, is adjusted so that the surface of applicator role 30 comes into contact with liquid layer 32 as it passes therebetween. Velocity
 10 V2 of applicator role 30 is adjusted to be greater than V1 so as to create, at proximity point 34, a shearing action on liquid 32. This shearing action causes a layer of liquid 36 to adhere to the outer periphery of applicator role 30 and to be carried around its periphery until
 15 it comes into contact at proximity point 38 with the external periphery of plate cylinder 10. Here again, the velocity V3 of plate cylinder 10 is adjusted to be higher than V2 so that a further shearing action occurs on liquid layer 36 as it reaches point 38. The shearing action results in a layer of liquid 40 being applied to plate cylinder 10.

By adjusting the relative velocities of the rolls/cylinder surfaces, the thicknesses of liquid layers 36 and 38 can be readily adjusted (assuming identical wetting characteristics of the moving surfaces). More specifically, as the velocity V2 is increased with respect to V1, a thicker layer of liquid 36 adheres to the surface of applicator role 30. In similar fashion, as the velocity V3 of plate cylinder 10 is increased with respect to the velocity V2 of applicator roll 30, the thickness of liquid layer 40 can be made to increase. Conversely, as peripheral velocities V2 and V3 approach each other, the layer 40 of liquid adhering to plate cylinder 10 will decrease in thickness. However, if the peripheral velocities become equal or so close as to negate a shearing action, the liquid layer thicknesses will split and tend to become non-uniform.

The above stated, non-contacting liquid application system provides a number of advantages. One is that there is no contact between applicator role 30 and plate cylinder 10 thereby preventing any contact between applicator role 30 and plate clamp aperture 16. Another is that the amount of wear on the respective rolls/cylinder is greatly decreased. The system further provides for relatively easy adjustment of the amounts of liquid to be applied to plate cylinder 10. As aforesaid, it is important that the peripheral velocities of adjoining rolls/cylinder be somewhat different to sustain the shearing action which creates the desired thickness of liquid coating.

The motive power for each of the rolls and cylinders should be linearly adjustable in speed so as to provide the desired variability of circumferential velocities. Hydraulic motors are preferred; however electric motors of the variable speed variety are also acceptable.

The above described liquid transfer assembly is particularly adapted to application as a dampening system for a plate cylinder. This is due to the fact that the viscosity of water is relatively constant (notwithstanding temperature changes) and enables the dampening system, once adjusted, to operate properly for long periods of time. On the other hand, if the viscosity of the liquid is subject to large changes or is highly viscous, this invention is less well suited. It is applicable to inking systems where ink of relatively medium to low viscosities are employed and to coating applications where relatively constant viscosity coating materials are utilized.

This invention further reduces the maintenance necessary for offset printing apparatus and substantially negates the need for chilling of the dampening solution. As is well known, especially for web presses, roll pressures generate substantial heat and cause the dampening solution to increase in temperature—thereby requiring refrigeration. This invention decreases the resulting roll-generated heat and this reduces refrigeration requirements.

It is to be understood that the above described embodiment of the invention is illustrative only and that modifications throughout may occur to those skilled in the art. Accordingly, this invention is not to be regarded as limited to the embodiment disclosed herein but is to be limited as defined by the appended claims.

I claim:

1. In an assembly for transferring a predetermined thickness of liquid to a moving surface, said liquid exhibiting a relatively constant velocity over the operating conditions experienced by said assembly, the combination comprising:

supply means for producing a source of said liquid:

a liquid bearing applicator roll movable at a first speed and adapted to contact said supply means and obtain a coating of said liquid on said surface; a plate cylinder juxtaposed to said applicator roll and adapted to be moved at a second speed different from said first speed, said plate cylinder being maintained out of contact with said applicator roll but sufficiently close thereto that said liquid coating on said applicator roll comes in contact with said plate cylinder at the nearest point of proximity of said roll and cylinder, whereby said liquid coating is subjected to a shearing action at said nearest point of proximity with a determined amount thereof being transferred to said plate cylinder by shearing action.

2. The invention as recited in claim 1 wherein said liquid is water.

3. The invention as recited in claim 1 wherein said liquid is ink.

4. The invention as recited in claim 1 wherein said liquid is a coating material.

* * * * *

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[54] **FLEXOGRAPHIC COATING AND/OR PRINTING METHOD AND APPARATUS INCLUDING INTERSTATION DRIERS**

[75] **Inventor:** John W. Bird, Westport, Conn.

[73] **Assignee:** Birow, Inc., Westport, Conn.

[*] **Notice:** The portion of the term of this patent subsequent to Jun. 27, 2006 has been disclaimed.

[21] **Appl. No.:** 336,219

[22] **Filed:** Apr. 11, 1989

Related U.S. Application Data

[63] Continuation-in-part of Ser. No. 65,914, Jun. 24, 1987, Pat. No. 4,841,903.

[51] **Int. Cl.⁵** B41F 5/24

[52] **U.S. Cl.** 101/183; 101/424.1; 101/488; 101/211; 118/46

[58] **Field of Search** 101/115, 488, 424.1, 101/183, 138, 136, 177, 181; 118/46, 66, 58; 427/378, 379, 382; 34/1 SS

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Primary Examiner—Clifford D. Crowder
Attorney, Agent, or Firm—Perman & Green

[57] ABSTRACT

A straight line flexographic printing method and machine having a plurality of in-line liquid application stations, at least one of which is an upstream ink image-printing stations for printing ink images on a succession of cardboard copy sheets, and at least one of which is a final downstream liquid-application station which may be a coating application station for printing a protective, and/or aesthetic coating over selected portions of, or over the entire ink image-printed surface of each cardboard copy sheet. The present method and apparatus involves the placement of a forced hot air drying station between each of the liquid application stations to evaporate volatile solvent/diluent from the ink images applied at each inking or coating station before the application of additional ink images or coatings thereover at the next downstream liquid application station.

11 Claims, 1 Drawing Sheet

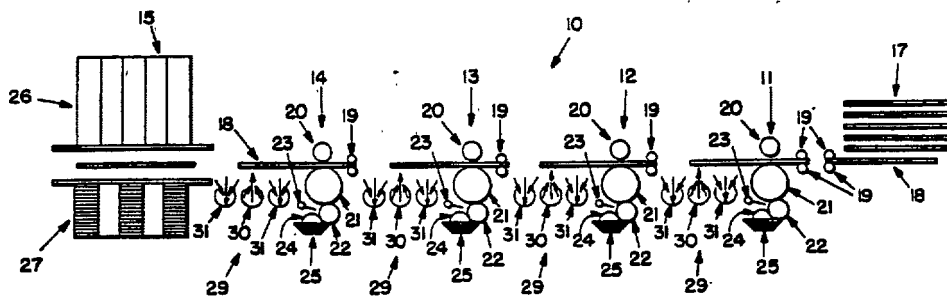
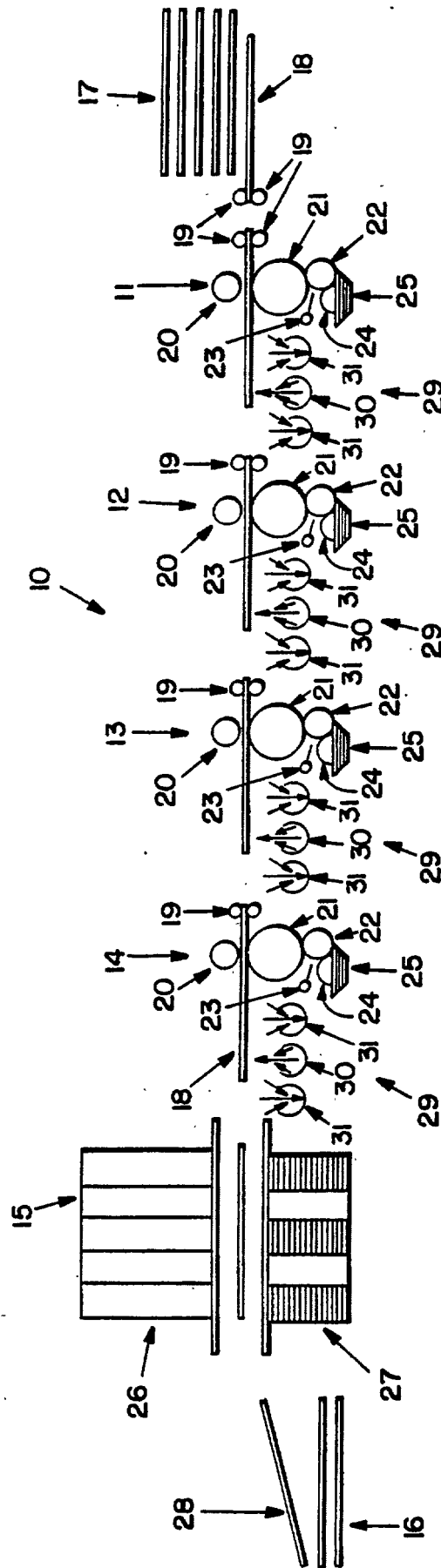


FIG. 1.



FLEXOGRAPHIC COATING AND/OR PRINTING METHOD AND APPARATUS INCLUDING INTERSTATION DRIERS

BACKGROUND OF THE INVENTION

The present application is a continuation-in-part of application Ser. No. 65,914 filed June 24, 1987, now U.S. Pat. No. 4,841,903.

Conventional flexographic coating and/or printing machines or presses comprise one or more image-printing stations each having a plate cylinder to which is fastened a flexographic plate having raised image or printing areas. Aqueous or solvent ink is applied to the raised image areas, which ink is transferred directly to an absorbent copy sheet or web.

This differs from lithographic printing in which the flat, imaged surface of a plate is continuously wetted with aqueous damping solution, which adheres only to the background areas, and the plate is then inked with oleoresinous ink composition which adheres only to the image areas of the plate as wet ink. The ink is offset-transferred to the rubber surface of a contacting blanket cylinder, and retransferred to the receptive surface of a copy web or a succession of copy sheets, such as of paper, where the ink gradually hardens or cures by oxidation, in some cases after passing through a final drying station located downstream of the final liquid application station where the volatile solvent is evaporated from the ink composition of the images.

In multicolor printing processes and machines of both flexographic and lithographic types, the copy web or sheets pass through a plurality of ink-printing stations in which inks of different colors are printed over the same areas in partial or complete registration to produce multi-ink images or image portions having a variety of desired colors or color-blends. However such multi-ink images vary in sharpness, color-intensity and tone or hue depending upon the number of underlying ink portions.

Stiff, heavyweight cardboard sheets, such as corrugated cardboard, can only be printed and/or coated on a straight line flexographic printer and/or coater since such sheets cannot be caused to wrap around and over plate cylinders or impression cylinders, as is common with lithographic presses and with some known flexographic presses which are used for printing flexible sheets.

Flexographic straight-line printing machines are employed for the printing of relatively thick sheets of highly absorbent material, such as corrugated cardboard, which are moved in a straight line, in flat condition, through one or more ink-printing stations. At each such station the thick absorbent sheets pass in the nip between a flexographic plate cylinder and an impression or back-up cylinder, the raised images on the plate applying flexographic ink directly to the absorbent surface of each sheet, such as cardboard. The flexographic ink comprises resin, pigment and volatile diluents and/or solvent and dries by the absorption of the diluent/solvent into the absorbent surface. This results in some spreading of the printed images, lines, etc., with resultant loss of sharpness, detail and quality of print. This is particularly true where different colored inks are printed in partial or complete registration, which further causes variations in coloration or color tone between areas which are overprinted and areas which are not, e.g., the redness of a red line printed over a grey

underprint is visibly different from the redness of the same line extending onto unprinted areas of the sheet, due to variations in the ability of the sheet to quickly absorb the diluent/solvent. The same is true with respect to the lack of uniformity of surface appearance of a solvent-applied overcoating.

In cases where cost is not a factor and/or where the aesthetic advantages of a protective supercoating, generally referred to as a coating in the flexographic industry, are desired, it is known to provide the printing machine with a downstream coating station having a coating application unit for the application of an overall protective coating over the entire printed area of the copy sheets.

While the in-line application of a protective or aesthetic coating over the flexographic images on a succession of copy sheets will improve the appearance of the print and render it smear-resistant and weather-resistant, the relatively wet condition of the printing ink composition, particularly in overprinted areas, at the time that the coating composition is applied thereover, produces a visible change in the appearance of the portions of the coating overlying the printed images during the evaporation and/or absorption of the solvent, diluent, water, etc., whereby, for example, a glossy-surfaced protective coating acquires a non-uniform flat, matte, or non-glossy surface, particularly in areas overlying the multi-printed images, and even the affected areas are not uniform in appearance depending upon the colors and/or surface areas of the underlying printed images due to the solvent/diluent in the coating interacting with the still-wet color inks. For example, printed colored images, half-tone illustrations, and the like, which are intended to be emphasized or heightened in appearance, by the application of glossy coatings thereover, undergo loss or degradation in the uniformity of their appearance and their color during the drying of the coating.

These defects in color quality and coating appearance are of substantial importance in cases where the additional expense of one or more coatings is justified by the desired results, i.e., promotional displays, artwork, product containers, etc. The defects, i.e., uneven surface appearance of the coating(s) and the quality of the underlying color images, detract from the appearance of the coating and/or underlying images, particularly in the case of multi-colored images and are due to the presence of various amounts of residual volatile solvents, diluents, water, etc., within the flexographic inks of the first images at the time that the second flexographic images are applied thereover, and/or to the presence of volatile solvents, diluents or water within the second subsequent flexographic ink images at the time that the coating is applied thereover. The application of a top coating over the printed images retards the volatile solvent, diluent or water against escape in the final drying station, but the volatiles can eventually migrate from the cardboard into the top coating during the final drying of the printed cardboard, resulting in a loss of perfection in the surface finish of the top coating.

These problems have not been important in cases where the sheets being printed are cardboard shipping cartons or the like, where high quality is not considered important. However in some cases, such as with display cardboard and ultimate sale cardboard containers, such as shoe boxes, toy boxes, clothing closets, etc., where high quality, multi-color printing is important, it has

been necessary to print an outer paper sheet by means of higher quality printing processes and then adhere or laminate the printed sheet to the cardboard support. This is expensive and labor-intensive. The present invention makes this unnecessary for many flexographic applications.

It is known to provide one or more drying stations between inking stations on continuous web flexographic printing machines. However such machines convey the copy sheet through a tortuous path and thus are only useful for printing flexible webs and not sheet lengths or cardboard blanks.

It is an object of the present invention to provide a novel flexographic printing and/or coating method and apparatus for the in-line application of one or more inks and/or protective or aesthetic coatings over imaged subject matter flexographically printed onto each of a succession of heavyweight, absorbent copy sheets while avoiding the usual degradation of sharpness, detail, color uniformity or loss of uniformity of the surface appearance of areas of the ink(s) and/or coating applied over the previously ink-printed images.

It is another objective of the present invention to provide a flexographic printing method and apparatus for providing high quality flexographic printing directly on heavyweight sheets, such as corrugated cardboard, thereby avoiding the need for pre-printing paper, such as by offset lithographic means, and thereafter adhering it to a cardboard support.

Essentially, the present invention is concerned with providing high quality flexographic copies of the types desired, directly on heavyweight absorbent sheets particularly in cases where the additional expense of multiple colors and supercoatings is justified by the desired results.

SUMMARY OF THE INVENTION

The present flexographic method and apparatus provides for the inline forced hot air drying of flexographic ink images, including multicolor images and photographic reproductions, printed or applied at one liquid application station before the application of a second printing ink or a continuous or spot coating over said ink images at the next downstream liquid application station by interposing an in-line drying station between each of said liquid application stations in order to pre-dry the first colored ink images prior to the application of images of a second color or a final coating thereover, whereby the drying of each ink removes volatile solvents/diluents which can cause the ink images to spread or broaden, and/or blemish the next ink or coating applied thereover.

The evaporation of volatile solvents/diluents from flexographic ink images applied to stiff, absorbent sheets is unknown and unobvious since such images are intended to dry by absorption of the volatile solvents/diluents and oil of the ink into the absorbent paper sheet, such as the outer paper ply of a corrugated cardboard. However I have discovered that the interstation evaporation of such volatiles dries the ink images before they can spread, bleed or wick into the absorbent paper support, thus preserving their sharpness, detail and coloration. Moreover such evaporation dries the surfaces of the first printed images so that they are more receptive to second images or coatings applied thereover and more resistant to being diluted, spread and/or broadened by the volatiles present in the second applied images or coating. Moreover the pre-removal of the vola-

tile avoids the accumulation of volatiles, in different quantities, in different areas of the printed copy sheets or cardboard sheets, depending upon the number of overprints, the presence of which can continue to cause the images to spread or broaden and/or can result in color degradation and degradation in the uniformity of the appearance of an overcoating, if present.

The present invention is concerned with drying or solvent/diluent evaporation prior to the application of a second ink or a supercoating over the printed images.

The coating compositions conventionally used to apply protective or aesthetic coatings over printed images are aqueous solutions, dispersions or emulsions of water-dispersible or water-soluble film-forming binder materials, such as acrylic resins, hydrophilic colloids, vinyl alcohol, etc. Also, coating compositions free of volatile solvents or vehicles are commonly used, such as resin precursor compositions which are polymerizable or curable by exposure to ultraviolet or other radiation. Such compositions are based upon liquid acrylic monomers or pre-polymers, or photopolymers and photoinitiators, cross-linking agents and/or other conventional ingredients. Both solvent-applied and solvent-free coating compositions can produce microporous coatings which are permeable to volatiles. While they are permeable to volatile ink solvents, diluents and water, the escape of these volatiles mars the appearance of the surface finish of the coatings, as discussed supra.

Multicolor flexographic printed ink images commonly are formed by using inks containing pigments of different primary colors which, when combined in superposition, produce different secondary colors depending upon the identity and number of primary colors used. However, unless each ink image is dried sufficiently to evaporate the solvents and water present therein, before a second ink is printed in partial or full registration thereover, said solvents and water produce blemishes in the total image when they are eventually evaporated. Such blemishes include voids uneven tones, ragged edges, etc.

Another problem, pertinent to the embodiment of drying between printing stations, relates to the reduced receptivity of wet images for images and/or supercoatings applied thereover, producing uneven, discontinuous or spotty images or supercoatings having "holidays" or areas which have not accepted the images or supercoating.

The novel flexographic method and apparatus of the present invention overcomes these problems with stiff, heavyweight absorbent sheets by drying the ink-imaged copy sheets prior to the application of additional ink images and/or prior to the application of a coating over the ink-printed images, whereby substantially-perfect flexographic images and/or coatings having excellent uniformity, color tone and surface properties, such as gloss, are produced on stiff copy sheets, such as cardboard, printed and/or coated in a straight line flexographic apparatus.

THE DRAWING

FIG. 1 is a vertical cross-sectional view of a flexographic printing and punching machine, illustrating four liquid application stations and the interposition of inline drying stations between each of the liquid application stations and including a final downstream in-line drying station in advance of an optional die cutting, folding and/or gluing creasing station.

DETAILED DESCRIPTION

Referring to the drawing, FIG. 1 illustrates a flexographic printing machine 10 comprising four liquid application stations 11, 12, 13 and 14 the final downstream station 14 being a coating station, if desired, an optional die cutting, creasing, folding and/or gluing station 15 at which the printed cardboard copies are die cut into desired shapes, such as carton blanks, and creased for folding purposes, if desired, prior to stacking at 16.

As illustrated, the present apparatus includes a feeding station 17 for feeding a continuous supply of cardboard blanks or sheets 18 in a straight line between a plurality of feed rolls 19 into and through each of the liquid application stations 11 to 14 in which each sheet 18 is engaged between an upper impression cylinder 20 and a lower printing cylinder 21. The printed blanks 18 are finally fed to a cutting and creasing press station 15 in which they are die cut and creased, and moved to a stack 16.

Each of the flexographic printing stations 11 to 14 comprises a flexographic plate cylinder 21, the final downstream one of which, in station 14, can be one for printing an overall or spot coating over the portions of the sheet 18 printed with ink images in stations 11, 12 and 13. The liquid application systems in stations 11 to 14 each comprise the plate cylinder 21, a metering roll 22 with associated doctor blade 23, an application roll 24 and an ink (or coating) supply 25. The illustrated ink (or coating) supply 25 is a pan into which the roll 24 extends to receive a continuous supply of the ink or coating composition as it is rotated in the counter-clockwise direction. However most commercially available flexographic printing machines pump the ink or coating supply as a continuous supply onto the surface of the applicator roll 24. The doctor blade 23 is adjustable relative to the surface of the metering roll 22 in order to control the thickness of the ink or coating layer moved onto the plate surface on the plate cylinder 21 for transfer to the undersurface of each cardboard sheet 18.

The apparatus includes conventional registration means, including feed rolls 19, so that each sheet 18 and the plate on each printing cylinder 21 are in exact registration to precisely control the areas of each sheet 18 to be printed with different colored inks at stations 11 to 14 or to be printed with coating composition at station 14.

The multi-printed sheets 18 are moved into the optional station 15, which includes a movable cutter/crease die 26 and an anvil 27, in order to cut away 50 and/or crease predetermined portions thereof to form printed blanks 28 which are stacked at 16.

The essential novelty of the present flexographic printing apparatus resides in the plurality of interstation driers 29, one or more of which are located after each of the printing stations 11 to 14 for purposes of rapidly drying the ink images applied to sheets 18 at each printing station 11 to 13 before the printed sheets enter the next printing station and to dry the final ink or coating after print station 14. This has been found to result in substantially sharper, clearer images being produced on the cardboard sheets as compared to conventional straight line flexographic printers which permit the images to dry by absorption of the volatile ink solvent/diluent into the cardboard surface. Moreover the present apparatus has been found to permit the overprinting of different colored inks in partial or complete registration without dilution or spreading or alteration of the

sharpness or color tone of the underlying images. The pre-drying of the underlying images sets their color and sharpness, preventing them from being spread and diluted by absorption by the cardboard sheet. Moreover the pre-drying of the images renders them more resistant to being redissolved and spread or diluted by the volatile solvent/diluent of the next-applied ink, and provides a pre-dried ink surface which is more receptive to being overprinted with the next-applied ink and is resistant to being drawn back off the cardboard surface by the pressure of the next ink printing cylinder 21.

Referring to FIG. 1, each interstation drier 29 comprises at least one elongate tubular forced hot air knife 30 which is closely-spaced from the printed undersurface of the sheets 18, and an associated pair of elongate tubular vapor suction means 31 for withdrawing the evaporated ink vehicle or solvent to a recovery unit or for safe release to the outside atmosphere.

In operation, the inked plate on the first flexographic cylinder 21 is rotated against the ink-receptive surface of each cardboard sheet 18, to which the wet flexographic ink images are transferred to form an image-printed copy sheet 18. Each sheet 18 is conveyed, imaged face down, through a first drying interstation 29, comprising at least one forced hot air knife 30 and a spaced pair of vapor-extraction units 31 which withdraw and convey the volatile vehicle vapors to a recovery unit, to the atmosphere or for other safe disposal.

As illustrated, each printed copy sheet 18 is conveyed past the first air knife 30 to form a dried printed copy sheet which is moved into the next liquid application station 12.

The air knife 30 and the extraction units 31 are conventional elements normally used as final drying elements on printing and coating machines of different types, and are sufficiently small in diameter, i.e., about two inches, that they can be accommodated within the small areas present between printing stations on conventional straight-line flexographic printing machines. Knives 30 are elongate tubular elements provided with an elongate narrow slot formed by opposed, converging walls. Heated air is circulated through the tubular elements under pressure and is expelled from the elongate slot as a concentrated narrow band of high speed hot air which is directed against the undersurface of the ink-printed copy sheets 18 to evaporate the volatile solvent or vehicle therefrom to release vapor which is withdrawn through elongate slots in the extraction units 31. Substantial drying is produced by the each air knife 30, but a spaced second air knife may be included at each drying station 29 to insure complete drying prior to the entry of the copy sheets 18 to the next liquid application station.

In the apparatus of FIG. 1, the second ink application station 12 is another ink printing station, such as for printing ink of a second color. Thus the various elements of station 12 are numbered similarly to those of station 11.

The printed copy sheets 18 exiting the second printing station 12 are moved by feed rollers 19, printed side down, through the second drying interstation 29 which is similar to the first drying station and comprises a similar elongate air knife 30 and a similar spaced pair of extraction units 31.

The line of forced hot air from the second knife 30, across the width of the copy sheets printed in station 12, substantially dries the second-applied ink images by evaporating the vehicle therefrom, after which the

1. General Information		2. Demographic Data		3. Clinical History		4. Physical Examination		5. Laboratory Investigations		6. Radiological Findings		7. Pathological Findings		8. Treatment and Outcome	
No.	Sex	Age	Occupation	Onset	Duration	Site	Character	Signs	Tests	Findings	Diagnosis	Prognosis	Therapy	Result	
1	M	45	Teacher	1980	10 years	Right hand	Intermittent	Swelling, pain, stiffness	X-ray, blood tests	Joint space narrowing, osteophytes	Osteoarthritis	Good	NSAIDs, physiotherapy	Improved	
2	F	52	Nurse	1985	5 years	Left knee	Constant	Swelling, pain, redness	X-ray, blood tests	Joint space narrowing, effusion	Rheumatoid arthritis	Poor	Corticosteroids, DMARDs	Stabilized	
3	M	60	Retired	1990	3 years	Both hands	Intermittent	Swelling, pain, stiffness	X-ray, blood tests	Joint space narrowing, osteophytes	Osteoarthritis	Good	NSAIDs, physiotherapy	Improved	
4	F	58	Homemaker	1988	7 years	Right knee	Constant	Swelling, pain, redness	X-ray, blood tests	Joint space narrowing, effusion	Rheumatoid arthritis	Poor	Corticosteroids, DMARDs	Stabilized	
5	M	48	Engineer	1982	12 years	Left hand	Intermittent	Swelling, pain, stiffness	X-ray, blood tests	Joint space narrowing, osteophytes	Osteoarthritis	Good	NSAIDs, physiotherapy	Improved	
6	F	55	Teacher	1987	6 years	Both knees	Constant	Swelling, pain, redness	X-ray, blood tests	Joint space narrowing, effusion	Rheumatoid arthritis	Poor	Corticosteroids, DMARDs	Stabilized	
7	M	62	Retired	1991	4 years	Right hand	Intermittent	Swelling, pain, stiffness	X-ray, blood tests	Joint space narrowing, osteophytes	Osteoarthritis	Good	NSAIDs, physiotherapy	Improved	
8	F	50	Nurse	1986	8 years	Left knee	Constant	Swelling, pain, redness	X-ray, blood tests	Joint space narrowing, effusion	Rheumatoid arthritis	Poor	Corticosteroids, DMARDs	Stabilized	
9	M	57	Engineer	1983	11 years	Both hands	Intermittent	Swelling, pain, stiffness	X-ray, blood tests	Joint space narrowing, osteophytes	Osteoarthritis	Good	NSAIDs, physiotherapy	Improved	
10	F	53	Homemaker	1989	9 years	Right knee	Constant	Swelling, pain, redness	X-ray, blood tests	Joint space narrowing, effusion	Rheumatoid arthritis	Poor	Corticosteroids, DMARDs	Stabilized	

dried, copy sheets 18 are conveyed by downstream feed rollers 19 for entry of the twice printed copy sheets 18 into the next printing station 13 where ink images of a third color are printed over the pre-applied, pre-dried ink images, and are dried at the next downstream interstation drier 29 prior to entry into the final printing station 14. The final downstream station 14 can, if desired, be a coating application station which is similar to the inking stations 11 to 13 with respect to flexographic plate cylinder 20 and its associated rollers, except that the plate has an overall or spot coating surface, and coating composition rather than ink is fed thereto from supply 25.

Thus, the station 14 can be a coating station for the application of continuous spot coatings onto the pre-dried printed copy sheets 18 which are transported by feed rollers 19 past a final downstream drying station 29 and its air knife 30 to evaporate the water or other volatile solvent/diluent from the coating and form final copies 18 which are cut, creased, folded and/or glued and stacked.

In operation, a succession of cardboard copy sheets 18 is automatically moved in a straight line by feed roller 19 and transported through two or more ink printing stations into printing contact with two or more flexographic cylinders 21 to print images, such as of different colors, on predetermined similar and/or different areas of the underside of each copy sheet, using conventional aqueous flexographic inks containing volatile organic solvent(s) and water. At each ink-printing station 11 to 14 a flexographic printing plate is fastened to a plate cylinder 21 and inked by means of metering roller 22. The ink is selectively received by the image areas of the plate and transferred to the under-surface of a copy sheet 18 passed in the nip of cylinder 21 and impression cylinder 20. At this point, the ink images on each imaged copy sheet 18 still contain the volatile organic solvent and water. Rather than moving the inked copy sheets 18 directly from the first ink printing station to the next ink printing station 12, as is conventional in the art, the present method and apparatus provides for intermediate or interstation drying of the inked copies to evaporate the volatile organic solvent from the ink images and copy sheet to form solvent-free copies 18 prior to the application of new ink images thereover.

Flexographic processes are conventionally used to print ink images onto absorbent paperboard, drying of the ink images being caused by the absorption of the volatile ink vehicle into the copy sheet. Heretofore it has not been possible to apply high quality multicolor ink images onto cardboard in a single pass on straight line flexographic machines because the volatile solvent/diluent of the after-applied ink images redissolves and smears the first applied images which mask the absorbent copy sheet against rapid absorption of the after-applied solvent. The same problem occurs when solvent/diluent-applied coating compositions are applied over ink images in the flexographic process.

The present invention solves these problems by providing the interstation forced hot air driers between each of the liquid application stations on a straight line flexographic printing and/or coating apparatus, whereby the volatile solvents and water are evaporated to dry the ink images rapidly before additional images or coatings are printed thereover. Rapid evaporation drying renders the dry ink images resistant to being dissolved or smeared, and reduces the dwell time of the

after applied solvents. Conventional drying by absorption is very slow, does not remove the solvents, diluents or water from the copy sheets and retards drying in cases where the later applied composition is applied over pre-printed areas of the absorbent copy sheet.

Thus the present flexographic printing process makes it possible to print stiff cardboard copy sheets, even those which have little or no porosity and little or no absorbing ability, such as cardboard having a printing face of high quality non-absorbant paper or plastic-coated cardboard, corrugated plastic board, and other similar materials on which quality images could not be printed by conventional flexographic printing processes.

It is to be understood that the above described embodiments of the invention are illustrative only and that modifications throughout may occur to those skilled in the art. Accordingly, this invention is not to be regarded as limited to the embodiments disclosed herein, but it to be limited as defined by the appended claims.

What is claimed is:

1. In a flexographic, straight line printing machine comprising a plurality of liquid application stations each comprising a printing cylinder, at least one of which is an upstream ink printing station for the printing of ink images containing a volatile solvent/diluent onto a succession of individual cardboard copy sheets as such sheets are moved therethrough, and at least one of which is a downstream printing station, and means for continuously feeding said individual copy sheets, without bending, through said liquid application stations, the improvement which comprises an intermediate drying station comprising at least one forced hot air means positioned between each of said liquid application stations to apply a line of forced hot air across the direction of travel of said sheets as they move therepast to effect the evaporation of the solvent/diluent from the ink images printed on said cardboard copy sheets prior to the movement of the ink-imaged copy sheets into the next liquid application station, to effect the drying of said images prior to the application of the ink images or a coating thereover.

2. A flexographic, straight line printing machine according to claim 1 in which one or more of the downstream application stations comprise coating stations for the application of spot coatings or continuous coatings, to said copy sheets.

3. A flexographic, straight line printing machine according to claim 1 in which each said intermediate drying station also comprises a vapor extraction means.

4. A flexographic straight line printing machine according to claim 1 which further comprises a final station for cutting the printed cardboard copy sheets.

5. A flexographic, straight-line printing machine according to claim 1 comprising at least two adjacent ink printing stations for printing ink images of different colors in partial or complete registration on said cardboard copy sheets.

6. A method for the flexographic printing of a succession of cardboard copy sheets on a continuous straight line, flexographic printing machine which comprises the steps of continuously feeding a succession of individual cardboard copy sheets, without bending, through a plurality of liquid application stations, each having a printing cylinder, including at least one upstream ink printing station and one or more downstream stations, printing images comprising volatile solvent/diluent-containing ink onto said copy sheets as they

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move through each of said ink-printing stations to form imaged copy sheets, heating said imaged sheets after each ink-printing station by moving them past forced hot air which applies a line of forced hot air across the direction of travel of said sheets to substantially-completely evaporate the volatile solvent/diluent therefrom to form dry imaged copy sheets, prior to movement thereof into the next liquid application station,

7. A method according to claim 6 in which one of said downstream printing stations comprises a coating station in which a coating is applied which covers the dry images printed at the ink printing stations.

8. A method according to claim 7 in which a said coating is applied comprising a partial or spot coating

which overlies only a portion of the dry images printed at the ink printing stations.

9. A method according to claim 6 in which drying is accomplished by directing a narrow line of forced hot said air from air knives against said imaged copy sheets.

10. A method according to claim 6 in which the evaporated solvent/diluent is extracted from the area at which it is evaporated.

11. A method according to claim 6 which comprises printing ink images of different colors in partial or complete registration at at least two adjacent ink printing stations.

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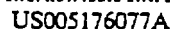
60

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FIG. 10

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[11] Patent Number: 5,176,077

[45] Date of Patent: Jan. 5, 1993

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|-----------|---------|------------------------|---------|
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Primary Examiner—Eugene H. Eickholt
Attorney, Agent, or Firm—Dennis T. Griggs

[57] ABSTRACT

A coating apparatus for use in a sheet-fed, offset rotary printing press to selectively apply a protective and/or decorative coating to the wet ink surface of freshly printed sheets and including a coating unit having a pick-up roller for supplying aqueous coating material from a reservoir to the surface of a delivery cylinder mounted on a press delivery drive shaft, the delivery cylinder performing the dual function of a coating applicator roller and a delivery cylinder during coating operations.

22 Claims, 5 Drawing Sheets

References Cited

4,270,483	6/1981	Butler et al.	118/46
4,372,244	2/1983	Rebel	118/46
4,399,767	8/1983	Simeth	118/46
4,402,267	9/1983	DeMoore	101/419
4,524,712	6/1985	Ito	118/46
4,685,414	8/1987	DiRico	118/46
4,704,296	11/1987	Leanna et al.	427/9
4,706,601	11/1987	Jahn	118/46
4,779,557	10/1988	Frazzitta	118/46

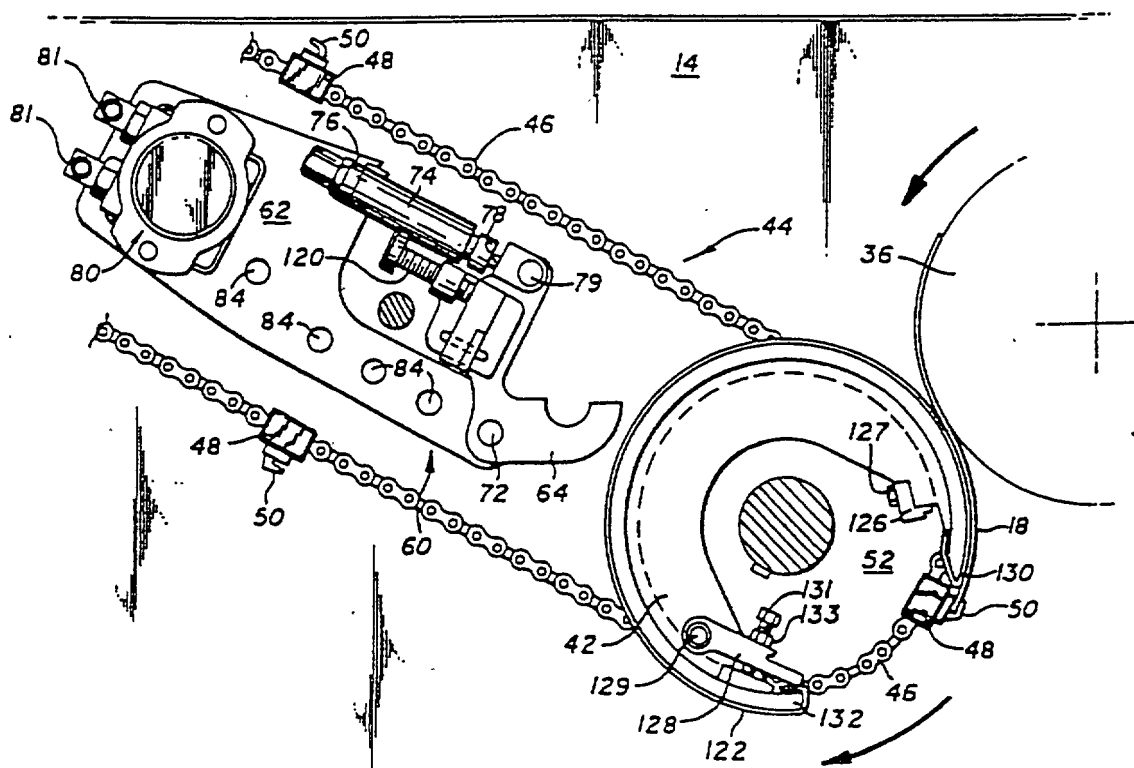


FIG. 1

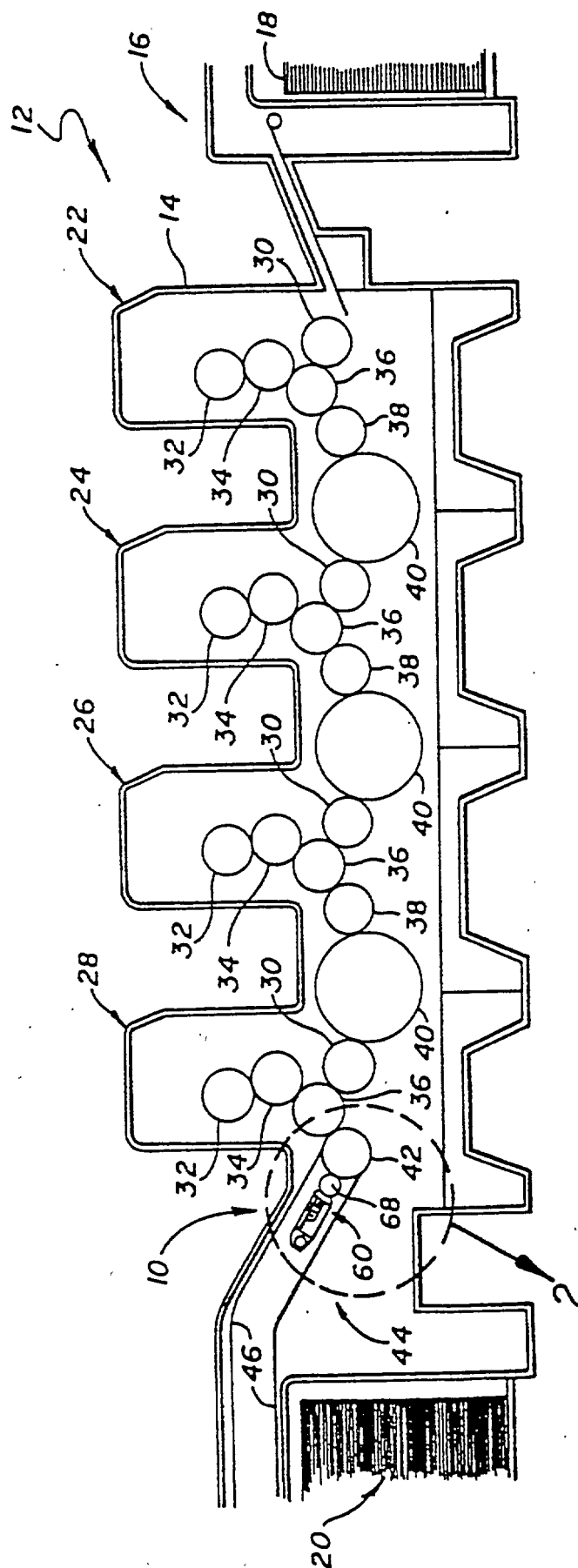


FIG. 2

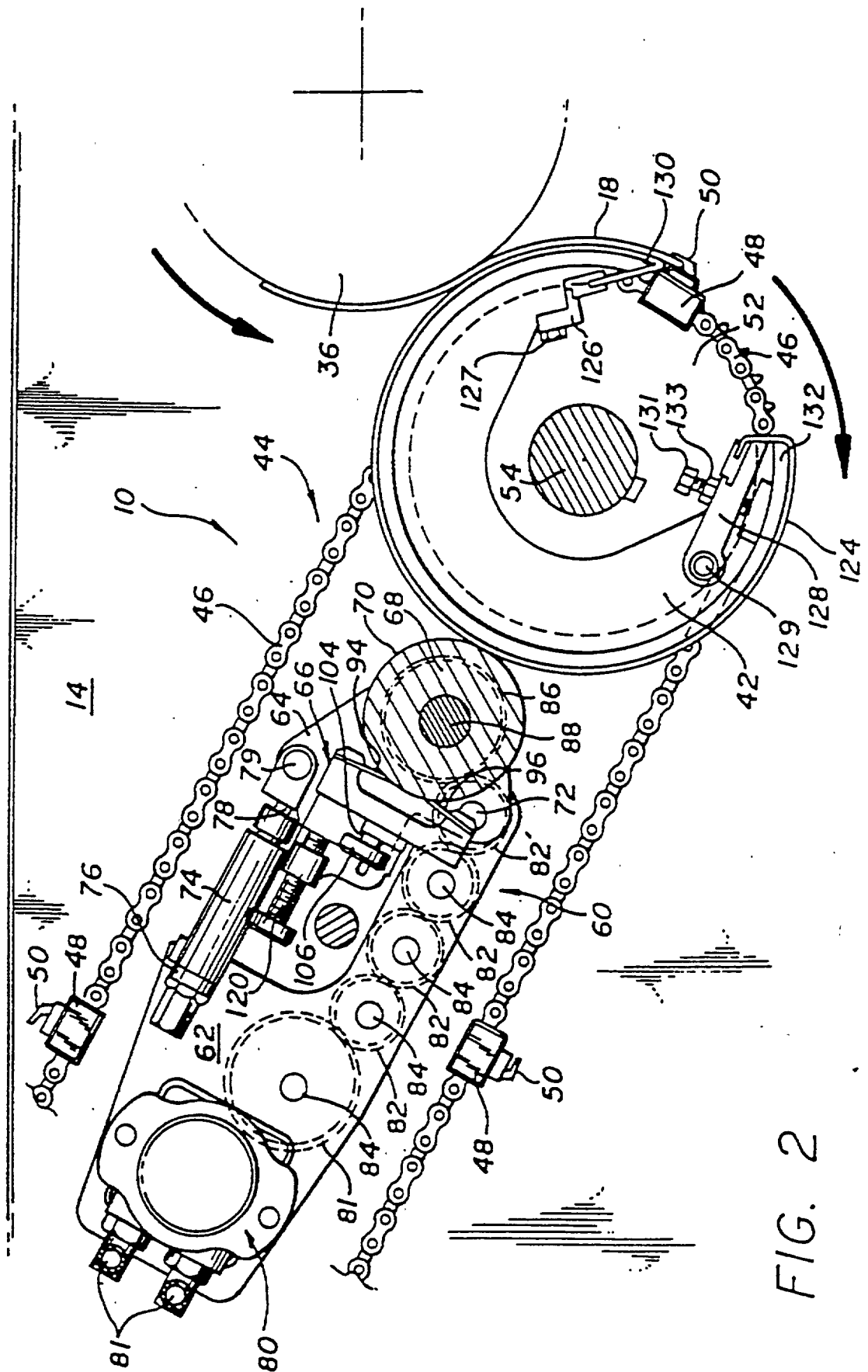


FIG. 2

FIG. 3

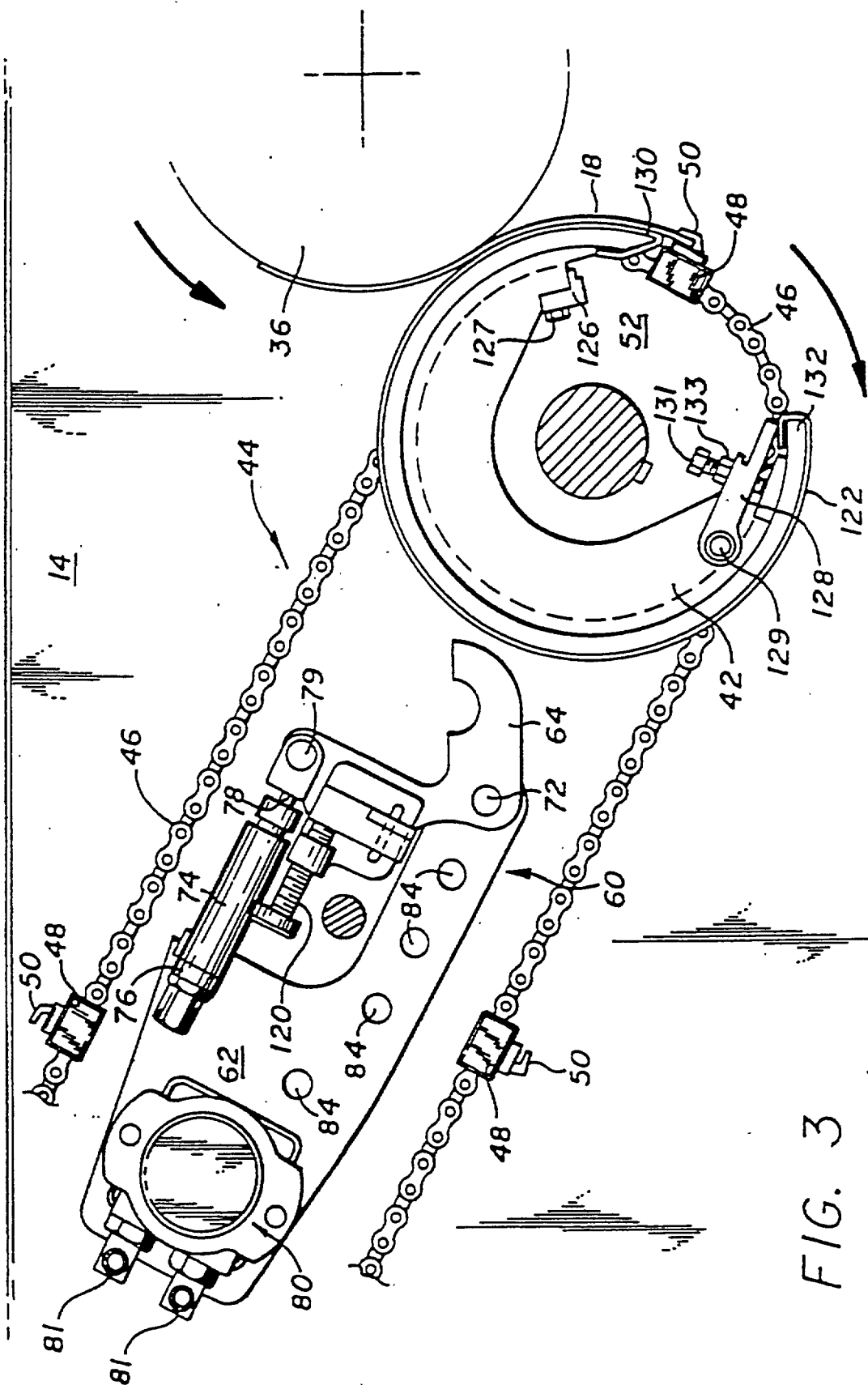
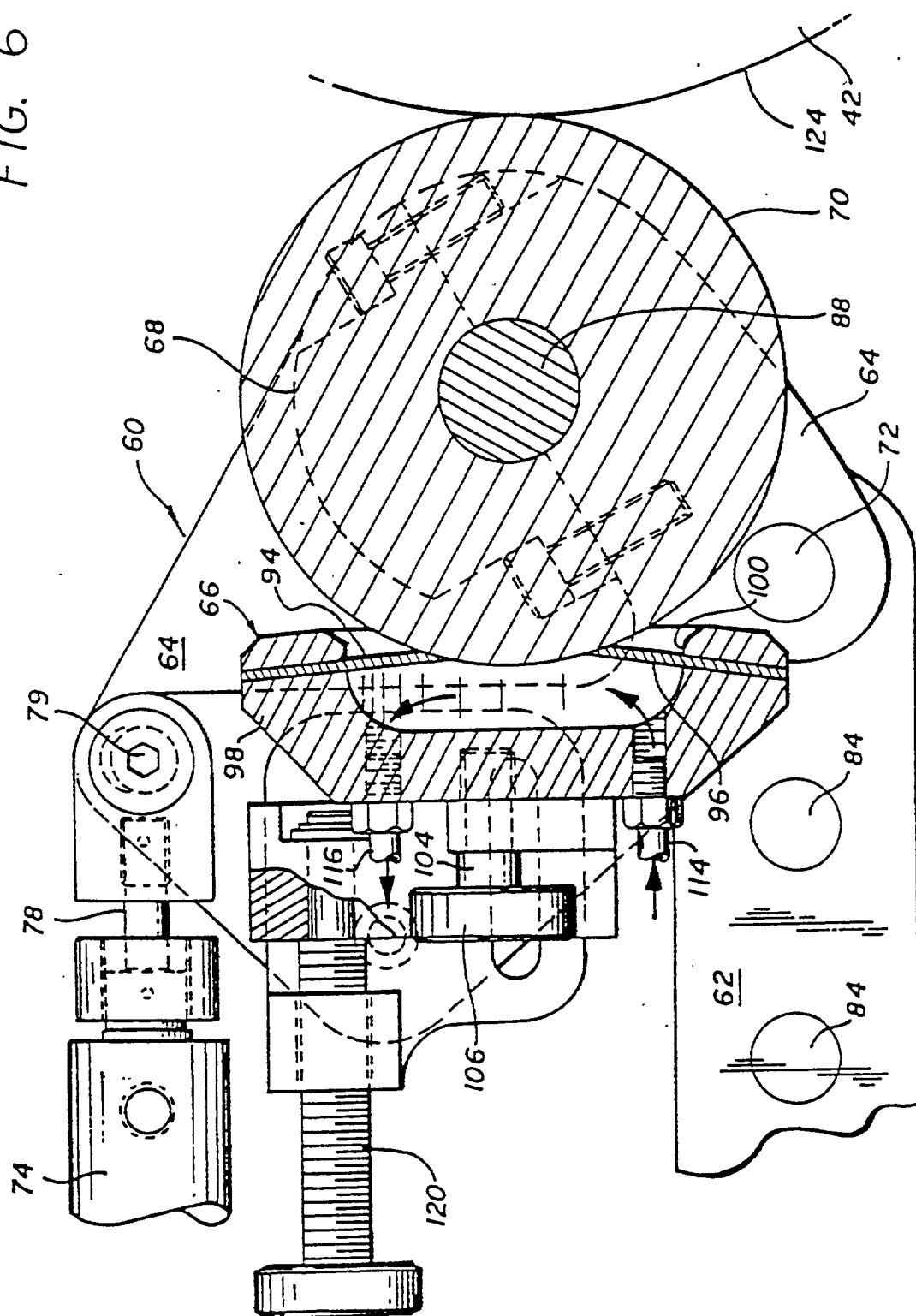


FIG. 3

FIG. 6



COATING APPARATUS FOR SHEET-FED, OFFSET ROTARY PRINTING PRESSES

BACKGROUND OF THE INVENTION

This invention relates to sheet-fed, offset rotary printing presses, and more particularly, to a new and improved apparatus for the in-line application of protective and decorative coatings to the printed surface of freshly printed sheets.

Conventional sheet-fed, offset rotary printing presses typically include one or more printing stations through which individual sheets are fed and printed with wet ink. After final printing, the sheets are fed by a delivery conveyor system to the delivery end of the press where the freshly printed sheets are collected and stacked. In a typical sheet-fed, offset rotary printing press such as the Heidelberg Speedmaster line of presses, the delivery conveyor system includes a pair of endless gripper chains carrying laterally spaced gripper bars and grippers which are used to grip and pull freshly printed sheets from the impression cylinder and convey the sheets toward the sheet delivery stacker. The gripper chains are driven in precisely timed relation to the impression cylinder by gripper chain sprocket wheels laterally spaced between a delivery drive shaft mounted on opposite sides of the press frame, the delivery drive shaft being mechanically coupled by gears for synchronous rotation with the impression cylinder.

Since the inks used with offset type printing presses typically remain wet and tacky for some time after printing, special precautions must be taken to insure that the wet inked surface of the freshly printed sheets are not marked or smeared as the sheets are transferred from one printing station to another, and through the delivery system to the sheet delivery stacker. One system for insuring that the freshly printed sheets are not marked or smeared during transfer is the transfer or delivery cylinder system marketed by Printing Research, Inc., of Dallas, Texas under its registered trademark "SUPER BLUE". That system, which is made and sold under license, is made in accordance with and operates as described in U.S. Pat. No. 4,402,267, issued Sep. 6, 1983 to Howard W. DeMoore, the disclosure of which is incorporated herein by this reference. In that system, marking and marring of freshly printed sheets is prevented by employing transfer or delivery cylinders provided with a coating of friction reducing material such as PTFE (Teflon) over which are loosely mounted fabric covers, referred to in the trade as "nets", and which support the wet ink side of the freshly printed sheets as they are pulled from the impression cylinder. Typically, in a multi-color press employing the "SUPER BLUE" cylinder system, each transfer cylinder for conveying the freshly printed sheets from one printing station to the next is supplied with a "SUPER BLUE" transfer cylinder system, and the delivery cylinder for conveying the sheets from the last printing station to the sheet delivery stacker is supplied with a "SUPER BLUE" delivery cylinder system. As used hereinafter, the term "net type cylinder" is intended to refer to cylinders having fabric nets disposed over the support surface, such as of the general type disclosed in the aforementioned DeMoore U.S. Pat. No. 4,402,267 and exemplified by the "SUPER BLUE" cylinder system.

Another system which can be used to prevent marking and smearing of the freshly printed sheets is that

disclosed in U.S. application Ser. No. 07/630,308 filed Dec. 18, 1990 entitled Vacuum Transfer Apparatus for Sheet-Fed Printing Presses now U.S. Pat. No. 5,127,329. That application, the disclosure of which is also incorporated herein by reference, discloses an apparatus which can be employed to draw the unprinted side of a freshly printed sheet into engagement with rollers which support the sheet on the unprinted side during transfer or delivery of the sheet from the impression cylinder after printing so that the wet ink on the freshly printed sheet does not come in contact with other apparatus in the press. The vacuum transfer apparatus disclosed in that application can be used as an alternative to the net type cylinder system disclosed in the aforementioned DeMoore patent, or when used in a perfecting press, as a supplement to that system, the vacuum transfer apparatus being primarily intended for use when only one-sided sheet printing is being performed by the press, and the net type cylinder system being used when the press is operating in the perfector mode with two-sided sheet printing.

In some printing applications, it is desirable that the press be capable of applying a protective and/or decorative coating over all or a portion of the surface of the printed sheets. Such coatings typically are formed of a UV-curable or water-soluble resin applied as a liquid solution or emulsion by an applicator roller over the freshly printed sheets to protect the ink and improve the appearance of the sheets. Use of such coatings is particularly desirable when decorative or protective finishes are required such as in the production of posters, record jackets, brochures, magazines, folding cartons and the like. In cases where a coating is to be applied, the coating operation is carried out after the final ink printing has been performed, most desirably by an in-line coating application, rather than as a separate step after the printed sheets have been delivered to the sheet delivery stacker.

Various suggestions have been made for applying the coating as an in-line press operation by using the final printing station of the press as the coating application station. For example, in U.S. Pat. Nos. 4,270,483, 4,685,414, and 4,779,557 there are disclosed coating apparatus which can be moved into position to allow the blanket cylinder of the last printing station of a press to be used to apply a coating material to the sheets. In U.S. Pat. No. 4,796,556 there is disclosed a coating apparatus which can be selectively moved between the blanket cylinder or the plate cylinder of the last printing station of the press so that that station can be used as a coating station for the press. However, when coating apparatus of these types are used, the last printing station can not be used to apply ink to the sheets, but rather can only be used for the coating operation. Thus, with these types of in-line press coating apparatus, the press loses the capability of printing its full range of colors since the last printing station is converted to a coating station.

Suggestions for overcoming the problem of the loss of a printing station when coating is desired have also been made, such as that set forth in U.S. Pat. Nos. 4,934,305 which discloses a coating apparatus having a separate timed applicator roller positioned to apply the coating material to the printed sheet while the sheet is on the last impression cylinder of the press. This is said to allow the last printing station to be operated simultaneously as both an ink application station and a coating

station so that no loss of press printing unit capability results. Another approach to providing a coating station without loosing the printing capabilities of the last printing station is to provide a totally separate coating unit down stream of the last printing station so that the coating is applied to the sheets after final printing and before the sheets have reached the sheet delivery stacker. Such an approach is suggested in U.S. Pat. Nos. 4,399,767 and 4,706,601. While each of these suggestions provide coating stations which allow the final printing station to continue to be used for printing, they each suffer from the disadvantages of requiring the provision of separately driven coating applicator rollers and apparatus which must be precisely timed in relation to the movement of the sheet to be coated so as to insure precise registration between application of the coating material and the printed sheet. The provision of separate timed applicator rollers require that the presses be modified to provide sufficient space within the presses to accommodate the added coating apparatus or to increase the length of the presses, and require additional and complex drive connections with the press drive system to achieve the required precise speed correlation between the sheets and the applicator rollers. Such modifications can be both expensive and cumbersome to install and maintain.

Thus, there exists a need for a new and improved in-line apparatus for use in a sheet-fed, offset rotary printing press to selectively apply a protective and/or decorative coating to the printed surface of freshly printed sheets which allows the final press printing station to continue to be used as a printing station, yet which does not require any substantial press modification or the addition of a separate timed applicator roller. As will be explained in more detail hereinafter, the present invention solves this need in a novel and unobvious manner.

SUMMARY OF THE INVENTION

The present invention provides a new and improved in-line apparatus for selectively applying a protective and/or decorative coating to the surface of freshly printed sheets in a sheet-fed, offset rotary printing press which is highly reliable and effective in use, yet which does not require any expensive or substantial press modification or result in any impairment of normal press operating capability. The present invention enables the press to be used to selectively apply the coating material to the freshly printed sheets as the sheets are conveyed from the impression cylinder of the last printing station of the press toward the sheet delivery stacker by utilizing a delivery cylinder mounted to the existing press delivery drive shaft to perform the dual function of a coating material applicator roller and a sheet delivery cylinder so that no modification of the press is required to enable the press to be used for either coating or non-coating operation, and without impairment of any normal press operations.

More specifically, the present invention is intended for use in a sheet-fed, offset rotary printing press of the type having at least one printing station which includes a blanket cylinder and an impression cylinder disposed for printing ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets off the impression cylinder and transporting the sheets toward the press sheet delivery stacker. For use of the present invention, the press must include a delivery drive shaft disposed adjacent to and extending par-

allel with the impression cylinder, and which is driven in timed synchronous relation with the impression cylinder.

In accordance with the invention, a delivery cylinder is mounted to the delivery drive shaft and provided with a coating blanket disposed over the peripheral outer surface of the cylinder, and adapted to engage and support the wet ink side of a freshly printed sheet. A coating apparatus including a supply of liquid coating material and a pick-up roller disposed to receive coating material from the supply, is mounted to the press and operable to permit the pick-up roller to be moved into engagement with the delivery cylinder so that coating material on the pick-up roller is transferred to the coating blanket of the delivery cylinder and then to the freshly printed sheet.

Preferably, the coating apparatus is mounted to the press downstream of the delivery drive shaft, and includes means to selectively move the pick-up roller into and out of engagement with the delivery cylinder. When the pick-up roller is not in the operable position in engagement with the delivery cylinder, the delivery cylinder can be used for conventional noncoating sheet delivery by removing the coating blanket and, preferably, replacing the coating blanket with a fabric net such as of the net type cylinder system previously described. To convert to a coating operation, the coating blanket is attached to the delivery cylinder and, depending upon the thickness of the sheets to be printed, packed with suitable packing sheets to increase the effective diameter of the cylinder so that pressure is applied to the freshly printed sheets against the impression cylinder by the coating blanket covered delivery cylinder. The pick-up roller is then moved to the operative position engaged with the delivery cylinder so that as freshly printed sheets are pulled by the delivery conveyor from the impression cylinder around the delivery cylinder, coating material applied to the delivery cylinder by the pick-up roller is transferred to the freshly printed sheets in the nip between the delivery cylinder and the impression cylinder.

Since the delivery cylinder is driven by the delivery drive shaft in precise timed relation with the impression cylinder, exact registration between the application of coating material and the printed sheet is assured. Further, since the coating of the freshly printed sheets is carried out through use of a delivery cylinder mounted to the existing press delivery drive shaft, no substantial press modifications are required, and the press can be quickly and easily converted between coating and non-coating operation with no loss of printing capability of the final printing station.

Many other features and advantages of the present invention will become more apparent from the following detailed description taken in conjunction with the accompanying drawings which disclose, by way of example, the principles of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic side elevational view of a sheet-fed, offset rotary printing press having a coating apparatus embodying the present invention;

FIG. 2 is an enlarged fragmentary side elevational view taken substantially within the circular area designated "2" in FIG. 1 and showing the coating apparatus of the present invention during coating operation;

FIG. 3 is a side elevational view similar to FIG. 2, but showing the coating apparatus in the inoperative position.

tion with the coating pick-up roller and reservoir removed, and the blanket covering over the delivery cylinder replaced with a fabric net for non-coating printing;

FIG. 4 is an enlarged fragmentary perspective view showing one side of the coating apparatus mounted in the press and illustrating the fluid path of coating material from a supply tank to the reservoir of the coating unit;

FIG. 5 is an enlarged fragmentary perspective view illustrating the end mounting of the coating pick-up roller to its support bracket; and

FIG. 6 is an enlarged fragmentary sectional view taken substantially along the lines 6—6 of FIG. 4.

DETAILED DESCRIPTION OF PRESENTLY PREFERRED EMBODIMENT

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line apparatus, herein generally designated 10, for selective use in applying a protective and/or decorative coating to the freshly printed surface of sheets printed in a sheet-fed, offset rotary printing press, herein generally designated 12. In this instance, as shown in FIG. 1, the coating apparatus 10 is illustrated as installed in a four color printing press 12, such as that manufactured by Heidelberg Druckmaschinen AG of the Federal Republic of Germany under its designation "Heidelberg Speedmaster 102V (40"), and which includes a press frame 14 coupled at one end, herein the right end, with a sheet feeder 16 from which sheets, herein designated 18, are individually and sequentially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the finally printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical sheet printing stations 22, 24, 26 and 28 which can print different color inks onto the sheets as they are moved through the press 10.

As illustrated, each of the printing stations 22, 24, 26 and 28 is substantially identical and of conventional design, herein including a sheet feed cylinder 30, a plate cylinder 32, a blanket cylinder 34 and an impression cylinder 36, with each of the first three printing stations 22, 24, and 26 having a transfer cylinder 38 disposed to withdraw the freshly printed sheets from the adjacent impression cylinder and transfer the freshly printed sheets to the next printing station via a transfer drum 40. The final printing station 28 herein is shown as equipped with a delivery cylinder 42 which functions to support the printed sheet 18 as it is moved from the final impression cylinder 36 by a delivery conveyor system, generally designated 44, to the sheet delivery stacker 20.

The delivery conveyor system 44 herein is of conventional design and includes a pair of endless delivery gripper chains 46, only one of which is shown in the drawings, carrying at regular spaced locations along the chains, laterally disposed gripper bars 48 having gripper elements 50 used to grip the leading edge of a sheet 18 after it leaves the nip between the delivery cylinder 42 and impression cylinder 36 of the last printing station 28. As the leading edge of the sheet 18 is gripped by the grippers 50, the delivery chains 46 pull the sheet away from the impression cylinder 36 and convey the freshly printed sheet to the sheet delivery stacker 20 where the grippers release the finally printed sheet. The endless delivery chains 46 are driven in synchronous timed relation to the impression cylinder 36 by sprocket

wheels 52 fixed adjacent the lateral ends of a delivery drive shaft 54 which has a mechanically geared coupling (not shown) through the press drive system to the impression cylinder. The delivery drive shaft 54 extends laterally between the sides of the press frame 14 adjacent the impression cylinder 36 of the last printing station 28, and is disposed to be parallel with the axis of the impression cylinder. In this instance, the delivery cylinder 42, which is constructed to allow adjustments in diameter by suitable means, is fixedly mounted to the delivery drive shaft 54 so that the delivery cylinder is also rotated in precise timed relation to the impression cylinder.

Preferably, each of the transfer cylinders 38 is equipped with an anti-marking system such as the aforementioned net type transfer cylinder system or the press 12 can be supplied in the transfer positions with vacuum transfer systems of the type disclosed in the above-identified copending U.S. application Ser. No. 07/630,308 filed Dec. 18, 1990, although as will become more apparent hereinafter, the use of such transfer systems is not required for the present invention and other types of transfer systems can be used. For reasons that will become more apparent hereinafter, for most effective use of the present invention, however, the delivery cylinder 42 should be of the type which employs the "SUPER BLUE" delivery cylinder system, or, as an alternative, should employ in the delivery position, a vacuum transfer system such as disclosed in the above-identified copending U.S. application Ser. No. 07/630,308.

In this respect, it is important to note that when the freshly printed sheets 18 are conveyed away from the impression cylinder 36 of the final printing station 28 by the gripper 50 carried by the delivery chains 46, the wet inked surfaces of the sheets face the delivery drive shaft 54 and the sheets must be supported such that the ink is not marked or smeared as the sheets are transferred. Typically, such support is provided by skeleton wheels or cylinders mounted to the press delivery drive shaft 54, or as is now more commonly used, net type delivery cylinders such as of the "SUPER BLUE" delivery cylinder system type disclosed in the aforementioned DeMoore patent. More recently, vacuum transfer apparatus of the type disclosed in the aforementioned copending U.S. application Ser. No. 07/630,308 have been used in place of delivery cylinders or skeleton wheels to pull the unprinted side of the sheet away from the delivery drive shaft 54 so that the wet ink surface of the sheets do not come into contact with any press apparatus. It has been found, however, that when a protective or decorative coating material is applied to the wet ink surface of the sheets, the coating protects the wet ink against marking and smearing such that the coating applicator roller itself can be used to support the wet inked surface of the sheets without fear of damage to the freshly printed surface.

In accordance with the present invention, the in-line coating apparatus 10 for selectively applying the protective or decorative coating to the sheets 18 enables the press 12 to be operated in the normal manner without the loss of the final printing station 28, and without requiring any substantial press modifications by employing the existing press delivery drive shaft 54 as the mounting location for the coating applicator roller. In presses 12 utilizing a net type delivery cylinder system, that system can be quickly and easily converted to perform the dual function of being a coating applicator roller and a delivery cylinder. In presses having other

types of delivery systems such as skeleton wheels mounted on the delivery drive shaft 54 or a vacuum transfer apparatus as disclosed in the aforementioned copending U.S. application Ser. No. 07/630,308, conversion to a coating operation can be quickly and easily achieved by mounting on the press delivery drive shaft in place of the skeleton wheels or in addition to the vacuum transfer apparatus, a suitable support cylinder capable of performing the combined function of a coating applicator roller and a delivery cylinder 42. Typically, such a support cylinder will have a diameter which provides no more than about a 0.090 inch clearance between the cylinder support surface and the adjacent impression cylinder 36. By utilizing the delivery cylinder 42 mounted on the delivery drive shaft 54 to also act as a coating applicator roller, the present invention insures that the coating will be applied to the printed sheet 18 in precise timed registration, and will permit the press to be operated with its full range of printing stations, yet allow fast, simple and convenient change-over from coating to noncoating operations, and vice versa, with a minimum of press down time.

Toward these ends, the coating apparatus 10 of the present invention includes a relatively simple, positive acting and economical coating unit, generally designated 60, mounted to the press frame 14 down stream of the delivery drive shaft 54 and positioned to selectively supply coating material to the support surface of a delivery cylinder 42 mounted on the delivery drive shaft. As best can be seen in FIGS. 2, 4 and 6, the coating unit 60 herein comprises a pair of side frames 62, only one of which is shown, it being understood that the other side frame is substantially the same as that of the side frame illustrated, attached to each side of the press frame 14. Pivotally mounted to one end of each of the side frames 62 is a support bracket 64 carrying one end of a coating material reservoir 66 and cooperating coating material pick-up roller 68 each disposed to extend laterally across the press 12 parallel with the delivery drive shaft 54. The coating unit 60 is mounted between the upper and lower runs of the delivery chains 46 down stream of the delivery drive shaft 54, and positioned so that the outer peripheral surface 70 of the pick-up roller 68 can be frictionally engaged with the support surface of a delivery cylinder 42 mounted on the delivery drive shaft.

As best seen in FIGS. 2 through 4, the support bracket 64 is pivotally attached to the end of the side frame 62 by a shaft 72 disposed at the lower end portion of the bracket, and can be pivoted about the shaft by an extensible cylinder 74, herein shown as a hydraulic cylinder, one end 76 of which is secured such as by welding to the side frame, and the opposite end 78 of which is coupled through a pivot shaft 79 to the upper end portion of the bracket. By extending or retracting the cylinder 74, the extent of frictional engagement of the pick-up roller 68 with the surface of the delivery cylinder 42 can be controlled, and the pick-up roller can be completely disengaged from the delivery cylinder.

The coating pick-up roller 68, which can be of conventional design and preferably one such as the Anilox rollers manufactured by A.R.C. International of Charlotte, N.C., and sold under the name "PRINTMASTER" having an engraved ceramic or chrome outer peripheral surface 70, is designed to pick up a predetermined uniform thickness of coating material from the reservoir 66, and then uniformly transfer the coating to the support surface of the delivery cylinder 42. To ef-

fect rotation of the pick-up roller 68, a suitable motor 80, herein a hydraulic motor, is attached to one of the side frames 62 and coupled to a suitable hydraulic fluid source (not shown) through fittings 81. Attached to the output of the motor 80 is an output gear which is drivingly coupled through a reduction gear 81 and a series of idler gears 82 each mounted on stub axles 84, to a drive gear 86 attached to the end of a shaft 88 on which the pick-up roller 68 is concentrically mounted. The shaft 88 of the pick-up roller 68 is, in turn, journaled at each end to the brackets 64 through a releasable semi-circular collar 90 (see FIG. 5) attached by bolts 92 to the bracket. Herein, the axle of the terminal idler gear, designated 82', also serves as the shaft 72 for pivotally mounting the support bracket 64 to the side frame 62 so that when the bracket is rotated about the shaft, the terminal idler gear remains engaged with the drive gear 86 of the pick-up roller 68.

In this instance, as best as can be seen in FIG. 6, the pick-up roller 68 has a portion which projects laterally into the reservoir 66 containing the supply of coating material, and a pair of upper and lower inclined doctor blades 94 and 96 attached to the reservoir engage the roller surface to meter the coating material picked up from the reservoir by the etched surface 70 of the roller. The reservoir 66 herein is formed by an elongated, generally rectangular housing 98 having a generally C-shaped cross-section with a laterally extending opening 100 along one side facing the pick-up roller 68, and is supplied with coating material from a supply tank 102 disposed in a remote location within or near the press 12. Preferably, the reservoir 66 is removably attached to the brackets 64, herein by bolts 104 having enlarged, knurled heads 106, and which can be threaded through slots 108 formed in the brackets to clamp the reservoir in place on the brackets.

To insure that an adequate supply of coating material is always present within the reservoir 66 and to prevent coagulation and clogging of the doctor blades 94 and 96 by the aqueous coating material, the coating material is circulated through the reservoir, herein by two substantially identical pumps 110 and 112, one of which pumps coating material from the supply tank 102 via a supply line 114 to the bottom of the reservoir, and the other of which acts to provide suction to a pair of return lines 116 coupled adjacent the top of the reservoir for withdrawing unused coating material from the reservoir. By circulating the coating material from the supply tank 102 at a greater rate than the rate of withdrawal of material by the pick-up roller 68, a substantially constant supply of coating material will always be present within the reservoir 66.

In this instance, the general arrangement of the pick-up roller 68, doctor blades 94 and 96, and reservoir 66 is, substantially like that disclosed in U.S. Pat. No. 4,821,672 entitled DOCTOR BLADE ASSEMBLY WITH ROTARY END SEALS AND INTERCHANGEABLE HEADS", the disclosure of which can be reviewed for details concerning the structure and operation of a pick-up roller and reservoir usable with the present invention.

Once the coating unit 60 has been installed in a press 12, which basically only requires that the side frames 62 be attached, such as with bolts, to the sides of the press frame 14, and the hydraulic motor 80 be coupled with a suitable hydraulic source, the press can be quickly and easily converted to the coating mode. In presses 12 already supplied with a net type delivery cylinder sys-

tem, to convert to a coating operation, all that is necessary is that the fabric net material (designated 122 in FIG. 3) normally used over the support surface of the net type delivery cylinder during noncoating press operations, be removed and replaced with a coating blanket 124 capable of transferring coating material deposited thereon onto the printed sheets. Typically, such a blanket 124 can be formed as a rubber covering such as used for the covering surface of the conventional blanket cylinders 34 of the press 12. In presses 12 having conventional skeleton wheels or a vacuum transfer type apparatus such as that of the aforementioned copending U.S. application Ser. No. 07/630,308, a suitable delivery cylinder 42 can be fixed to the delivery drive shaft 54 and a similar coating blanket 124 applied thereto over the cylinder surface.

It is important to note that during nonprinting operations, the net type delivery cylinder 42 does not engage the surface of the impression cylinder 36 during sheet delivery. However, when used as a coating applicator roller during coating operations, the effective diameter of the delivery cylinder 42 must be increased so that the coating blanket 124 presses the sheet 18 against the surface of the impression cylinder 36, as shown in FIG. 2. To increase the effective diameter of the delivery cylinder 42, the thickness of the coating blanket 124 applied over the support surface of the delivery cylinder 42 can be selected to correspond with the thickness of the sheets 18 to be printed, or suitable packing sheets, such as paper sheets (not shown) of the type conventionally used in conjunction with press blanket cylinders 34, can be interposed between the delivery cylinder and the coating blanket.

While any suitable means can be used to attach the coating blanket 124 to the support surface of the delivery cylinder 42, in this instance, as shown in FIGS. 2 and 3, the delivery cylinder is supplied with clamps 126 attached by bolts 127 to the cylinder adjacent the leading edge 130 to secure the leading edge of the coating blanket 124 to the cylinder, and adjustable tensioning clamps 128 are provided adjacent the cylinder trailing edge 132 for securing the trailing edge of the blanket to the cylinder. However, the tensioning clamps 128 are pivotally mounted at one end by a pin 129 to the cylinder 42, and the blanket tension is adjusted through a bolt 131 and nut 133 arrangement. Depending upon the thickness of the sheets 18 to be printed and coated by the press 12, one or more layers of packing paper or the like may be interposed between the support surface of the delivery cylinder 42 and the coating blanket 124 to increase the effective diameter of the cylinder. Provision of the tensioning clamps 128 for attaching the coating blanket 124 to the leading edge 132 of the delivery cylinder 42 allows for such control and adjustment.

Once installed, the coating unit 60 can remain in position even though the press 12 is operated in the non-coating mode. In this respect, when the coating unit 60 is not in operation, the extensible cylinder 74 can be actuated to pivot the support brackets 64 carrying the pick-up roller 68 and reservoir 66 about the shaft 72 and away from the delivery cylinder 42, thus rendering the coating unit inoperative. This then also frees the pick-up roller 68 and reservoir 66 for fast and easy removal from the coating unit 60 for cleaning, service or replacement. To remove the pick-up roller 68, the coating material is drained from the reservoir 66, and the pressure exerted by the doctor blades 94 and 96 against the roller is released, therein through operation

of a pressure adjustment screw 120 attached to the reservoir, and the bolts 92 and collars 90 are removed, thereby permitting the pick-up roller to be lifted from the coating unit 60. To remove the reservoir 66, all that need be done is to release the mounting bolts 104 securing the reservoir to the brackets 64. With the coating unit 60 moved by the extensible cylinder 74 to the inoperative position, the delivery cylinder 42 can be converted for normal delivery cylinder operation simply by removing the coating blanket 124 from the delivery cylinder 42 and replacing the blanket with a fabric net 122. Alternatively, if a vacuum transfer apparatus such as described in the aforementioned copending U.S. application Ser. No. 07/630,308 is installed in the press 12, that apparatus can be activated to deliver sheets from the impression cylinder 36 without effecting any delivery cylinder change since the freshly printed side of the sheets will not come into contact with the delivery cylinder.

In a typical noncoating operation of the press 12 with the coating apparatus 10 installed, the coating unit 60 will be in the inoperative position. In that situation and with a net type delivery cylinder 42 installed, the delivery cylinder will be covered with the fabric net 122 so that the delivery cylinder operates in the normal manner with the wet ink side of the freshly printed sheets 18 being supported by the net covered surface of the delivery cylinder. Should the press 12 include a vacuum transfer apparatus such as disclosed in the aforementioned copending U.S. application Ser. No. 07/630,308, the delivery cylinder 42 can remain on the delivery drive shaft 54, with or without a fabric net 122, depending upon whether or not the press is used for perfecter printing.

When it is desired to convert to the coating mode of operation, the press 12 is stopped just long enough to replace the fabric net 122 on the delivery cylinder 42 with the coating blanket 124 packed to the required extent necessary for providing the proper pressure to effect coating of the sheet thickness to be printed. Thereafter, the pumps 110 and 112 are activated and the press 12 re-started. The extensible cylinder 74 can then be activated to control the pressure of the pick-up roller 68 against the delivery cylinder 42 to obtain the desired application of coating material to the freshly printed sheets 18.

Notably, with the coating apparatus 10 of the present invention, no timing adjustments between the delivery cylinder 42 and the impression cylinder 36 are required to achieve and maintain precise registration between application of the coating material and the printed surface of the sheets 18. Further, the coating unit 60 permits a wide range of coating weights to be applied to the printed sheets 18 by quickly and easily changing pick-up rollers 68 from those designed to produce a very light coating application to those designed to produce a very thick coating application can be used.

From the foregoing, it should be apparent that the coating apparatus 10 of the present invention provides a highly reliable, effective and economical in-line apparatus for selectively applying coating material to the freshly printed sheets 18 in a sheet-fed, offset rotary printing press 12 which allows the final printing station to continue to be used as a print station, yet which does not require any substantial press modification or the addition of a separate timed applicator roller. While a particular form of the present invention has been illustrated and described, it should be apparent that varia-

tions and modifications therein can be made without departing from the spirit and scope of the invention.

We claim:

1. In a sheet-fed, offset rotary printing press of the type including at least one printing station having a blanket cylinder and an impression cylinder disposed for printing ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery conveyor system including a delivery drive shaft disposed adjacent to and extending parallel with the impression cylinder and driven in timed synchronous relation with the impression cylinder, the improvement comprising:

a delivery cylinder mounted to said delivery drive shaft and having an outer peripheral support surface adapted to engage and support a sheet being transported by said delivery conveyor system;

a coating apparatus including a supply of liquid coating material, a rotatable pick-up roller having an outer peripheral surface of substantially cylindrical shape, and means for applying a coating of liquid coating material from said supply onto said outer peripheral surface of said pick-up roller; and

means for mounting said coating apparatus to the press adjacent said delivery cylinder including selectively operable means for moving said pick-up roller between a first operable position with a portion of said peripheral surface of said pick-up roller engaged with said support surface of said delivery cylinder, and a second inoperable position with said peripheral surface out of engagement with said support surface of said delivery cylinder, whereby when said pick-up roller is in said first operable position, liquid coating material from said supply applied onto said peripheral surface of said pick-up roller is transferred to said support surface of said delivery cylinder and to said freshly printed sheet.

2. The improvement as set forth in claim 1 wherein said delivery cylinder includes a coating blanket disposed over said peripheral support surface.

3. The improvement as set forth in claim 1 wherein said delivery cylinder includes a removable coating blanket disposed over said peripheral support surface when said pick-up roller is in said first operable position.

4. The improvement as set forth in claim 3 wherein said coating blanket has a rubber outer surface.

5. The improvement as set forth in claim 3 wherein said delivery cylinder includes a fabric net disposed over said peripheral support surface when said pick-up roller is in said second inoperable position.

6. The improvement as set forth in claim 1 wherein said coating apparatus includes an elongated reservoir containing said supply of liquid coating material, said reservoir being disposed to extend parallel with said pick-up roller with a portion of said peripheral surface extending into said reservoir in contact with liquid coating material contained therein, and at least one doctor blade attached to said reservoir and engaging said peripheral surface, said doctor blade acting to limit the amount of liquid coating material applied onto said peripheral surface from said reservoir.

7. The improvement as set forth in claim 6 wherein said reservoir and said pick-up roller are movably coupled to said press and said selectively operable means includes an extensible cylinder coupled between said reservoir and said press and operable to move said res-

ervoir and said pick-up roller between said first and second positions.

8. The improvement as set forth in claim 7 wherein said pick-up roller is rotatably driven by a motor attached to said coating apparatus.

9. The improvement as set forth in claim 8 wherein said delivery cylinder includes a rubber coating blanket disposed over said peripheral support surface when said pick-up roller is in said first operable position, and includes a fabric net disposed over said peripheral support surface when said pick-up roller is in said second inoperable position.

10. The improvement as set forth in claim 9 wherein said coating apparatus is mounted to said press downstream of said delivery drive shaft in the direction of travel of said sheets during transport by said delivery conveyor system.

11. The improvement as set forth in claim 1 wherein said mounting means includes first and second side frames mounted on said press, a support shaft mounted on and extending between said first and second side frames, a support bracket attached to said coating apparatus and movably coupled to said support shaft for pivotal movement between said first and second positions, and said selectively operable means includes an extensible cylinder coupled between said coating apparatus and said support bracket and operable to move said coating apparatus toward and away from said delivery cylinder.

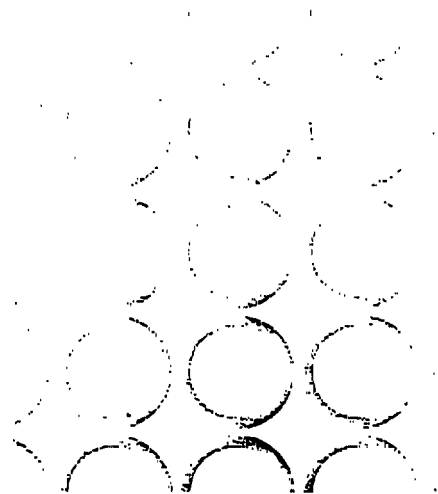
12. In a sheet-fed, offset rotary printing press of the type including at least one printing station having a blanket cylinder and an impression cylinder disposed for printing wet ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery conveyor system comprising a pair of endless gripper chains disposed on opposite sides of the press and supporting therebetween gripper bars and grippers spaced along the chains, the gripper chains being driven in timed synchronous relation with the impression cylinder by laterally spaced sprocket wheels mounted on opposite ends of a delivery drive shaft disposed adjacent to and extending parallel with the impression cylinder, the improvement comprising:

a delivery cylinder mounted to said delivery drive shaft between said sprocket wheels and having an outer peripheral support surface covered by a removable coating blanket adapted to engage and support the wet ink side of a sheet being transported by said gripper bars;

a coating apparatus including a supply of liquid coating material, a rotatable pick-up roller having an outer peripheral surface of substantially cylindrical shape communicating with said supply, and means for applying liquid coating material from said supply onto said peripheral surface of said pick-up roller; and,

means for mounting said coating apparatus to the press adjacent the delivery cylinder, said means including selectively operable means for moving said coating apparatus between a first operable position with a portion of said peripheral surface of said pick-up roller engaged with said delivery cylinder, and a second inoperable position with said peripheral surface of said pick-up roller out of engagement with said delivery cylinder, whereby when said coating apparatus is in said first operable

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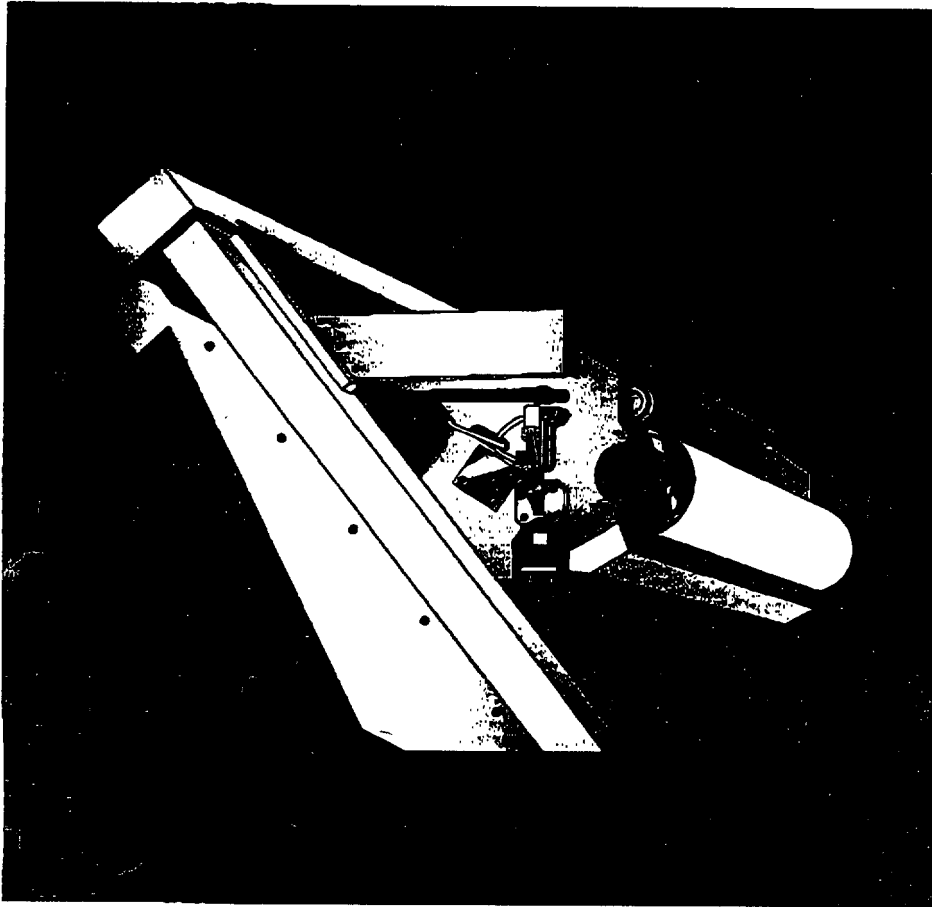


SUPER BLUE

**PBC PLATE/BLANKET
AND PC PLATE COATER**

**BECAUSE TO MOST
CUSTOMERS HIGH
GLOSS MEANS
HIGH QUALITY**

It is now possible to dramatically increase gloss levels of printed sheets



Among print buyers and consumers alike, "gloss" and "feel" are strongly associated with quality. Through our systems, printers can profitably achieve superb finish-quality and high-impact appearance at low cost.

Our Plate/Blanket Coater (PBC) maximizes your coating flexibility, giving you more precise control and broader capabilities than ever before. Offering full-coverage gloss or matte coatings as well as spot coatings of impeccable register and quality, the PBC smoothly and consistently applies uniform coatings of a wide viscosity range to any desired thickness.

- Precision spot-register applications
- Elimination of halos and hard/beaded edges
- Maximum coating application

The advent of coatable, water-based and UV-curable resins offers sheetfed color printers the unprecedented power to add high gloss levels, special effects and unusual surface treatments to their range of *in-house* capabilities. These coatings vastly exceed the gloss potential of varnish, while banishing forever the mess and quality problems spray powder causes in the pressroom.

Maximize press production while minimizing clean-up

Because the PBC is easily retracted when coating is not necessary, the press unit used for coating can function as a full printing unit whenever you need it. Or, you can easily establish a dedicated coating line on an under-used press. What's more, with our coaters, you will eliminate forever the press downtime associated with blanket cutting, packing and image registration. No other coater can accomplish this.

Our coaters minimize wash-up and makeready, offering unrivaled time and cost savings. Ruggedly constructed, easy to operate and maintain, our patented coaters are on the leading edge of industry technology.

Winner



InterTech Award

- Makeready as fast as regular ink presses
- Elimination of slinging and misting problems
- Minimized wash-up times

The PBC provides unparalleled quality control, enabling you to coat with as much control as you print. Coating material is applied as if it were another ink color, using your printing unit as it was designed to operate — to lay down a precise film membrane on the substrate.

What's more, the PBC achieves this high-impact appearance in a fraction of the time it takes to varnish or laminate — and without the mess and quality control problems associated with these now obsolete methods. So your customers receive the highest quality product, with an incredibly fast turnaround.

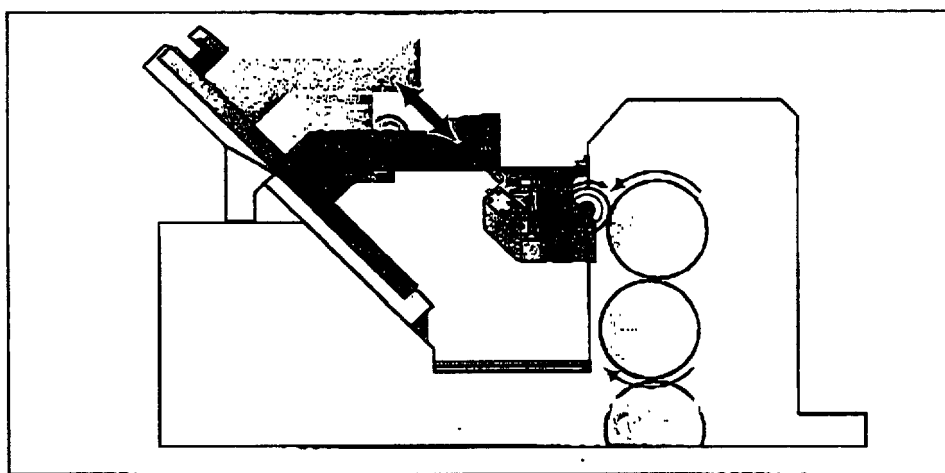
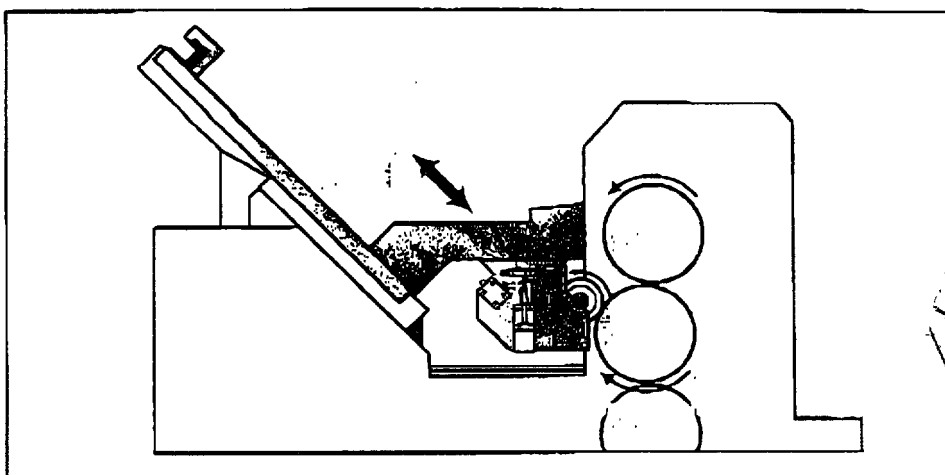
The PBC applies coating either at the blanket, for full coverage work, or at the plate, for precise register application of spot coating without hard edges. Or when coating is not necessary, it can be easily retracted to allow for regular printing uses. Unlike other coater designs that haphazardly squeeze coating material onto substrate under pressure — slinging coating material — the shear-coating PBC works neatly and precisely.

In the blanket mode when overall coverage is required, PBC's design provides for fast makeready and smooth application of the coating.

In the plate mode, the coater applies coating to a relief image on the plate cylinder to apply a uniform thickness of the coating film to the blanket cylinder. This coating "image" is then transferred by the blanket to the substrate, ensuring precise registration in all axes. Coating thickness and pressure between the plate, blanket and impression cylinders are all accurately and easily controlled.

Both the PBC and its Common Impression Cylinder (CIC) press counterpart, the Plate Coater (PC), improve operational profitability by eliminating the extensive "wash-up" downtime associated with coater dampeners — the only alternative with a CIC press. The typical two to three hour wash-up is reduced to less than a half hour, and the entire process is carried out independently from the press.

Being fully retractable, the coater does not interfere with the dampening system, ensuring fast changeover from print to coat and coat to print. This makes your entire operation more efficient *and* more profitable.

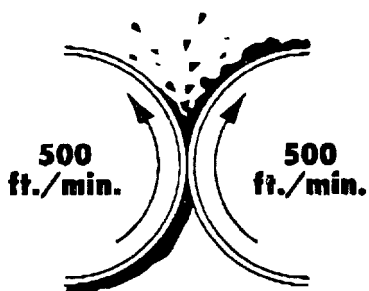


PBC in Plate Position

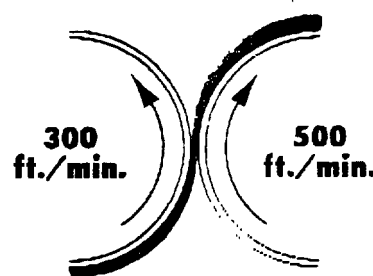
Productivity, safety and long-term value

As a supplier of precision-engineered coating and drying systems for the graphic arts and packaging industries, Printing Research, Inc.'s high-performance systems improve your bottom-line profitability by adding value to your existing operations. With our systems, you improve the quality of your services by becoming a low-cost provider of the highest quality printing — all while maximizing the utilization of your existing presses. Our dependable, high-performance systems will increase your sales, profits and customer satisfaction levels.

See the difference yourself. Experience a demonstration of our PBC and PC and witness how coatings can be as easy to handle and precise to apply as the ink used in daily printing!



NIP 500 ft./min.



SHEAR 300/500 ft./min.

Instant-drying inks and the elimination of spray powder have been the dream of every printer and printing buyer. The idea was put forward in the 1970's and 80's that it would be possible to print with conventional inks and apply a coating which would dry completely before placement on the delivery stack. This would place a dry skin over the ink, eliminating offsetting, sheet marking and the need for spray powder. The inks dry under the coating.

The advent of the 90's has made the dream a reality. It is now possible to print superior quality with conventional inks and coat the surface in order to deliver a dry, mark-free sheet at full production speeds. This is what the Super Blue products from Printing Research accomplish for you.



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Telephone 214-353-9000
Telex 794028 Superblue dal
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Patented

[illegible]

THE UNIVERSITY OF CHICAGO



US005176077A

United States Patent [19]

DeMoore et al.

[11] Patent Number: 5,176,077

[45] Date of Patent: Jan. 5, 1993

[54] COATING APPARATUS FOR SHEET-FED,
OFFSET ROTARY PRINTING PRESSES[75] Inventors: Howard W. DeMoore, 2552 Royal
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[73] Assignee: Howard W. DeMoore, Dallas, Tex.

[21] Appl. No.: 752,778

[22] Filed: Aug. 30, 1991

[51] Int. Cl.⁵ B41F 9/00[52] U.S. Cl. 101/142; 101/147;
101/232; 101/348; 118/46[58] Field of Search 101/135, 424.1, 142,
101/148, 155, 157, 177, 217, 232, 246, 329, 330,
331, 408, 409, 419, 422, 348-349; 118/46, 211,
236, 249, 257, 258, 261, 262, 263, 206, DIG. 15

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Primary Examiner—Eugene H. Eickholt

Attorney, Agent, or Firm—Dennis T. Griggs

[57] ABSTRACT

A coating apparatus for use in a sheet-fed, offset rotary printing press to selectively apply a protective and/or decorative coating to the wet ink surface of freshly printed sheets and including a coating unit having a pick-up roller for supplying aqueous coating material from a reservoir to the surface of a delivery cylinder mounted on a press delivery drive shaft, the delivery cylinder performing the dual function of a coating applicator roller and a delivery cylinder during coating operations.

22 Claims, 5 Drawing Sheets

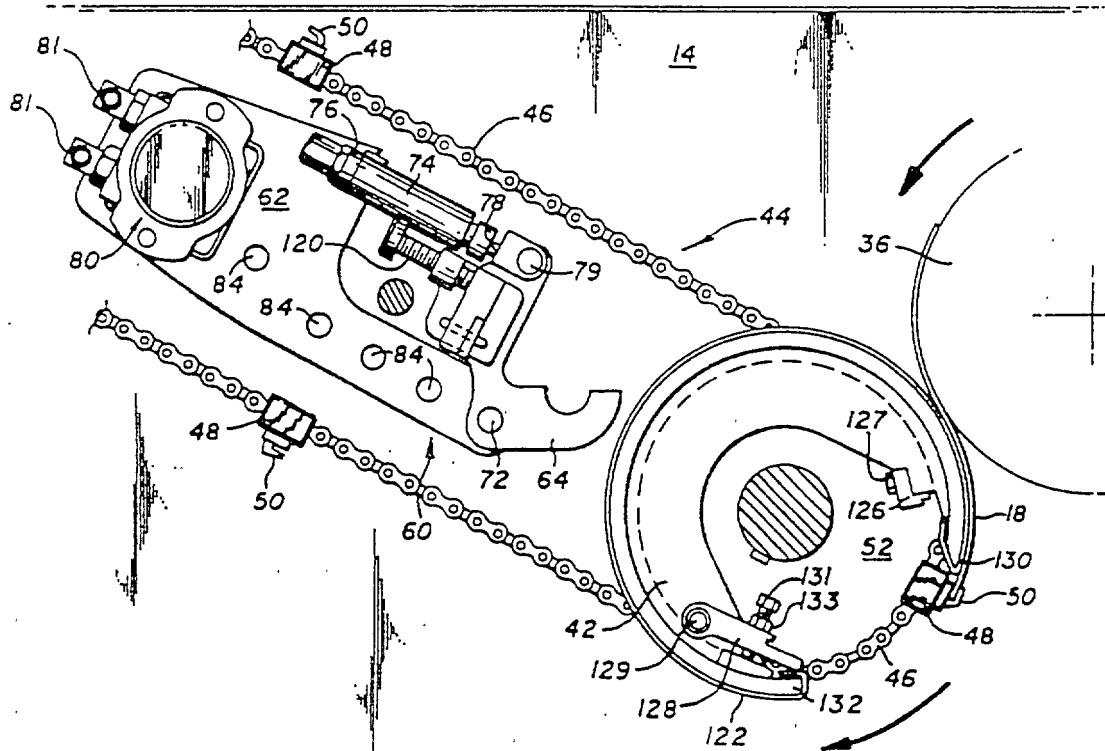
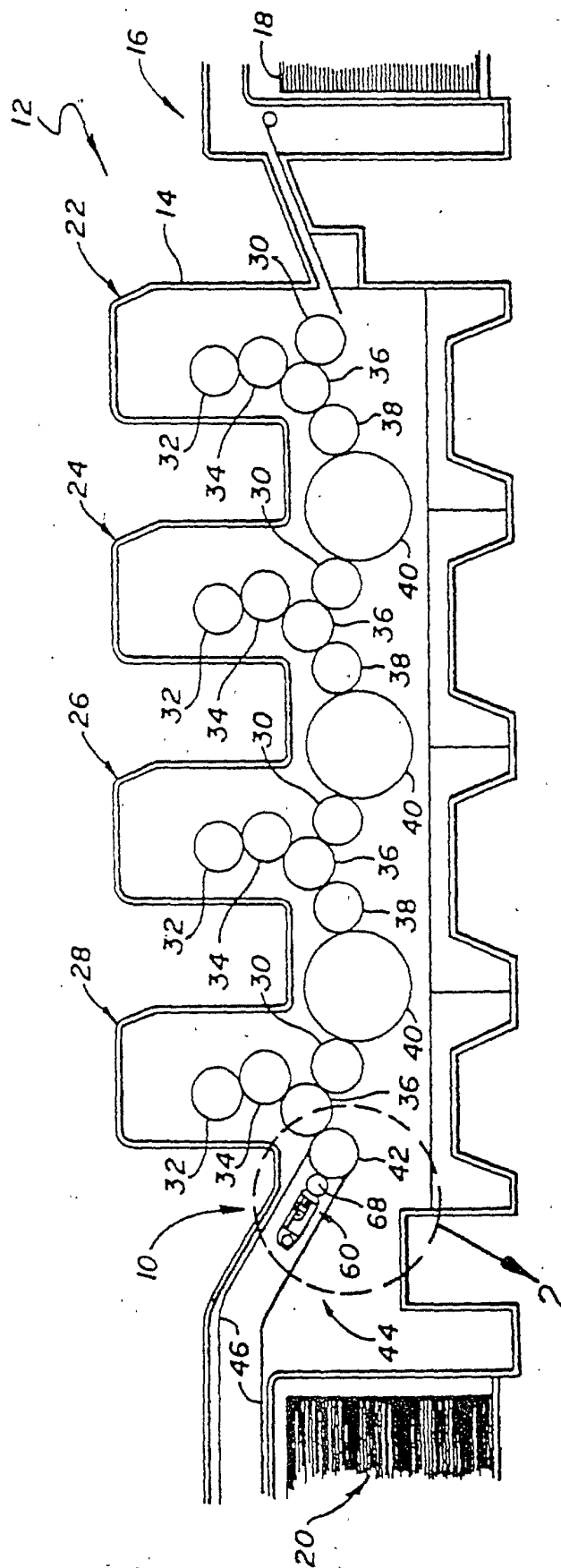


FIG. 1



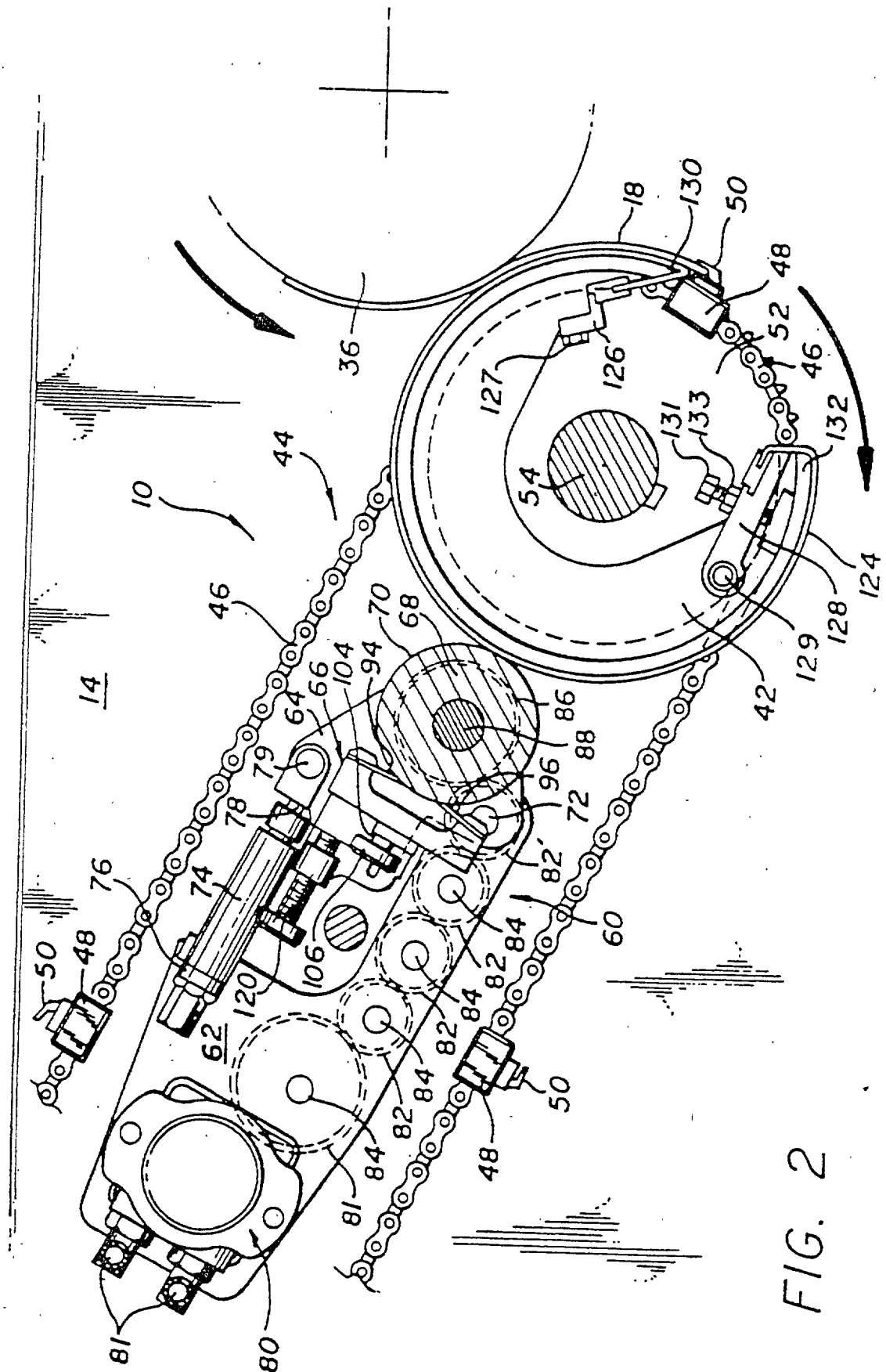


FIG. 2

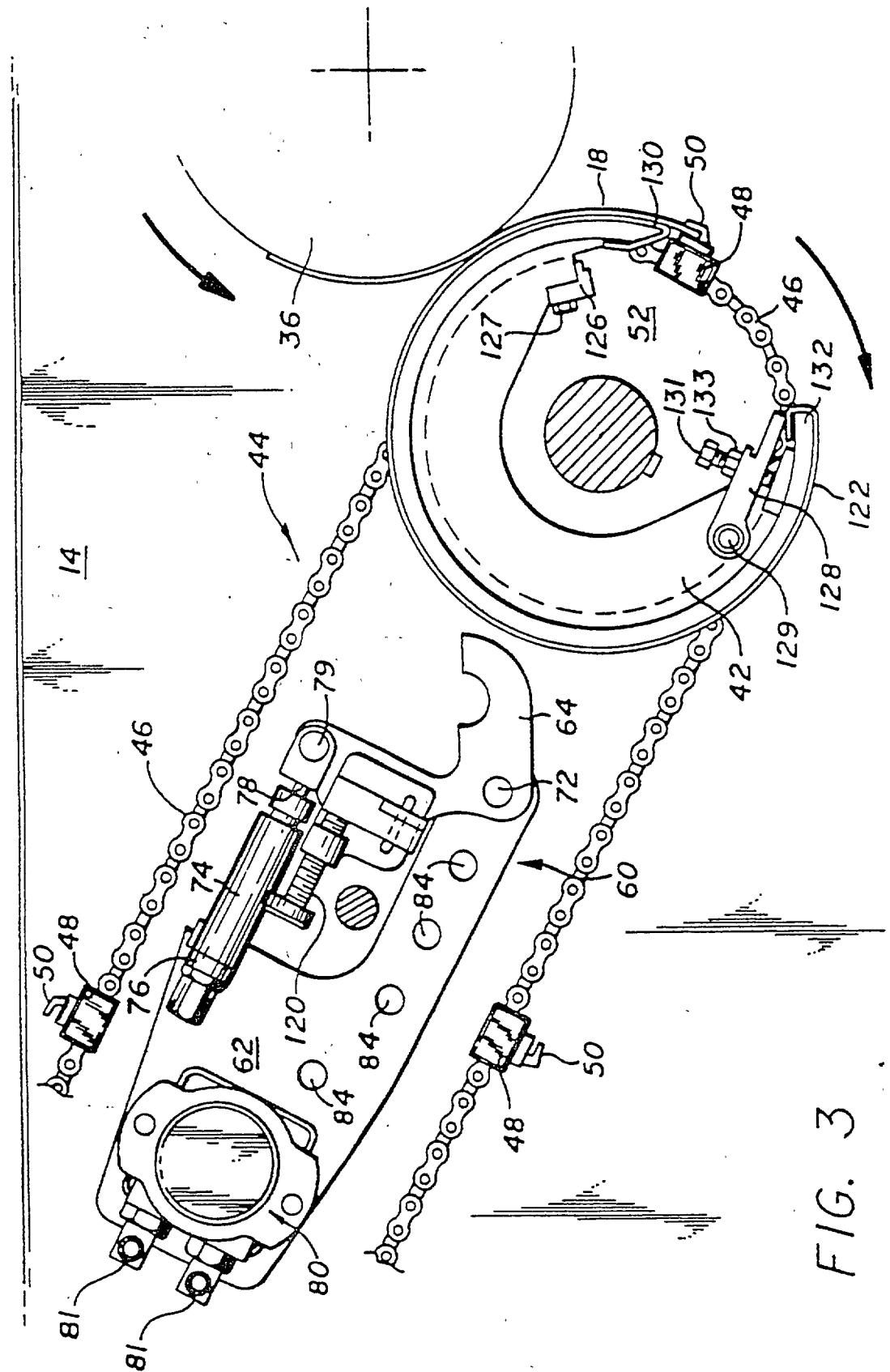
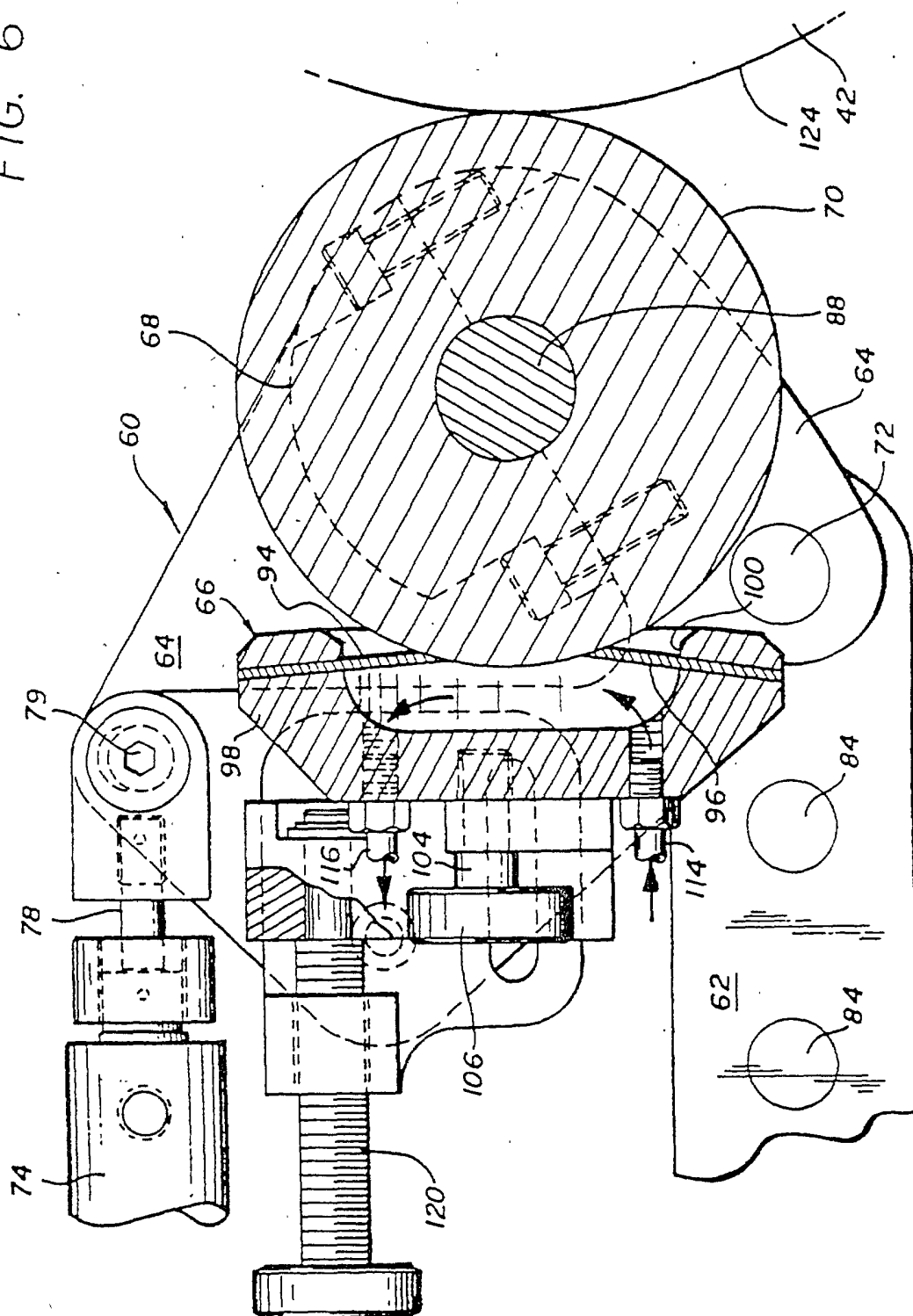


FIG. 3

FIG. 6



COATING APPARATUS FOR SHEET-FED, OFFSET ROTARY PRINTING PRESSES

BACKGROUND OF THE INVENTION

This invention relates to sheet-fed, offset rotary printing presses, and more particularly, to a new and improved apparatus for the in-line application of protective and decorative coatings to the printed surface of freshly printed sheets.

Conventional sheet-fed, offset rotary printing presses typically include one or more printing stations through which individual sheets are fed and printed with wet ink. After final printing, the sheets are fed by a delivery conveyor system to the delivery end of the press where the freshly printed sheets are collected and stacked. In a typical sheet-fed, offset rotary printing press such as the Heidelberg Speedmaster line of presses, the delivery conveyor system includes a pair of endless gripper chains carrying laterally spaced gripper bars and grippers which are used to grip and pull freshly printed sheets from the impression cylinder and convey the sheets toward the sheet delivery stacker. The gripper chains are driven in precisely timed relation to the impression cylinder by gripper chain sprocket wheels laterally spaced between a delivery drive shaft mounted on opposite sides of the press frame, the delivery drive shaft being mechanically coupled by gears for synchronous rotation with the impression cylinder.

Since the inks used with offset type printing presses typically remain wet and tacky for some time after printing, special precautions must be taken to insure that the wet inked surface of the freshly printed sheets are not marked or smeared as the sheets are transferred from one printing station to another, and through the delivery system to the sheet delivery stacker. One system for insuring that the freshly printed sheets are not marked or smeared during transfer is the transfer or delivery cylinder system marketed by Printing Research, Inc., of Dallas, Texas under its registered trademark "SUPER BLUE". That system, which is made and sold under license, is made in accordance with and operates as described in U.S. Pat. No. 4,402,267, issued Sep. 6, 1983 to Howard W. DeMoore, the disclosure of which is incorporated herein by this reference. In that system, marking and marring of freshly printed sheets is prevented by employing transfer or delivery cylinders provided with a coating of friction reducing material such as PTFE (Teflon) over which are loosely mounted fabric covers, referred to in the trade as "nets", and which support the wet ink side of the freshly printed sheets as they are pulled from the impression cylinder. Typically, in a multi-color press employing the "SUPER BLUE" cylinder system, each transfer cylinder for conveying the freshly printed sheets from one printing station to the next is supplied with a "SUPER BLUE" transfer cylinder system, and the delivery cylinder for conveying the sheets from the last printing station to the sheet delivery stacker is supplied with a "SUPER BLUE" delivery cylinder system. As used hereinafter, the term "net type cylinder" is intended to refer to cylinders having fabric nets disposed over the support surface, such as of the general type disclosed in the aforementioned DeMoore U.S. Pat. No. 4,402,267 and exemplified by the "SUPER BLUE" cylinder system.

Another system which can be used to prevent marking and smearing of the freshly printed sheets is that

disclosed in U.S. application Ser. No. 07/630,308 filed Dec. 18, 1990 entitled Vacuum Transfer Apparatus for Sheet-Fed Printing Presses now U.S. Pat. No. 5,127,329. That application, the disclosure of which is also incorporated herein by reference, discloses an apparatus which can be employed to draw the unprinted side of a freshly printed sheet into engagement with rollers which support the sheet on the unprinted side during transfer or delivery of the sheet from the impression cylinder after printing so that the wet ink on the freshly printed sheet does not come in contact with other apparatus in the press. The vacuum transfer apparatus disclosed in that application can be used as an alternative to the net type cylinder system disclosed in the aforementioned DeMoore patent, or when used in a perfecting press, as a supplement to that system, the vacuum transfer apparatus being primarily intended for use when only one-sided sheet printing is being performed by the press, and the net type cylinder system being used when the press is operating in the perfecter mode with two-sided sheet printing.

In some printing applications, it is desirable that the press be capable of applying a protective and/or decorative coating over all or a portion of the surface of the printed sheets. Such coatings typically are formed of a UV-curable or water-soluble resin applied as a liquid solution or emulsion by an applicator roller over the freshly printed sheets to protect the ink and improve the appearance of the sheets. Use of such coatings is particularly desirable when decorative or protective finishes are required such as in the production of posters, record jackets, brochures, magazines, folding cartons and the like. In cases where a coating is to be applied, the coating operation is carried out after the final ink printing has been performed, most desirably by an in-line coating application, rather than as a separate step after the printed sheets have been delivered to the sheet delivery stacker.

Various suggestions have been made for applying the coating as an in-line press operation by using the final printing station of the press as the coating application station. For example, in U.S. Pat. Nos. 4,270,483, 4,685,414, and 4,779,557 there are disclosed coating apparatus which can be moved into position to allow the blanket cylinder of the last printing station of a press to be used to apply a coating material to the sheets. In U.S. Pat. No. 4,796,556 there is disclosed a coating apparatus which can be selectively moved between the blanket cylinder or the plate cylinder of the last printing station of the press so that that station can be used as a coating station for the press. However, when coating apparatus of these types are used, the last printing station can not be used to apply ink to the sheets, but rather can only be used for the coating operation. Thus, with these types of in-line press coating apparatus, the press loses the capability of printing its full range of colors since the last printing station is converted to a coating station.

Suggestions for overcoming the problem of the loss of a printing station when coating is desired have also been made, such as that set forth in U.S. Pat. Nos. 4,934,305 which discloses a coating apparatus having a separate timed applicator roller positioned to apply the coating material to the printed sheet while the sheet is on the last impression cylinder of the press. This is said to allow the last printing station to be operated simultaneously as both an ink application station and a coating

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station so that no loss of press printing unit capability results. Another approach to providing a coating station without loosing the printing capabilities of the last printing station is to provide a totally separate coating unit down stream of the last printing station so that the coating is applied to the sheets after final printing and before the sheets have reached the sheet delivery stacker. Such an approach is suggested in U.S. Pat. Nos. 4,399,767 and 4,706,601. While each of these suggestions provide coating stations which allow the final printing station to continue to be used for printing, they each suffer from the disadvantages of requiring the provision of separately driven coating applicator rollers and apparatus which must be precisely timed in relation to the movement of the sheet to be coated so as to insure precise registration between application of the coating material and the printed sheet. The provision of separate timed applicator rollers require that the presses be modified to provide sufficient space within the presses to accommodate the added coating apparatus or to increase the length of the presses, and require additional and complex drive connections with the press drive system to achieve the required precise speed correlation between the sheets and the applicator rollers. Such modifications can be both expensive and cumbersome to install and maintain.

Thus, there exists a need for a new and improved in-line apparatus for use in a sheet-fed, offset rotary printing press to selectively apply a protective and/or decorative coating to the printed surface of freshly printed sheets which allows the final press printing station to continue to be used as a printing station, yet which does not require any substantial press modification or the addition of a separate timed applicator roller. As will be explained in more detail hereinafter, the present invention solves this need in a novel and unobvious manner.

SUMMARY OF THE INVENTION

The present invention provides a new and improved in-line apparatus for selectively applying a protective and/or decorative coating to the surface of freshly printed sheets in a sheet-fed, offset rotary printing press which is highly reliable and effective in use, yet which does not require any expensive or substantial press modification or result in any impairment of normal press operating capability. The present invention enables the press to be used to selectively apply the coating material to the freshly printed sheets as the sheets are conveyed from the impression cylinder of the last printing station of the press toward the sheet delivery stacker by utilizing a delivery cylinder mounted to the existing press delivery drive shaft to perform the dual function of a coating material applicator roller and a sheet delivery cylinder so that no modification of the press is required to enable the press to be used for either coating or non-coating operation, and without impairment of any normal press operations.

More specifically, the present invention is intended for use in a sheet-fed, offset rotary printing press of the type having at least one printing station which includes a blanket cylinder and an impression cylinder disposed for printing ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets off the impression cylinder and transporting the sheets toward the press sheet delivery stacker. For use of the present invention, the press must include a delivery drive shaft disposed adjacent to and extending par-

allel with the impression cylinder, and which is driven in timed synchronous relation with the impression cylinder.

In accordance with the invention, a delivery cylinder is mounted to the delivery drive shaft and provided with a coating blanket disposed over the peripheral outer surface of the cylinder, and adapted to engage and support the wet ink side of a freshly printed sheet. A coating apparatus including a supply of liquid coating material and a pick-up roller disposed to receive coating material from the supply, is mounted to the press and operable to permit the pick-up roller to be moved into engagement with the delivery cylinder so that coating material on the pick-up roller is transferred to the coating blanket of the delivery cylinder and then to the freshly printed sheet.

Preferably, the coating apparatus is mounted to the press downstream of the delivery drive shaft, and includes means to selectively move the pick-up roller into and out of engagement with the delivery cylinder. When the pick-up roller is not in the operable position in engagement with the delivery cylinder, the delivery cylinder can be used for conventional noncoating sheet delivery by removing the coating blanket and, preferably, replacing the coating blanket with a fabric net such as of the net type cylinder system previously described. To convert to a coating operation, the coating blanket is attached to the delivery cylinder and, depending upon the thickness of the sheets to be printed, packed with suitable packing sheets to increase the effective diameter of the cylinder so that pressure is applied to the freshly printed sheets against the impression cylinder by the coating blanket covered delivery cylinder. The pick-up roller is then moved to the operative position engaged with the delivery cylinder so that as freshly printed sheets are pulled by the delivery conveyor from the impression cylinder around the delivery cylinder, coating material applied to the delivery cylinder by the pick-up roller is transferred to the freshly printed sheets in the nip between the delivery cylinder and the impression cylinder.

Since the delivery cylinder is driven by the delivery drive shaft in precise timed relation with the impression cylinder, exact registration between the application of coating material and the printed sheet is assured. Further, since the coating of the freshly printed sheets is carried out through use of a delivery cylinder mounted to the existing press delivery drive shaft, no substantial press modifications are required, and the press can be quickly and easily converted between coating and non-coating operation with no loss of printing capability of the final printing station.

Many other features and advantages of the present invention will become more apparent from the following detailed description taken in conjunction with the accompanying drawings which disclose, by way of example, the principles of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS.

FIG. 1 is a schematic side elevational view of a sheet-fed, offset rotary printing press having a coating apparatus embodying the present invention;

FIG. 2 is an enlarged fragmentary side elevational view taken substantially within the circular area designated "2" in FIG. 1 and showing the coating apparatus of the present invention during coating operation;

FIG. 3 is a side elevational view similar to FIG. 2, but showing the coating apparatus in the inoperative position.

tion with the coating pick-up roller and reservoir removed, and the blanket covering over the delivery cylinder replaced with a fabric net for non-coating printing;

FIG. 4 is an enlarged fragmentary perspective view showing one side of the coating apparatus mounted in the press and illustrating the fluid path of coating material from a supply tank to the reservoir of the coating unit;

FIG. 5 is an enlarged fragmentary perspective view illustrating the end mounting of the coating pick-up roller to its support bracket; and

FIG. 6 is an enlarged fragmentary sectional view taken substantially along the lines 6-6 of FIG. 4.

DETAILED DESCRIPTION OF PRESENTLY PREFERRED EMBODIMENT

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line apparatus, herein generally designated 10, for selective use in applying a protective and/or decorative coating to the freshly printed surface of sheets printed in a sheet-fed, offset rotary printing press, herein generally designated 12. In this instance, as shown in FIG. 1, the coating apparatus 10 is illustrated as installed in a four color printing press 12, such as that manufactured by Heidelberg Druckmaschinen AG of the Federal Republic of Germany under its designation "Heidelberg Speedmaster 102V (40"), and which includes a press frame 14 coupled at one end, herein the right end, with a sheet feeder 16 from which sheets, herein designated 18, are individually and sequentially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the finally printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical sheet printing stations 22, 24, 26 and 28 which can print different color inks onto the sheets as they are moved through the press 10.

As illustrated, each of the printing stations 22, 24, 26 and 28 is substantially identical and of conventional design, herein including a sheet feed cylinder 30, a plate cylinder 32, a blanket cylinder 34 and an impression cylinder 36, with each of the first three printing stations 22, 24, and 26 having a transfer cylinder 38 disposed to withdraw the freshly printed sheets from the adjacent impression cylinder and transfer the freshly printed sheets to the next printing station via a transfer drum 40. The final printing station 28 herein is shown as equipped with a delivery cylinder 42 which functions to support the printed sheet 18 as it is moved from the final impression cylinder 36 by a delivery conveyor system, generally designated 44, to the sheet delivery stacker 20.

The delivery conveyor system 44 herein is of conventional design and includes a pair of endless delivery gripper chains 46, only one of which is shown in the drawings, carrying at regular spaced locations along the chains, laterally disposed gripper bars 48 having gripper elements 50 used to grip the leading edge of a sheet 18 after it leaves the nip between the delivery cylinder 42 and impression cylinder 36 of the last printing station 28. As the leading edge of the sheet 18 is gripped by the grippers 50, the delivery chains 46 pull the sheet away from the impression cylinder 36 and convey the freshly printed sheet to the sheet delivery stacker 20 where the grippers release the finally printed sheet. The endless delivery chains 46 are driven in synchronous timed relation to the impression cylinder 36 by sprocket

wheels 52 fixed adjacent the lateral ends of a delivery drive shaft 54 which has a mechanically geared coupling (not shown) through the press drive system to the impression cylinder. The delivery drive shaft 54 extends laterally between the sides of the press frame 14 adjacent the impression cylinder 36 of the last printing station 28, and is disposed to be parallel with the axis of the impression cylinder. In this instance, the delivery cylinder 42, which is constructed to allow adjustments in diameter by suitable means, is fixedly mounted to the delivery drive shaft 54 so that the delivery cylinder is also rotated in precise timed relation to the impression cylinder.

Preferably, each of the transfer cylinders 38 is equipped with an anti-marking system such as the aforementioned net type transfer cylinder system or the press 12 can be supplied in the transfer positions with vacuum transfer systems of the type disclosed in the above-identified copending U.S. application Ser. No. 07/630,308 filed Dec. 18, 1990, although as will become more apparent hereinafter, the use of such transfer systems is not required for the present invention and other types of transfer systems can be used. For reasons that will become more apparent hereinafter, for most effective use of the present invention, however, the delivery cylinder 42 should be of the type which employs the "SUPER BLUE" delivery cylinder system, or, as an alternative, should employ in the delivery position, a vacuum transfer system such as disclosed in the above-identified copending U.S. application Ser. No. 07/630,308.

In this respect, it is important to note that when the freshly printed sheets 18 are conveyed away from the impression cylinder 36 of the final printing station 28 by the gripper 50 carried by the delivery chains 46, the wet inked surfaces of the sheets face the delivery drive shaft 54 and the sheets must be supported such that the ink is not marked or smeared as the sheets are transferred. Typically, such support is provided by skeleton wheels or cylinders mounted to the press delivery drive shaft 54, or as is now more commonly used, net type delivery cylinders such as of the "SUPER BLUE" delivery cylinder system type disclosed in the aforementioned DeMoore patent. More recently, vacuum transfer apparatus of the type disclosed in the aforementioned copending U.S. application Ser. No. 07/630,308 have been used in place of delivery cylinders or skeleton wheels to pull the unprinted side of the sheet away from the delivery drive shaft 54 so that the wet ink surface of the sheets do not come into contact with any press apparatus. It has been found, however, that when a protective or decorative coating material is applied to the wet ink surface of the sheets, the coating protects the wet ink against marking and smearing such that the coating applicator roller itself can be used to support the wet inked surface of the sheets without fear of damage to the freshly printed surface.

In accordance with the present invention, the in-line coating apparatus 10 for selectively applying the protective or decorative coating to the sheets 18 enables the press 12 to be operated in the normal manner without the loss of the final printing station 28, and without requiring any substantial press modifications by employing the existing press delivery drive shaft 54 as the mounting location for the coating applicator roller. In presses 12 utilizing a net type delivery cylinder system, that system can be quickly and easily converted to perform the dual function of being a coating applicator roller and a delivery cylinder. In presses having other

types of delivery systems such as skeleton wheels mounted on the delivery drive shaft 54 or a vacuum transfer apparatus as disclosed in the aforementioned copending U.S. application Ser. No. 07/630,308, conversion to a coating operation can be quickly and easily achieved by mounting on the press delivery drive shaft in place of the skeleton wheels or in addition to the vacuum transfer apparatus, a suitable support cylinder capable of performing the combined function of a coating applicator roller and a delivery cylinder 42. Typically, such a support cylinder will have a diameter which provides no more than about a 0.090 inch clearance between the cylinder support surface and the adjacent impression cylinder 36. By utilizing the delivery cylinder 42 mounted on the delivery drive shaft 54 to also act as a coating applicator roller, the present invention insures that the coating will be applied to the printed sheet 18 in precise timed registration, and will permit the press to be operated with its full range of printing stations, yet allow fast, simple and convenient change-over from coating to noncoating operations, and vice versa, with a minimum of press down time.

Toward these ends, the coating apparatus 10 of the present invention includes a relatively simple, positive acting and economical coating unit, generally designated 60, mounted to the press frame 14 down stream of the delivery drive shaft 54 and positioned to selectively supply coating material to the support surface of a delivery cylinder 42 mounted on the delivery drive shaft. As best can be seen in FIGS. 2, 4 and 6, the coating unit 60 herein comprises a pair of side frames 62, only one of which is shown, it being understood that the other side frame is substantially the same as that of the side frame illustrated, attached to each side of the press frame 14. Pivotally mounted to one end of each of the side frames 62 is a support bracket 64 carrying one end of a coating material reservoir 66 and cooperating coating material pick-up roller 68 each disposed to extend laterally across the press 12 parallel with the delivery drive shaft 54. The coating unit 60 is mounted between the upper and lower runs of the delivery chains 46 down stream of the delivery drive shaft 54, and positioned so that the outer peripheral surface 70 of the pick-up roller 68 can be frictionally engaged with the support surface of a delivery cylinder 42 mounted on the delivery drive shaft.

As best seen in FIGS. 2 through 4, the support bracket 64 is pivotally attached to the end of the side frame 62 by a shaft 72 disposed at the lower end portion of the bracket, and can be pivoted about the shaft by an extensible cylinder 74, herein shown as a hydraulic cylinder, one end 76 of which is secured such as by welding to the side frame, and the opposite end 78 of which is coupled through a pivot shaft 79 to the upper end portion of the bracket. By extending or retracting the cylinder 74, the extent of frictional engagement of the pick-up roller 68 with the surface of the delivery cylinder 42 can be controlled, and the pick-up roller can be completely disengaged from the delivery cylinder.

The coating pick-up roller 68, which can be of conventional design and preferably one such as the Anilox rollers manufactured by A.R.C. International of Charlotte, N.C., and sold under the name "PRINTMASTER" having an engraved ceramic or chrome outer peripheral surface 70, is designed to pick up a predetermined uniform thickness of coating material from the reservoir 66, and then uniformly transfer the coating to the support surface of the delivery cylinder 42. To ef-

fect rotation of the pick-up roller 68, a suitable motor 80, herein a hydraulic motor, is attached to one of the side frames 62 and coupled to a suitable hydraulic fluid source (not shown) through fittings 81. Attached to the output of the motor 80 is an output gear which is drivingly coupled through a reduction gear 81 and a series of idler gears 82 each mounted on stub axles 84, to a drive gear 86 attached to the end of a shaft 88 on which the pick-up roller 68 is concentrically mounted. The shaft 88 of the pick-up roller 68 is, in turn, journaled at each end to the brackets 64 through a releasable semi-circular collar 90 (see FIG. 5) attached by bolts 92 to the bracket. Herein, the axle of the terminal idler gear, designated 82', also serves as the shaft 72 for pivotally mounting the support bracket 64 to the side frame 62 so that when the bracket is rotated about the shaft, the terminal idler gear remains engaged with the drive gear 86 of the pick-up roller 68.

In this instance, as best as can be seen in FIG. 6, the pick-up roller 68 has a portion which projects laterally into the reservoir 66 containing the supply of coating material, and a pair of upper and lower inclined doctor blades 94 and 96 attached to the reservoir engage the roller surface to meter the coating material picked up from the reservoir by the etched surface 70 of the roller. The reservoir 66 herein is formed by an elongated, generally rectangular housing 98 having a generally C-shaped cross-section with a laterally extending opening 100 along one side facing the pick-up roller 68, and is supplied with coating material from a supply tank 102 disposed in a remote location within or near the press 12. Preferably, the reservoir 66 is removably attached to the brackets 64, herein by bolts 104 having enlarged, knurled heads 106, and which can be threaded through slots 108 formed in the brackets to clamp the reservoir in place on the brackets.

To insure that an adequate supply of coating material is always present within the reservoir 66 and to prevent coagulation and clogging of the doctor blades 94 and 96 by the aqueous coating material, the coating material is circulated through the reservoir, herein by two substantially identical pumps 110 and 112, one of which pumps coating material from the supply tank 102 via a supply line 114 to the bottom of the reservoir, and the other of which acts to provide suction to a pair of return lines 116 coupled adjacent the top of the reservoir for withdrawing unused coating material from the reservoir. By circulating the coating material from the supply tank 102 at a greater rate than the rate of withdrawal of material by the pick-up roller 68, a substantially constant supply of coating material will always be present within the reservoir 66.

In this instance, the general arrangement of the pick-up roller 68, doctor blades 94 and 96, and reservoir 66 is substantially like that disclosed in U.S. Pat. No. 4,821,672 entitled DOCTOR BLADE ASSEMBLY WITH ROTARY END SEALS AND INTERCHANGEABLE HEADS", the disclosure of which can be reviewed for details concerning the structure and operation of a pick-up roller and reservoir usable with the present invention.

Once the coating unit 60 has been installed in a press 12, which basically only requires that the side frames 62 be attached, such as with bolts, to the sides of the press frame 14, and the hydraulic motor 80 be coupled with a suitable hydraulic source, the press can be quickly and easily converted to the coating mode. In presses 12 already supplied with a net type delivery cylinder sys-

tem, to convert to a coating operation, all that is necessary is that the fabric net material (designated 122 in FIG. 3) normally used over the support surface of the net type delivery cylinder during noncoating press operations, be removed and replaced with a coating blanket 124 capable of transferring coating material deposited thereon onto the printed sheets. Typically, such a blanket 124 can be formed as a rubber covering such as used for the covering surface of the conventional blanket cylinders 34 of the press 12. In presses 12 having conventional skeleton wheels or a vacuum transfer type apparatus such as that of the aforementioned copending U.S. application Ser. No. 07/630,308, a suitable delivery cylinder 42 can be fixed to the delivery drive shaft 54 and a similar coating blanket 124 applied thereto over the cylinder surface.

It is important to note that during nonprinting operations, the net type delivery cylinder 42 does not engage the surface of the impression cylinder 36 during sheet delivery. However, when used as a coating applicator roller during coating operations, the effective diameter of the delivery cylinder 42 must be increased so that the coating blanket 124 presses the sheet 18 against the surface of the impression cylinder 36, as shown in FIG. 2. To increase the effective diameter of the delivery cylinder 42, the thickness of the coating blanket 124 applied over the support surface of the delivery cylinder 42 can be selected to correspond with the thickness of the sheets 18 to be printed, or suitable packing sheets, such as paper sheets (not shown) of the type conventionally used in conjunction with press blanket cylinders 34, can be interposed between the delivery cylinder and the coating blanket.

While any suitable means can be used to attach the coating blanket 124 to the support surface of the delivery cylinder 42, in this instance, as shown in FIGS. 2 and 3, the delivery cylinder is supplied with clamps 126 attached by bolts 127 to the cylinder adjacent the leading edge 130 to secure the leading edge of the coating blanket 124 to the cylinder, and adjustable tensioning clamps 128 are provided adjacent the cylinder trailing edge 132 for securing the trailing edge of the blanket to the cylinder. However, the tensioning clamps 128 are pivotally mounted at one end by a pin 129 to the cylinder 42, and the blanket tension is adjusted through a bolt 131 and nut 133 arrangement. Depending upon the thickness of the sheets 18 to be printed and coated by the press 12, one or more layers of packing paper or the like may be interposed between the support surface of the delivery cylinder 42 and the coating blanket 124 to increase the effective diameter of the cylinder. Provision of the tensioning clamps 128 for attaching the coating blanket 124 to the leading edge 132 of the delivery cylinder 42 allows for such control and adjustment.

Once installed, the coating unit 60 can remain in position even though the press 12 is operated in the non-coating mode. In this respect, when the coating unit 60 is not in operation, the extensible cylinder 74 can be actuated to pivot the support brackets 64 carrying the pick-up roller 68 and reservoir 66 about the shaft 72 and away from the delivery cylinder 42, thus rendering the coating unit inoperative. This then also frees the pick-up roller 68 and reservoir 66 for fast and easy removal from the coating unit 60 for cleaning, service or replacement. To remove the pick-up roller 68, the coating material is drained from the reservoir 66, and the pressure exerted by the doctor blades 94 and 96 against the roller is released, therein through operation

of a pressure adjustment screw 120 attached to the reservoir, and the bolts 92 and collars 90 are removed, thereby permitting the pick-up roller to be lifted from the coating unit 60. To remove the reservoir 66, all that need be done is to release the mounting bolts 104 securing the reservoir to the brackets 64. With the coating unit 60 moved by the extensible cylinder 74 to the inoperative position, the delivery cylinder 42 can be converted for normal delivery cylinder operation simply by removing the coating blanket 124 from the delivery cylinder 42 and replacing the blanket with a fabric net 122. Alternatively, if a vacuum transfer apparatus such as described in the aforementioned copending U.S. application Ser. No. 07/630,308 is installed in the press 12, that apparatus can be activated to deliver sheets from the impression cylinder 36 without effecting any delivery cylinder change since the freshly printed side of the sheets will not come into contact with the delivery cylinder.

In a typical noncoating operation of the press 12 with the coating apparatus 10 installed, the coating unit 60 will be in the inoperative position. In that situation and with a net type delivery cylinder 42 installed, the delivery cylinder will be covered with the fabric net 122 so that the delivery cylinder operates in the normal manner with the wet ink side of the freshly printed sheets 18 being supported by the net covered surface of the delivery cylinder. Should the press 12 include a vacuum transfer apparatus such as disclosed in the aforementioned copending U.S. application Ser. No. 07/630,308, the delivery cylinder 42 can remain on the delivery drive shaft 54, with or without a fabric net 122, depending upon whether or not the press is used for perfect printing.

When it is desired to convert to the coating mode of operation, the press 12 is stopped just long enough to replace the fabric net 122 on the delivery cylinder 42 with the coating blanket 124 packed to the required extent necessary for providing the proper pressure to effect coating of the sheet thickness to be printed. Thereafter, the pumps 110 and 112 are activated and the press 12 re-started. The extensible cylinder 74 can then be activated to control the pressure of the pick-up roller 68 against the delivery cylinder 42 to obtain the desired application of coating material to the freshly printed sheets 18.

Notably, with the coating apparatus 10 of the present invention, no timing adjustments between the delivery cylinder 42 and the impression cylinder 36 are required to achieve and maintain precise registration between application of the coating material and the printed surface of the sheets 18. Further, the coating unit 60 permits a wide range of coating weights to be applied to the printed sheets 18 by quickly and easily changing pick-up rollers 68 from those designed to produce a very light coating application to those designed to produce a very thick coating application can be used.

From the foregoing, it should be apparent that the coating apparatus 10 of the present invention provides a highly reliable, effective and economical in-line apparatus for selectively applying coating material to the freshly printed sheets 18 in a sheet-fed, offset rotary printing press 12 which allows the final printing station to continue to be used as a print station, yet which does not require any substantial press modification or the addition of a separate timed applicator roller. While a particular form of the present invention has been illustrated and described, it should be apparent that varia-

tions and modifications therein can be made without departing from the spirit and scope of the invention.

We claim:

1. In a sheet-fed, offset rotary printing press of the type including at least one printing station having a blanket cylinder and an impression cylinder disposed for printing ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery conveyor system including a delivery drive shaft disposed adjacent to and extending parallel with the impression cylinder and driven in timed synchronous relation with the impression cylinder, the improvement comprising:
 - a delivery cylinder mounted to said delivery drive shaft and having an outer peripheral support surface adapted to engage and support a sheet being transported by said delivery conveyor system;
 - a coating apparatus including a supply of liquid coating material, a rotatable pick-up roller having an outer peripheral surface of substantially cylindrical shape, and means for applying a coating of liquid coating material from said supply onto said outer peripheral surface of said pick-up roller; and
 - means for mounting said coating apparatus to the press adjacent said delivery cylinder including selectively operable means for moving said pick-up roller between a first operable position with a portion of said peripheral surface of said pick-up roller engaged with said support surface of said delivery cylinder, and a second inoperable position with said peripheral surface out of engagement with said support surface of said delivery cylinder, whereby when said pick-up roller is in said first operable position, liquid coating material from said supply applied onto said peripheral surface of said pick-up roller is transferred to said support surface of said delivery cylinder and to said freshly printed sheet.
2. The improvement as set forth in claim 1 wherein said delivery cylinder includes a coating blanket disposed over said peripheral support surface.
3. The improvement as set forth in claim 1 wherein said delivery cylinder includes a removable coating blanket disposed over said peripheral support surface when said pick-up roller is in said first operable position.
4. The improvement as set forth in claim 3 wherein said coating blanket has a rubber outer surface.
5. The improvement as set forth in claim 3 wherein said delivery cylinder includes a fabric net disposed over said peripheral support surface when said pick-up roller is in said second inoperable position.
6. The improvement as set forth in claim 1 wherein said coating apparatus includes an elongated reservoir containing said supply of liquid coating material, said reservoir being disposed to extend parallel with said pick-up roller with a portion of said peripheral surface extending into said reservoir in contact with liquid coating material contained therein, and at least one doctor blade attached to said reservoir and engaging said peripheral surface, said doctor blade acting to limit the amount of liquid coating material applied onto said peripheral surface from said reservoir.
7. The improvement as set forth in claim 6 wherein said reservoir and said pick-up roller are movably coupled to said press and said selectively operable means includes an extensible cylinder coupled between said reservoir and said press and operable to move said res-

ervoir and said pick-up roller between said first and second positions.

8. The improvement as set forth in claim 7 wherein said pick-up roller is rotatably driven by a motor attached to said coating apparatus.

9. The improvement as set forth in claim 8 wherein said delivery cylinder includes a rubber coating blanket disposed over said peripheral support surface when said pick-up roller is in said first operable position, and includes a fabric net disposed over said peripheral support surface when said pick-up roller is in said second inoperable position.

10. The improvement as set forth in claim 9 wherein said coating apparatus is mounted to said press downstream of said delivery drive shaft in the direction of travel of said sheets during transport by said delivery conveyor system.

11. The improvement as set forth in claim 1 wherein said mounting means includes first and second side frames mounted on said press, a support shaft mounted on and extending between said first and second side frames, a support bracket attached to said coating apparatus and movably coupled to said support shaft for pivotal movement between said first and second positions, and said selectively operable means includes an extensible cylinder coupled between said coating apparatus and said support bracket and operable to move said coating apparatus toward and away from said delivery cylinder.

12. In a sheet-fed, offset rotary printing press of the type including at least one printing station having a blanket cylinder and an impression cylinder disposed for printing wet ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery conveyor system comprising a pair of endless gripper chains disposed on opposite sides of the press and supporting therebetween gripper bars and grippers spaced along the chains, the gripper chains being driven in timed synchronous relation with the impression cylinder by laterally spaced sprocket wheels mounted on opposite ends of a delivery drive shaft disposed adjacent to and extending parallel with the impression cylinder, the improvement comprising:

- a delivery cylinder mounted to said delivery drive shaft between said sprocket wheels and having an outer peripheral support surface covered by a removable coating blanket adapted to engage and support the wet ink side of a sheet being transported by said gripper bars;
- a coating apparatus including a supply of liquid coating material, a rotatable pick-up roller having an outer peripheral surface of substantially cylindrical shape communicating with said supply, and means for applying liquid coating material from said supply onto said peripheral surface of said pick-up roller; and
- means for mounting said coating apparatus to the press adjacent the delivery cylinder, said means including selectively operable means for moving said coating apparatus between a first operable position with a portion of said peripheral surface of said pick-up roller engaged with said delivery cylinder, and a second inoperable position with said peripheral surface of said pick-up roller out of engagement with said delivery cylinder, whereby when said coating apparatus is in said first operable

position, liquid coating material from said supply metered onto said peripheral surface of said pick-up roller is transferred to said delivery cylinder and to said freshly printed sheet, and when said coating apparatus is in said second inoperable position, said delivery cylinder is disposed for non-coating sheet delivery operation.

13. The improvement as set forth in claim 12 wherein the effective diameter of said delivery cylinder covered by said coating blanket is sufficient to apply pressure to sheets against said impression cylinder as said sheets are pulled from said impression cylinder by said gripper bars.

14. The improvement as set forth in claim 13 wherein said coating blanket has a rubber outer support surface.

15. The improvement as set forth in claim 14 wherein said coating apparatus is disposed downstream of said delivery drive shaft in the direction of travel of said sheets during transport by said delivery conveyor system.

16. A sheet-fed, offset rotary printing press including: at least one printing station having a blanket cylinder and an impression cylinder disposed for printing wet ink onto sheets passing therebetween;

a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery system including a delivery drive shaft;

a delivery cylinder mounted to said delivery drive shaft and having an outer peripheral support surface adapted to engage and support a sheet being transported by said delivery conveyor system;

a coating apparatus including a supply of liquid coating material, a rotatable pick-up roller having an outer peripheral surface of substantially cylindrical shape communicating with said supply, and means for applying liquid coating material from said supply onto said peripheral surface of said pick-up roller; and

means for mounting said coating apparatus to the press adjacent said delivery cylinder, said means including selectively operable means for moving said pick-up roller between a first operable position

with a portion of said peripheral surface of said pick-up roller engaged with said delivery cylinder, and a second inoperable position with said peripheral surface of said pick-up roller out of engagement with said delivery cylinder, whereby when said pick-up roller is in said first operable position, liquid coating material from said supply applied to said peripheral surface of said pick-up roller is transferred to said delivery cylinder and then to said freshly printed sheet.

17. A sheet-fed, offset rotary printing press as set forth in claim 16 wherein said delivery cylinder includes a removable coating blanket disposed over said peripheral support surface when said pick-up roller is in said first operable position.

18. A sheet-fed, offset rotary printing press as set forth in claim 17 wherein said coating blanket has a rubber outer surface.

19. A sheet-fed, offset rotary printing press as set forth in claim 17 wherein said delivery cylinder includes a fabric net disposed over said peripheral support surface when said pick-up roller is in said second inoperable position.

20. A sheet-fed, offset rotary printing press as set forth in claim 19 wherein said coating apparatus includes an elongated reservoir containing said supply of liquid coating material, said reservoir being disposed to extend parallel with said pick-up roller with a portion of said peripheral surface extending into said reservoir in contact with liquid coating material contained therein, and at least one doctor blade attached to said reservoir and engaging said peripheral surface, said doctor blade acting to limit the amount of liquid coating material applied onto said peripheral surface from said reservoir.

21. A sheet-fed, offset rotary printing press as set forth in claim 20 wherein said selectively operable means includes an extensible cylinder coupled between said reservoir and said press and operable to move said reservoir and said pick-up roller laterally between said first and second positions.

22. A sheet-fed, offset rotary printing press as set forth in claim 21 wherein said pick-up roller is rotatably driven by a motor attached to said coating apparatus.

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DeMoore et al.

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- [54] COATING APPARATUS FOR SHEET-FED, OFFSET ROTARY PRINTING PRESSES
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- [73] Assignee: Howard W. DeMoore, Plano, Tex.
- [21] Appl. No.: 879,841
- [22] Filed: May 6, 1992

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Primary Examiner—Eugene H. Eickholt
 Attorney, Agent, or Firm—Dennis T. Griggs

[57] ABSTRACT

A coating apparatus for use in a sheet-fed or web-fed, offset rotary or flexographic printing press to apply a protective and/or decorative coating to the surface or freshly printed sheets includes a doctor blade coating unit coupled to a pickup roller for supplying liquid material from a reservoir to the surface of a pickup roller mounted on a press delivery drive shaft. Liquid material is circulated through the reservoir of the doctor blade unit by suction flow produced by a return pump. This prevents the buildup of a positive pressure differential within the doctor blade reservoir. The doctor blade reservoir is maintained at below ambient pressure level, thereby preventing leakage through the end seals. A vacuum sensor circuit provides a visual indication of air vacuum pressure in the doctor blade reservoir chamber, and a vacuum sensor switch applies electrical power to an audio transducer. The audio transducer produces an audible alarm in response to an increase in doctor blade chamber pressure, thereby providing advance warning of an impending end seal failure or a worn doctor blade condition.

Related U.S. Application Data

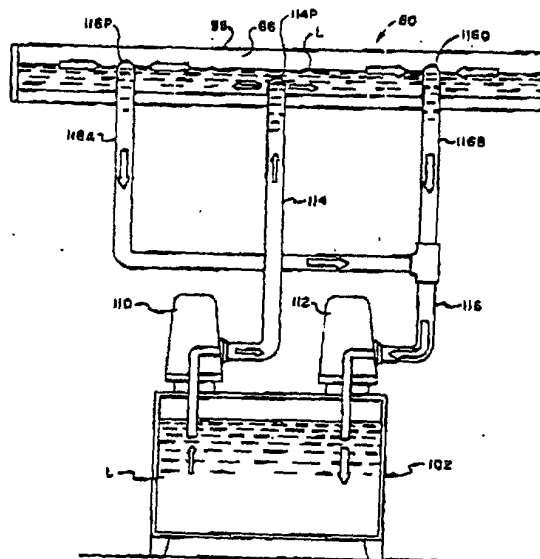
- [63] Continuation-in-part of Ser. No. 752,778, Aug. 30, 1991.
- [51] Int. Cl.⁵ B41F 31/00
- [52] U.S. Cl. 101/350; 101/351; 101/367; 101/147; 118/261; 118/262
- [58] Field of Search 101/135, 147, 148, 157, 101/167, 169, 207, 208, 210, 329, 330, 331, 348, 349, 350, 351, 364, 365, 366, 367; 118/602, 612, 236, 242, 259, 261

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21 Claims, 9 Drawing Sheets



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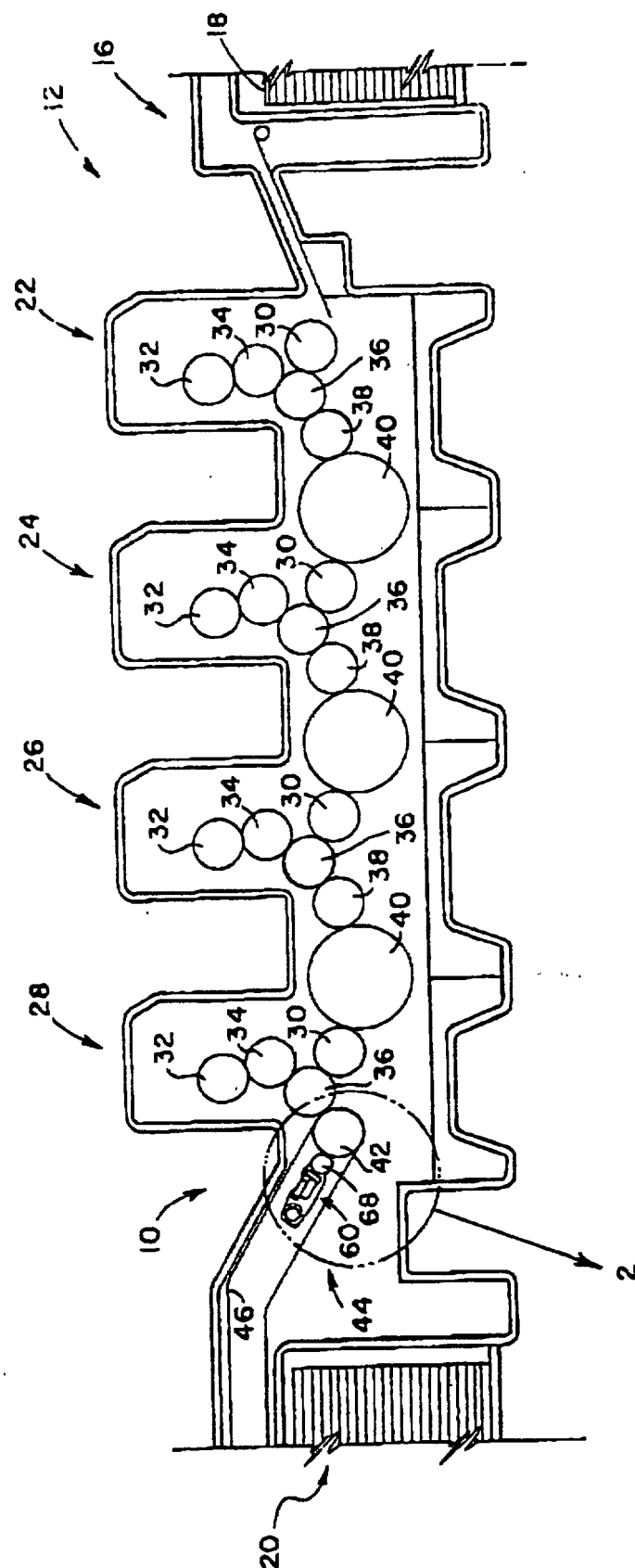


FIG. 1

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FIG. 2

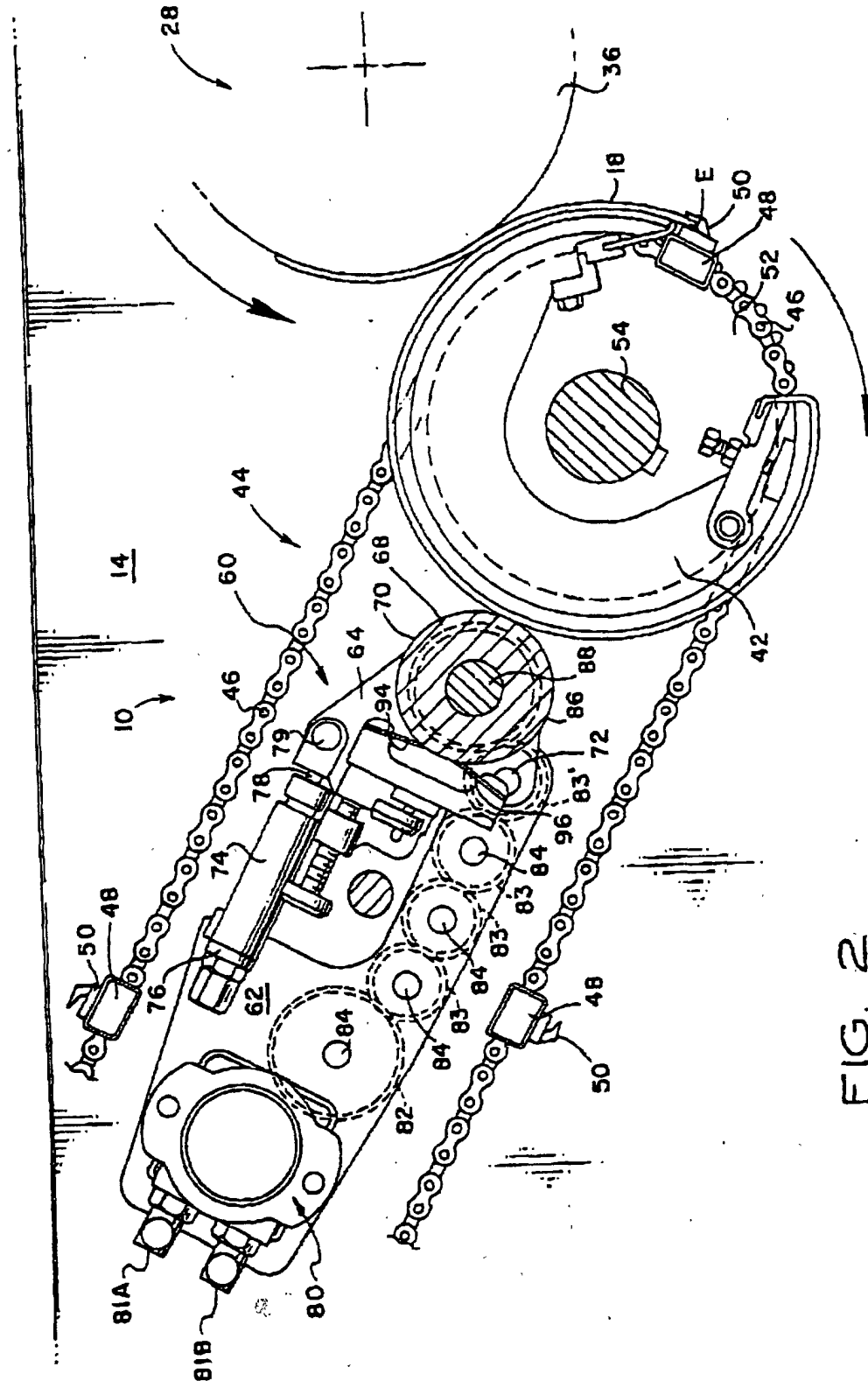


FIG. 2

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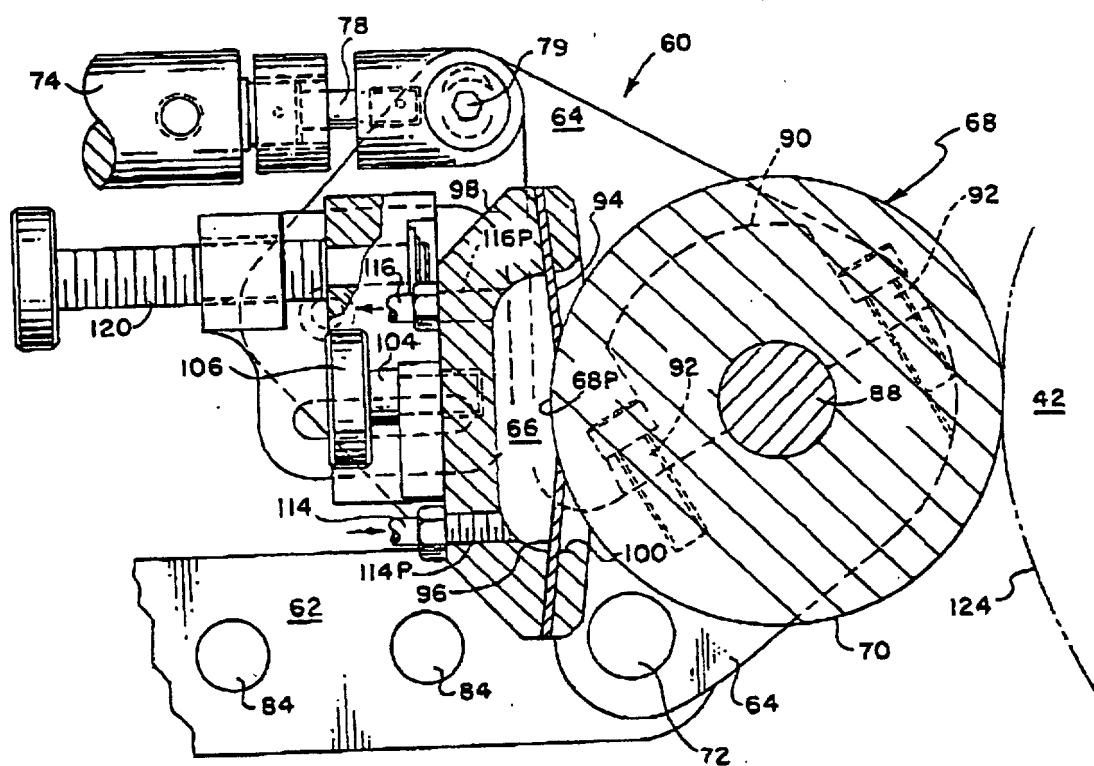


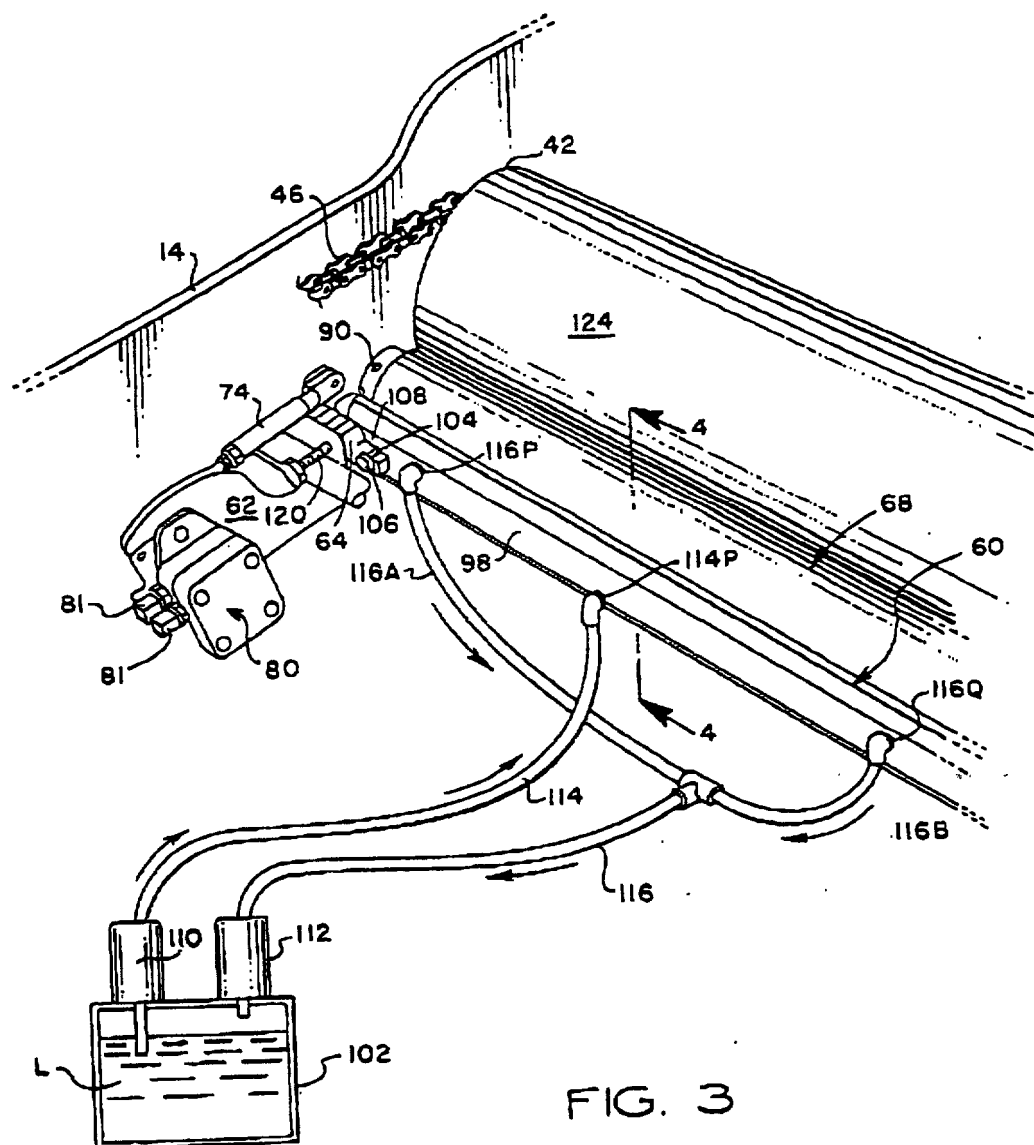
FIG. 4

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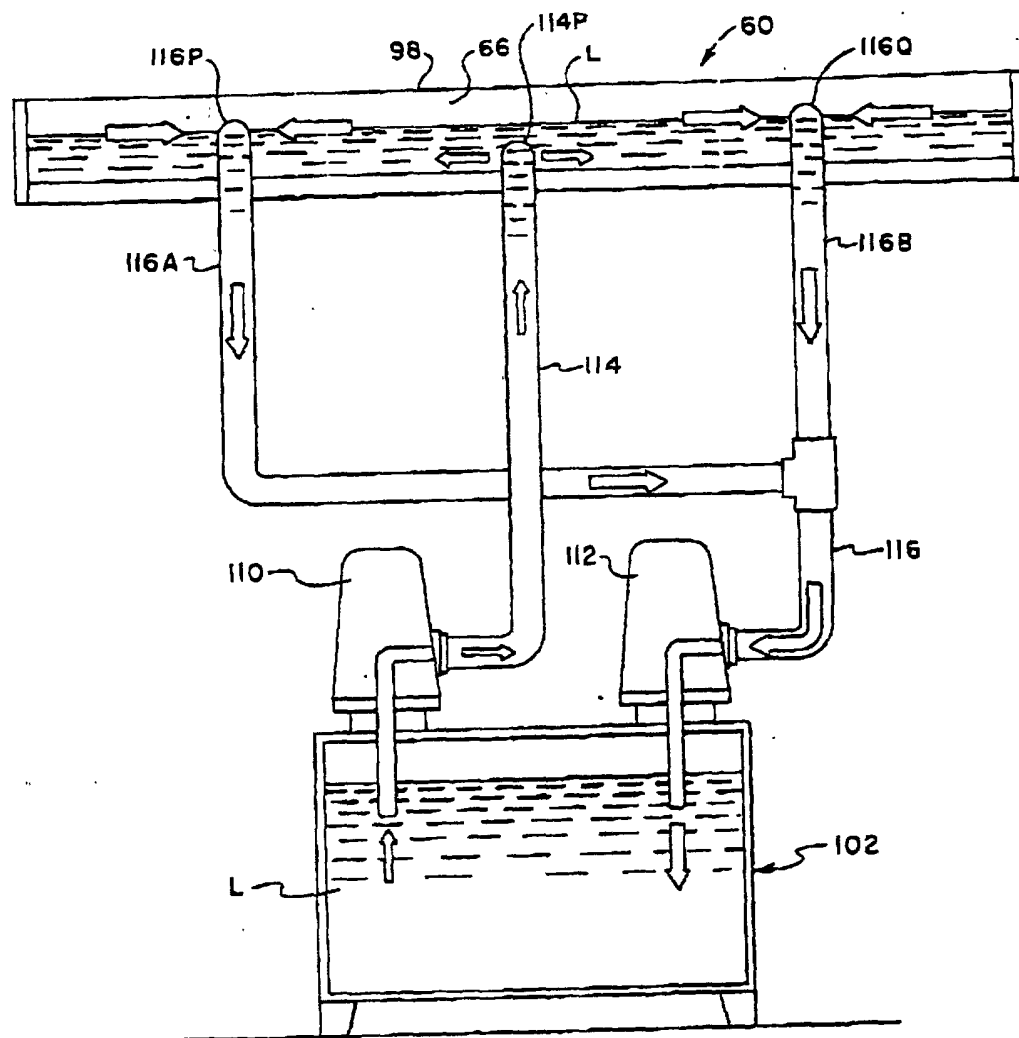


FIG. 5

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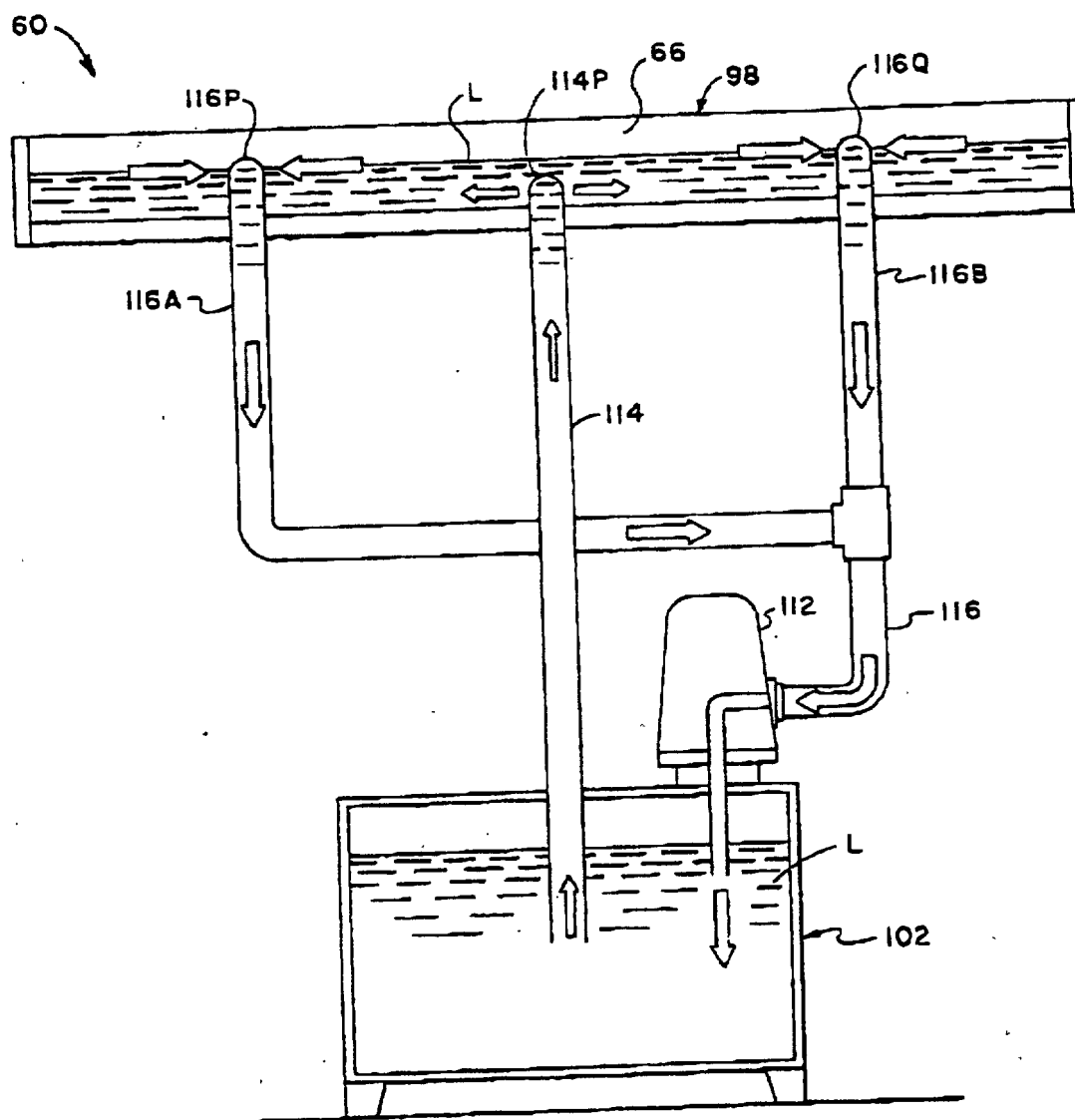


FIG. 6

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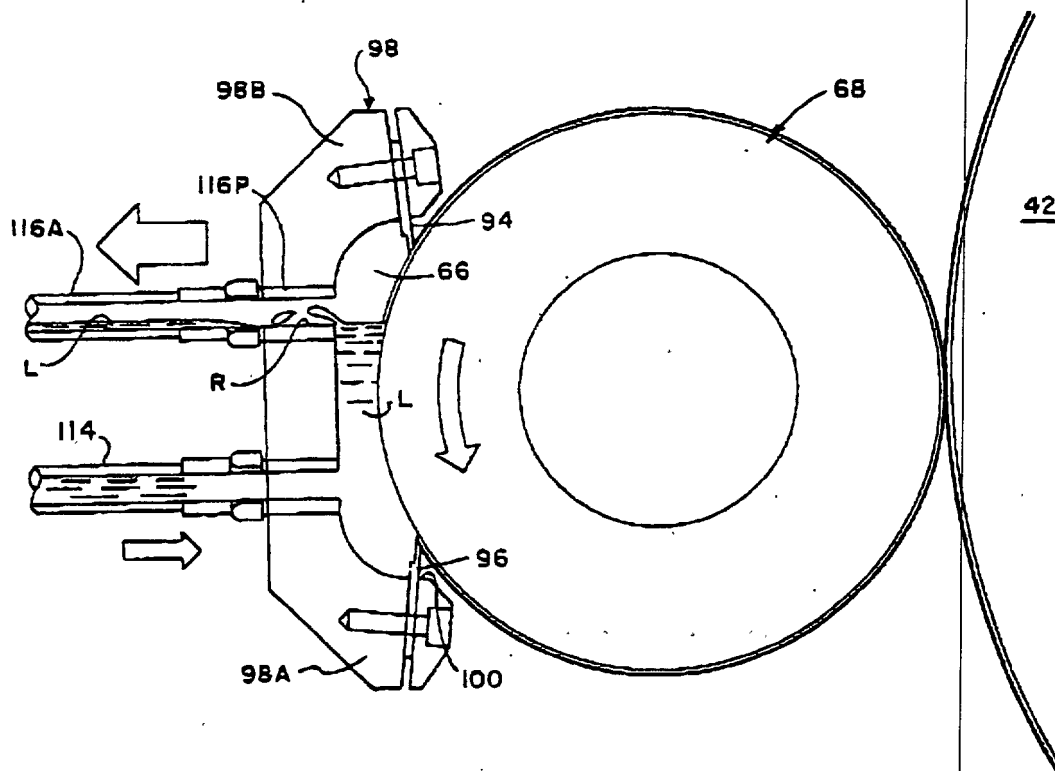


FIG. 8

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FIG. 9

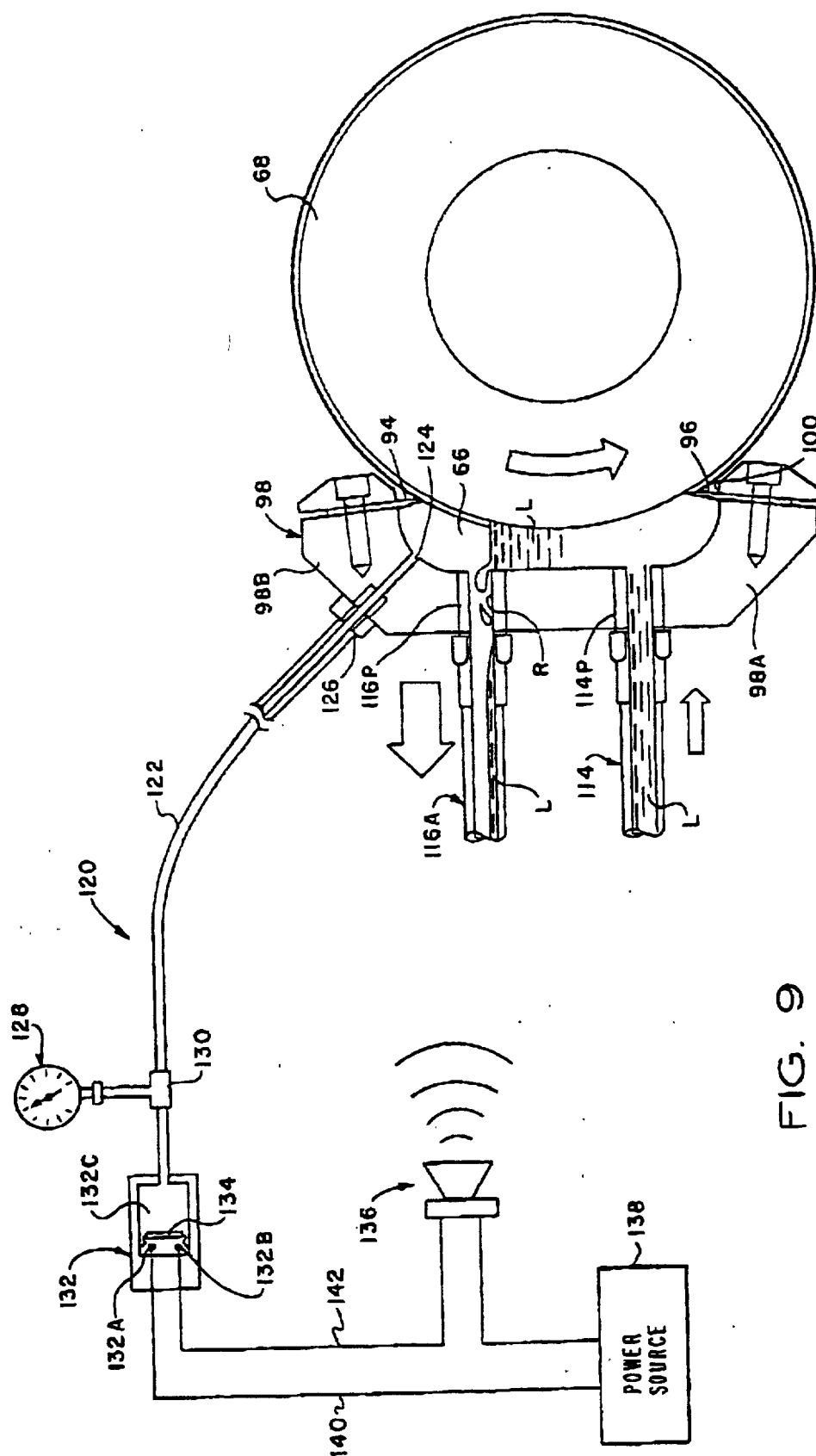


FIG. 9

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COATING APPARATUS FOR SHEET-FED, OFFSET ROTARY PRINTING PRESSES

CROSS REFERENCE TO RELATED APPLICATION

This application is a continuation-in-part of application Ser. No. 07/752,778 filed Aug. 30, 1991.

FIELD OF THE INVENTION

This invention relates to sheet-fed or web-fed, offset rotary or flexographic printing presses, and more particularly, to a new and improved apparatus for the in-line application of protective and decorative coatings or inks to the printed surface of freshly printed sheets or web.

BACKGROUND OF THE INVENTION

Conventional sheet-fed, offset rotary printing presses typically include one or more printing stations through which individual sheets are fed and printed with wet ink. After final printing, the sheets are fed by a delivery conveyor system to the delivery end of the press where the freshly printed sheets are collected and stacked. In a typical sheet-fed, offset rotary printing press such as the Heidelberg Speedmaster line of presses, the delivery conveyor system includes a pair of endless gripper chains carrying spaced laterally disposed gripper bars and grippers which are used to grip and pull freshly printed sheets from the impression cylinder and convey the sheets toward the sheet delivery stacker. The gripper chains are driven in precisely timed relation to the impression cylinder by gripper chain sprocket wheels which are laterally spaced between a delivery drive shaft mounted on opposite sides of the press frame. The delivery drive shaft is mechanically coupled by gears for synchronous rotation with the impression cylinder.

Since the inks used with offset type printing presses typically remain wet and tacky for some time after printing, special precautions must be taken to insure that the wet inked surface of the freshly printed sheets is not marked or smeared as the sheets are transferred from one printing station to another, and through the delivery system to the sheet delivery stacker. The printed surface of the paper dries relatively slowly and can be smeared during subsequent processing, particularly when the printed sheets are stacked. In order to minimize smearing, a dryer may be mounted along the delivery path of the printed sheets, or an anti-offset spray powder may be sprayed on the printed surface.

In some printing applications, it is desirable that the press be capable of applying a protective and/or decorative coating over all or a portion of the surface of the printed sheets. Typical coating solutions include varnish, lacquer, dye, moisturizers and ink. Such coatings typically are formed of a UV-curable or water-soluble resin applied as a liquid solution or emulsion by an applicator roller over the freshly printed sheets to protect the ink and improve the appearance of the sheets. Use of such coatings is particularly desirable when decorative or protective finishes are required such as in the production of posters, record jackets, brochures, magazines, folding cartons and the like. In cases where a liquid coating is to be applied, the coating operation is carried out after the final ink printing has been performed, most desirably by an in-line coating application.

DESCRIPTION OF THE PRIOR ART

Various suggestions have been made for applying the coating as an in-line press operation by using the final printing station of the press as the coating application station. For example, in U.S. Pat. Nos. 4,270,483, 4,685,414 and 4,779,557, there are disclosed coating apparatus which can be moved into position to allow the blanket cylinder of the last printing station of a press to be used to apply a coating material to the sheets. In U.S. Pat. No. 4,796,556, there is disclosed a coating apparatus which can be selectively moved between the blanket cylinder or the plate cylinder of the last printing station of the press so that the station can be used as a coating station for the press.

Suggestions for overcoming the problem of the loss of a printing station when coating is desired have also been made, such as that set forth in U.S. Pat. Nos. 4,934,305 which discloses a coating apparatus having a separate timed applicator roller positioned to apply the coating material to the printed sheet while the sheet is on the last impression cylinder of the press. This is said to allow the last printing station to be operated simultaneously as both an ink application station and a coating station so that no loss of press printing unit capability results. Another approach to providing a coating station without losing the printing capabilities of the last printing station is to provide a totally separate coating unit downstream of the last printing station so that the coating is applied to the sheets after final printing and before the sheets have reached the sheet delivery stacker. Such an approach is suggested in U.S. Pat. Nos. 4,399,767 and 4,706,601.

Conventional coating apparatus which is operable as an in-line press operation utilizes an engraved transfer roller, with the liquid coating being applied to the engraved roller by means of a doctor blade assembly. The doctor blade assembly includes an elongated housing having a reservoir chamber extending the length of the transfer roller for holding a volume of coating liquid in wetting contact with the circumferential surface of the transfer roller. A pair of circumferentially spaced doctor blades extend longitudinally along the reservoir housing on either side of the chamber. The doctor blades are angled tangentially toward the transfer roller surface, and seal the reservoir chamber against the roller surface and wipe the roller surface to deposit liquid in the cells of the engraved transfer surface.

The reservoir chamber is pressurized with coating liquid, which is pumped from a remote supply drum into the upper region of the pressure chamber. After the pressure chamber fills to a certain level, it is returned to the remote drum by gravity flow. Occasionally, the doctor blade reservoir chamber becomes completely filled with the coating liquid when the volume of coating liquid being delivered to the doctor blade reservoir chamber exceeds the gravity flow return rate. The positive pressure may cause the seals at the ends of the roller to leak, allowing the coating liquid to drip onto the floor or onto adjacent press parts. Occasionally, the coating liquid may be slung from the roller onto adjacent press equipment and operator areas. Moreover, the buildup of positive pressure within the doctor blade reservoir chamber accelerates the wear of the end seals.

It will be appreciated that the transfer roller may be operated at high speeds, for example, on the order of 1,000 linear feet per minute, and that the end seals of the doctor blade assembly will tend to wear quickly. The

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end seal wear is accelerated by the buildup of positive pressure within the doctor blade chamber. Low volume drip leakage can be collected in a drip pan or catch tray, but as the end seals wear, the coating liquid will be slung from the transfer roller, thereby causing a difficult cleanup problem. When this occurs, the press must be shut down, the doctor blade head must be removed, and the end seals replaced. The steps of rebuilding or replacing the end seals and realigning the doctor blade head causes an unacceptable amount of press downtime.

One approach for overcoming the problem of end seal wear is to provide stationary end seals which are mounted on the press frame, and which bear in sealing engagement against the ends of the transfer roller, so that the doctor blade head may form a seal with stationary seals rather than with the dynamic seals carried on the transfer roller. Another approach is to use rotary end seals which include an end plate which is resiliently engaged against the end surface of the transfer roller, with a seal member being secured between the end plate and the end portions of the roller by quick removal mounting lugs.

While the foregoing mechanical approaches to limiting end seal wear and thereby avoiding leakage have been moderately successful, and some arrangements have reduced downtime by quick change mounting features, the end seals nevertheless are still experiencing accelerated wear and early failure, thereby causing frequent replacements and unacceptable downtime for correction of end seal leakage.

OBJECTS OF THE INVENTION

Accordingly, there exists a need for a new and improved in-line coating apparatus for use in a sheet-fed or web-fed, offset rotary or flexographic printing press for applying a protective and/or decorative coating to the printed surface of freshly printed sheets which does not require any expensive or substantial press modification or result in any impairment of normal press operating capability.

Specifically, the principal object of the present invention is to provide a new and improved in-line coating and/or inking apparatus of the character described which achieves a reduction in end seal leakage.

SUMMARY OF THE INVENTION

The present invention provides a new and improved inline doctor blade apparatus for applying a protective and/or decorative coating and/or inking to the surface of freshly printed sheets in a sheet-fed or web-fed, offset rotary or flexographic printing press which is highly reliable and effective in use, yet which does not require any expensive or substantial press modification or result in any impairment of normal press operating capability.

The reservoir of a doctor blade head is supplied with coating material from a remote supply drum. To insure that an adequate supply of coating liquid is always present within the doctor blade reservoir, the coating material is drawn from the remote supply drum and is circulated by suction flow constantly through the reservoir. In contrast to the conventional approach of positively pressurizing the doctor blade reservoir with liquid coating pumped from the remote drum to the reservoir, the coating material is instead circulated through the reservoir by suction flow. That is, instead of charging the reservoir with coating liquid pumped from the remote drum and thereby creating a positive pressure condition within the doctor blade reservoir, circulation through

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the reservoir is induced by suction flow provided by a suction pump having an input connected for drawing coating liquid from the doctor blade reservoir, and returning it by forced (positive pressure) flow to the remote supply drum, rather than by gravity flow return.

As a result of the suction flow arrangement, the liquid material is drawn from the remote supply drum at a greater rate than the rate of withdrawal of the liquid material by the pickup roller, and a substantially constant supply of liquid material will always be present within the doctor blade reservoir. A benefit of the suction flow arrangement is that a positive pressure buildup does not occur within the doctor blade chamber. Moreover, liquid material which rises above a predetermined fill level is drawn out of the doctor blade reservoir by the suction pump, and is returned to the remote drum. Consequently, the end seals are not subjected to high pressure differential conditions. Instead, the suction flow arrangement produces a negative pressure differential, with the doctor blade chamber being operated at a level below atmospheric. Under negative pressure conditions, leakage of coating liquid is virtually non-existent, and the operating life of the end seals is substantially increased.

According to another aspect of the present invention, visual and audible alerts are provided by a vacuum sensor line which is coupled to the vacuum space within the doctor blade chamber. The sensor line is coupled to a vacuum gauge which provides a visual indication of the suction pressure within the doctor blade chamber. A vacuum sensor switch is also coupled to the chamber for selectively applying electrical power to an audio transducer when the pressure within the vacuum chamber rises above a predetermined safe operating suction level.

Other features and advantages of the present invention will become more apparent from the following detailed description taken in conjunction with the accompanying drawings which disclose, by way of example, the principles of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic side elevational view of a sheet-fed, offset rotary printing press having a coating apparatus embodying the present invention;

FIG. 2 is an enlarged fragmentary side elevational view taken substantially within the circular area designated "2" in FIG. 1 and showing the coating apparatus of the present invention during coating operation;

FIG. 3 is an enlarged fragmentary perspective view showing one side of the coating apparatus mounted in the press and illustrating the fluid path of coating material from a remote supply drum to the doctor blade reservoir of the coating unit;

FIG. 4 is an enlarged fragmentary sectional view taken substantially along the line 4-4 of FIG. 3;

FIG. 5 is a simplified flow diagram which illustrates a dual pump arrangement for circulating coating liquid from a remote supply drum to the doctor blade reservoir and return;

FIG. 6 is a simplified flow diagram which illustrates a single pump arrangement for circulating coating liquid by suction flow from a remote supply drum to the doctor blade reservoir and return;

FIG. 7 is an enlarged fragmentary perspective view of one end portion of the doctor blade coating apparatus of the present invention;

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FIG. 8 is an enlarged sectional view taken substantially along the line 8--8 of FIG. 7; and,

FIG. 9 is a view similar to FIG. 8 which includes a suction pressure sensing circuit for providing a visual indication of suction pressure and an audible alert when the suction/vacuum pressure inside the doctor blade rises above a safe operating level, thereby signaling an impending end seal failure.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line doctor blade apparatus, herein generally designated 10, for use in applying a protective and/or decorative coating or inks to the freshly printed surface of sheets printed in a sheet-fed or web-fed, offset rotary or flexographic printing press, herein generally designated 12. In this instance, as shown in FIG. 1, the doctor blade coating apparatus 10 is illustrated as installed in a four color printing press 12, such as that manufactured by Heidelberger Druckmaschinen AG of the Federal Republic of Germany under its designation Heidelberg Speedmaster 102V (40"), and which includes a press frame 14 coupled at one end, herein the right end, with a sheet feeder 16 from which sheets, herein designated 18, are individually and sequentially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the finally printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical sheet printing stations 22, 24, 26 and 28 which can print different color inks onto the sheets as they are moved through the press 10.

As illustrated, each of the printing stations 22, 24, 26 and 28 is substantially identical and of conventional design, herein including a sheet-fed cylinder 30, a plate cylinder 32, a blanker cylinder 34 and an impression cylinder 36, with each of the first three printing stations 22, 24 and 26 having a transfer cylinder 38 disposed to withdraw the freshly printed sheets from the adjacent impression cylinder and transfer the freshly printed sheets to the next printing station via a transfer drum 40. The final printing station 28 herein is shown as equipped with a delivery cylinder 42 which functions to support the printed sheet 18 as it is moved from the final impression cylinder 36 by a delivery conveyor system, generally designated 44, to the sheet delivery stacker 20.

The delivery conveyor system 44 as shown in FIG. 2 is of conventional design and includes a pair of endless delivery gripper chains 46, only one of which is shown carrying at regular spaced locations along the chains, laterally disposed gripper bars 48 having gripper elements 50 used to grip the leading edge of a sheet 18 after it leaves the nip between the delivery cylinder 42 and impression cylinder 36 of the last printing station 28. As the leading edge E of the sheet 18 is gripped by the grippers 50 the delivery chains 46 pull the sheet away from the impression cylinder 36 and convey the freshly printed sheet to the sheet delivery stacker 20 where the grippers release the finally printed sheet.

The endless delivery chains 46 are driven in synchronous timed relation to the impression cylinder 36 by sprocket wheels 52 fixed adjacent the lateral ends of a delivery drive shaft 54 which has a mechanically geared coupling (not shown) to the press drive system. The delivery drive shaft 54 extends laterally between the sides of the press frame 14 adjacent the impression cyl-

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inder 36 of the last printing station 28, and is disposed to be parallel with the axis of the impression cylinder. In this instance, the delivery cylinder 42, which is constructed to allow adjustments in diameter by suitable means, is attached to the delivery drive shaft 54 so that the delivery cylinder is also rotated in precise timed relation with the impression cylinder.

In this respect, it is important to note that when the freshly printed sheets 18 are conveyed away from the impression cylinder 36 of the final printing station 28 by the gripper 50 carried by the delivery chains 46, the wet inked surfaces of the sheets face the delivery drive shaft 54 and the sheets must be supported such that the ink is not smeared as the sheets are transferred. Typically, such support is provided by skeleton wheels or cylinders mounted to the press delivery drive shaft 54, or as is now more commonly used, net equipped delivery cylinders marketed by Printing Research, Inc. of Dallas, Tex. under its registered trademark SUPERBLUE. That system, which is made and sold under license, is manufactured in accordance with and operates as described in U.S. Pat. No. 4,402,267, issued Sep. 6, 1983, to Howard W. DeMoore, the disclosure of which is incorporated herein by this reference.

More recently, vacuum transfer apparatus of the type disclosed in co-pending U.S. application Ser. No. 07/630,308, filed Dec. 18, 1990, entitled "Vacuum Transfer Apparatus for Sheet-Fed Printing Presses", which is also incorporated herein by reference, has been used. The vacuum transfer apparatus disclosed in that application can be used in place of delivery cylinders or skeleton wheels to pull the unprinted side of the sheet away from the delivery drive shaft 54 so that the wet ink surface of the sheets do not come into contact with any press apparatus.

In accordance with the present invention, the in-line doctor blade coating apparatus 10 for applying the protective or decorative coating or ink to the sheets 18 enables the press 12 to be operated in the normal manner without the loss of the final printing station 28, and without requiring any substantial press modifications by employing the existing press delivery drive shaft 54 as the mounting location for the coating applicator roller. In presses having delivery systems such as skeleton wheels mounted on the delivery drive shaft 54 or a vacuum transfer apparatus as disclosed in the aforementioned co-pending U.S. application Ser. No. 07/630,308, conversion to a coating operation can be quickly and easily achieved by mounting on the press delivery drive shaft in place of the skeleton wheels or in addition to the vacuum transfer apparatus, a suitable support cylinder capable of performing the combined function of a coating applicator roller and a net enhanced delivery cylinder 42. By utilizing the delivery cylinder 42 mounted on the delivery drive shaft 54 to also act as a coating applicator roller, protective coating will be applied to the printed sheet 18 in precise timed registration, and will permit the press to be operated with its full range of printing stations.

Toward these ends, the coating apparatus 10 of the present invention includes a relatively simple, positive acting and economical doctor blade coating unit, generally designated 60, mounted to the press frame 14 downstream of the delivery drive shaft 54 and positioned to apply liquid coating material to the support surface of a delivery cylinder 42 mounted on the delivery drive shaft. As can best be seen in FIGS. 2, 3 and 4, the doctor blade coating unit 60 herein comprises a pair of side

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frames 62, only one of which is shown, it being understood that the other side frame is substantially the same as that of the side frame illustrated, attached to each side of the press frame 14. Pivotally mounted to one end of each of the side frames 62 is a support bracket 64 carrying one end of a liquid material reservoir 66 and cooperating liquid material pickup roller 68 each disposed to extend laterally across the press 12 parallel with the delivery drive shaft 54. The coating unit 60 is mounted between the upper and lower runs of the delivery chains 46 downstream of the delivery drive shaft 54, and positioned so that the outer peripheral surface 70 of the pickup roller 68 can be engaged with the support surface of a delivery cylinder 42 mounted on the delivery drive shaft.

As best seen in FIGS. 2 and 3, the support bracket 64 is pivotally attached to the end of the side frame 62 by a shaft 72 disposed at the lower end portion of the bracket, and can be pivoted about the shaft by an extensible cylinder 74, herein shown as a pneumatic cylinder, one end 76 of which is secured such as by welding to the side frame, and the opposite end 78 of which is coupled through a pivot shaft 79 to the upper end portion of the bracket. By extending or retracting the cylinder 74, the extent of engagement of the pickup roller 68 against the surface of the applicator roller 42 can be controlled, and the pickup roller can be completely disengaged from the applicator roller 42.

The coating pickup roller 68, which is of conventional design and preferably one such as the Anilox rollers manufactured by A.R.C. International of Charlotte, N.C. and sold under the name "PRINTMASTER" having an engraved ceramic or chrome outer peripheral surface 70, is designed to pick up a predetermined uniform thickness of liquid coating material or ink from the reservoir 66, and then uniformly transfer the coating material to the support surface of the applicator roller 42. To effect rotation of the pickup roller 68, a suitable motor 80, herein a hydraulic motor, is attached to one of the side frames 62 and coupled to a suitable hydraulic fluid source (not shown) through fittings 81A, 81B. Attached to the output of the motor 80 is an output gear which is drivingly coupled through a cluster gear 82 and a series of idler gears 83 each mounted on stub axles 84, to a drive gear 86 attached to the end of a shaft 88 on which the pickup roller 68 is concentrically mounted. The shaft 88 of the pickup roller 68 is, in turn, journaled at each end to the brackets 64 through a releasable semicircular collar 90 attached by bolts 92 to the bracket. Herein, the axle of the terminal idler gear, designated 83', also serves as the shaft 72 for pivotally mounting the support bracket 64 to the side frame 62 so that when the bracket is rotated about the shaft, the terminal idler gear remains engaged with the drive gear 86 of the pickup roller 68.

In this instance, as can best be seen in FIG. 4, the pickup roller 68 has a peripheral surface portion 68P which projects radially into the reservoir 66 containing the supply of coating material or ink. A pair of upper and lower inclined doctor blades 94 and 96 attached to the doctor blade head 98 on shoulders 98A, 98B engage the roller surface to doctor the excess liquid coating material or ink picked up from the reservoir by the engraved surface 70 of the roller. The reservoir cavity 66 herein is formed within an elongated doctor blade head 98 having a generally C-shaped cross-section with an opening 100 extending longitudinally along one side facing the pickup roller 68. The reservoir 66 is supplied

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with liquid material or ink from a supply drum 102 disposed in a remote location within or near the press 12. preferably, the doctor blade head 98 is removably attached to the brackets 64, herein by bolts 104 having enlarged, knurled heads 106, and which can be threaded through slots 108 formed in the brackets to clamp the reservoir in place on the brackets.

To insure that an adequate supply of liquid coating material is always present within the reservoir 66 and to prevent coagulation and clogging of the doctor blades 94 and 96 by the liquid coating material or ink, the coating material or ink is circulated through the reservoir by two pumps 110 and 112 as shown in FIG. 5. Pump 110 draws the liquid material L from the supply drum 102 via a supply line 114 and discharges it into a bottom region of the reservoir 66 through a delivery port 114P, and the other pump 112 acts to provide suction to a pair of return lines 116A, 116B coupled adjacent a top region of the reservoir through return ports 116P, 116Q for withdrawing excess liquid coating material or ink from the reservoir. By supplying the coating material or ink from the supply drum 102 at a greater rate than the rate of withdrawal of material by the pickup roller 68, a substantially constant supply of coating material or ink will always be present within the reservoir 66. The excess coating material or ink which rises above the liquid level of the return port R (FIG. 8) is suctioned away by the suction return pump 112.

The general arrangement of the pickup roller 68, doctor blades 94 and 96, and reservoir 66 is similar to that disclosed in U.S. Pat. No. 4,821,672 entitled "Doctor Blade Assembly With Rotary End Seals and Interchangeable Heads", the disclosure of which provides details concerning the end seal structure and operation of a pickup roller and reservoir usable with the present invention. According to an important feature of the present invention, however, the doctor blade reservoir 66 is not pressurized as taught by the prior art. Instead, coating liquid or ink is supplied to the doctor blade reservoir 66 by the suction flow produced by the pump 112. In this arrangement, the suction pump 112 applies a vacuum or suction force in the reservoir which draws liquid material L from the supply through the supply conduit 114 to the reservoir and draws excess liquid material L from the doctor blade reservoir 66 through the return conduit 116 into the remote reservoir 102 at a rate which is greater than the rate that liquid coating material or ink is being supplied to the doctor blade reservoir through the supply conduit 114. Because the suction return flow rate is greater than the supply flow rate, a positive pressure condition within the doctor blade reservoir is avoided, and a below atmospheric vacuum pressure level is provided.

Referring to FIG. 5, FIG. 6, FIG. 7 and FIG. 8, the liquid material is delivered into the lower region of the doctor blade reservoir 66, and is withdrawn from the doctor blade reservoir near an upper region of the chamber through the return conduits 116A, 116B. The liquid level elevation of the return port is preferably selected to provide for the accumulation of liquid coating material or ink in more than about half of the doctor blade chamber, thereby insuring that the engraved surface of the pickup roller 68 will be thoroughly wetted by the coating material or ink L as it turns through the doctor blade chamber 66. The reservoir 66 is bounded vertically by lower and upper doctor head shoulders 98A, 98B. Accordingly, the return ports 116P, 116Q of return lines 116A, 116B are located at a liquid level R

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intermediate the limits established by the lower and upper shoulders. Any excess liquid coating material or ink which rises above the liquid level R of the return ports will be suctioned away by the pump 112.

It will be appreciated that the supply pump 110 is optional, and that the suction circulation system can be operated effectively with only the single suction pump 112 as shown in FIG. 6. In the single pump configuration, it may be necessary to prime the supply conduit 114 to obtain satisfactory operation. The two pump arrangement as shown in FIG. 5 is preferred for those installations in which the supply drum 102 is located at a distance that is too far from the press to achieve adequate suction flow. The auxiliary supply pump 110 provides positive flow input to the doctor blade reservoir at a fixed flow rate. The return suction pump 112 has a faster suction flow rate than the supply flow rate. Consequently, a positive pressure buildup in the doctor blade reservoir cannot occur. By utilizing two pumps as shown in FIG. 5, the liquid level within the doctor blade chamber 66 can be closely controlled, without positive pressure buildup, thereby reducing leakage through the end seals.

Referring to FIG. 8, it will be appreciated that the doctor blade chamber 66 is maintained at a pressure level below atmospheric by the suction action of the return flow pump 112. The coating liquid L rises to the liquid level of the return port R and is drawn off immediately by the suction pump 112. Additionally, air within the doctor blade chamber 66 is also evacuated, thereby reducing the doctor blade chamber pressure to a level below atmospheric. This negative pressure differential condition opposes leakage of coating liquid L through the end seals. Since the doctor blade chamber 66 is not positively pressurized, the end seals are operated under favorable pressure differential conditions, thereby extending their useful lifetime. Moreover, the negative pressure differential doctor blade assembly will accommodate a pickup roller having a chipped corner, which would leak under positive pressure conditions, but does not leak because of the negative pressure reservoir condition established by suction flow.

It is useful for the press operator to have an advance warning of an impending end seal failure. With advance warning, the press operator can schedule repair and/or replacement of the doctor blades and the end seals at a convenient time, for example between press runs or before undertaking the next printing job. Apparatus for monitoring the suction/vacuum condition within the doctor blade chamber 66 is provided by a pneumatic sensor circuit 120 as shown in FIG. 9. The pneumatic sensor circuit 120 includes a pneumatic sensor line 122 which is coupled in fluid communication with the doctor blade chamber 66 through a vacuum sensor bore 124 formed through the upper doctor head shoulder 98B. The vacuum sensor line 122 is coupled to the sensor bore 124 by a threaded fitting 126.

Continuous monitoring of the vacuum/suction condition within the doctor blade chamber 66 is provided by a vacuum gauge 128 which can be of any conventional design, for example a Bourdon gauge which is calibrated for dry air and covers the range from about zero to about twenty torrs. The vacuum gauge 128 is coupled into the sensor line 122 by a tee coupling 130. According to this arrangement, the press operator receives a continuous visual indication of the vacuum/suction condition within the doctor blade chamber 66.

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According to another feature of the invention, the vacuum/suction line 122 is coupled to a vacuum switch 132. The vacuum switch 132 has a conductive, movable diaphragm 134 which moves into and out of electrical contact with switch electrodes 132A, 132B. That is, the diaphragm 134 is pulled out of contacting engagement with the switch electrodes 132A, 132B when the vacuum/suction level in the doctor blade chamber 66 is below a predetermined level. When the pressure level within the doctor blade chamber 66 rises above that preset level, for example in response to leakage of air through the end seals or around a worn doctor blade 94, the vacuum force within the vacuum chamber 132C of the sensor switch also rises, thereby permitting the conductive switch element 134 to engage the switch electrodes 132A, 132B.

When switch closure occurs, electrical power is applied to an audio transducer 136 from a power source 138. Electrical current is conducted through the pneumatic switch 132 to the audio transducer 136 through power conductors 140, 142. According to this arrangement, the press operator will receive an audible alert as soon as the suction/vacuum pressure in the doctor blade chamber rises above a safe operating level, thereby signaling wear failure of the doctor blades and/or an impending failure of the end seals.

From the foregoing, it should be apparent that the coating apparatus 10 of the present invention provides a highly reliable, effective and economical in-line apparatus for applying coating material to the freshly printed sheets 18 in a sheet-fed, offset rotary printing press 12 which allows the final printing station to continue to be used as a print station, yet which does not require any substantial press modification or the addition of a separate timed applicator roller. While a particular form of the present invention has been illustrated and described, it should be apparent that variations and modifications therein can be made without departing from the spirit and scope of the invention.

What is claimed is:

1. Apparatus for applying liquid material from a supply to a pickup roller comprising in combination:
 - a doctor blade head having an elongated reservoir for receiving liquid material from the supply, said doctor blade head being adapted to extend in parallel with the pickup roller in an operative position with a portion of the peripheral surface of the pickup roller extending into said reservoir for wetting contact with liquid material contained therein, and two doctor blades attached to said doctor blade head for engagement against said peripheral surface in the operative position;
 - a supply conduit connecting said supply in flow communication with said reservoir;
 - a return conduit connecting said reservoir in flow communication with said supply; and,
 - a first pump coupled in series flow relation with said return conduit for inducing suction flow of liquid material from said reservoir through said return conduit into said supply.
2. Apparatus as defined in claim 1, including:
 - a second pump coupled in series flow relation with said supply conduit for pumping liquid material from said supply to said reservoir.
3. Apparatus as defined in claim 2, wherein the suction return pumping rate of said first pump is greater than the supply pumping rate of said second pump.

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4. Apparatus as defined in claim 1, said doctor blade head having first and second shoulders forming lower and upper liquid level boundaries for said reservoir, respectively, wherein the return conduit is coupled in flow communication with said reservoir at a liquid level location disposed intermediate the liquid level boundaries established by said first and second shoulders.

5. Apparatus as defined in claim 1, wherein the return conduit is coupled in flow communication with said reservoir at a first liquid level location and the supply conduit is coupled in flow communication with said reservoir at a second liquid level location, the first liquid level location of the return conduit being higher in elevation than the second liquid level location of the supply conduit when the doctor blade head is in the operative position.

6. Apparatus for applying liquid material from a supply to a pickup roller comprising, in combination:

a elongated doctor blade head having an elongated cavity formed therein defining a reservoir for receiving liquid material from the supply, said doctor blade head being adapted to extend in parallel with the pickup roller in an operative position with a portion of the peripheral surface of the pickup roller extending into said cavity for wetting contact with liquid material contained therein, and a pair of doctor blades disposed on opposite sides of said cavity and extending the length thereof for engagement against the peripheral surface of the pickup roller in the operative position; and,

means coupled to said supply and to said reservoir for inducing flow of liquid material from said supply into said reservoir and for returning excess liquid material by suction force from said reservoir to said supply.

7. Apparatus as defined in claim 6, said inducing means comprising:

a supply conduit connecting said supply in flow communication with said reservoir;

a return conduit connecting said reservoir in flow communication with said supply; and,

a first pump coupled in series flow relation with said return conduit for inducing suction flow of liquid material from said supply through said supply conduit into said reservoir, and for inducing suction flow of liquid material from said reservoir through said return conduit into said supply.

8. Apparatus as defined in claim 7, said means including:

a second pump coupled in series flow relation with said supply conduit for pumping liquid material from said supply to said reservoir.

9. Apparatus as defined in claim 8, wherein the suction return pumping rate of said first pump is greater than the supply pumping rate of said second pump.

10. Apparatus as defined in claim 6, said doctor blade head having first and second shoulders forming lower and upper liquid level boundaries for said reservoir, respectively, wherein said means for inducing suction flow includes a return conduit coupled in flow communication with said reservoir at a liquid level location disposed intermediate the liquid level boundaries established by said first and second shoulders.

11. Apparatus for applying liquid material from a supply to a pickup roller comprising in combination:

a doctor blade head having an elongated reservoir for receiving liquid material from the supply, said doctor blade head being adapted to extend in parallel

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with the pickup roller in an operative position with a portion of the peripheral surface of the pickup roller extending into said reservoir for wetting contact with liquid material contained therein, and two doctor blades attached to said doctor blade head for engagement against said peripheral surface in the operative position;

first means coupled to said supply and to said reservoir for pumping liquid material from said supply into said reservoir; and,

second means coupled to said reservoir and to said supply for inducing suction flow of liquid material from said reservoir into said supply.

12. Apparatus for applying liquid material from a supply to a pickup roller comprising in combination:

a doctor blade head having an elongated reservoir chamber for receiving liquid material from the supply, said doctor blade head being adapted to extend in parallel with the pickup roller in an operative position with a portion of the peripheral surface of the pickup roller extending into said reservoir chamber for wetting contact with liquid material contained therein, and two doctor blades attached to said doctor blade head for engagement against said peripheral surface in the operative position; and,

a suction pump coupled to said reservoir and to said supply for inducing suction flow of liquid material from said reservoir to said supply.

13. Apparatus as defined in claim 12, including a pneumatic sensor conduit coupled to said reservoir chamber for sensing the air vacuum pressure within said reservoir chamber, and a vacuum gauge coupled to said sensor conduit for providing a visual indication of air vacuum pressure in said reservoir chamber.

14. Apparatus as defined in claim 12, including a pneumatic sensor conduit coupled to said reservoir chamber for sensing the air vacuum pressure within said reservoir chamber, a vacuum responsive switch having a sensing chamber coupled to said sensor conduit and switch electrodes and an audio transducer electrically connected to said switch electrodes for making and breaking an electrical circuit from a power source to said audio transducer.

15. In a sheet-fed, offset rotary printing press of the type including at least one printing station having a blanket cylinder and an impression cylinder disposed for printing ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery conveyor system including a delivery drive shaft disposed adjacent to and extending parallel with the impression cylinder and driven in timed synchronous relation with the impression cylinder, the improvement comprising:

a delivery cylinder mounted onto said delivery drive shaft and having an outer peripheral support surface adapted to engage and support a sheet being transported by said delivery conveyor system;

a coating apparatus including a supply of liquid material, a rotatable pickup roller having an outer peripheral surface of substantially cylindrical shape, and means for applying a coating of liquid material from said supply onto said outer peripheral surface of said pickup roller;

means for mounting said coating apparatus to the press adjacent said delivery cylinder with a portion

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of said peripheral surface of said pickup roller engaged with the support surface of said delivery cylinder, whereby liquid coating material from said supply applied onto the peripheral surface of said pickup roller is transferred to said support surface of said delivery cylinder and to said freshly printed sheet;

said coating apparatus including an elongated reservoir for receiving liquid material from said supply, said reservoir extending parallel with said pickup roller with a portion of the peripheral surface of the pickup roller extending into said reservoir for wetting contact with liquid material contained therein, and two doctor blades attached to said reservoir and engaging said peripheral surface, said doctor blades acting to limit the amount of liquid material applied onto said peripheral surface from said reservoir;

a supply conduit connecting said supply in flow communication with said reservoir;

a return conduit connecting said reservoir in flow communication with said supply; and,

a first pump coupled in series flow relation with said return conduit for inducing suction flow return of liquid material from said reservoir to the remote supply.

16. The improvement as set forth in claim 15, wherein said coating apparatus is mounted to said press downstream of said delivery drive shaft in the direction of travel of said sheets during transport by said delivery conveyor system.

17. The improvement as set forth in claim 15, including:

a second pump coupled in series flow relation with said supply conduit for liquid material from the remote supply to said reservoir.

18. The improvement as set forth in claim 17, wherein the suction return flow rate of said first pump is greater than the positive pressure supply flow rate of said second pump.

19. The improvement as set forth in claim 15, wherein the return conduit is coupled in flow communication with said reservoir at a first liquid level location and the supply conduit is coupled in flow communication with said reservoir at a second liquid level location, the first liquid level location of the return conduit being higher than the second liquid level location of the supply conduit.

20. In a sheet-fed, offset rotary printing press of the type including at least one printing station having a blanket cylinder and an impression cylinder disposed for printing wet ink onto sheets passing therebetween, and a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery conveyor system comprising a pair of endless gripper chains disposed on opposite sides of the press and supporting therebetween gripper bars and grippers spaced along the chains, the gripper chains being driven in timed synchronous relation with the impression cylinder by laterally spaced sprocket wheels mounted on opposite ends of a delivery drive shaft disposed adjacent to and extending parallel with the impression cylinder, the improvement comprising:

a delivery cylinder mounted to said delivery drive shaft between said sprocket wheels and having an outer peripheral support surface covered by a removable coating blanket adapted to engage and

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support the wet ink side of a sheet being transported by said gripper bars;

a coating apparatus including a supply of liquid material, a rotatable pickup roller having an outer peripheral surface of substantially cylindrical shape, and means for applying liquid material from said supply onto said peripheral surface of said pickup roller;

means for mounting said coating apparatus to the press adjacent the delivery cylinder, with a portion of the outer peripheral surface of said pickup roller engaged with said delivery cylinder, whereby liquid material doctored onto the peripheral surface of said pickup roller is transferred to said delivery cylinder and to said freshly printed sheet;

said coating apparatus including an elongated reservoir containing liquid material, said reservoir being disposed to extend parallel with said pickup roller with a portion of said peripheral surface extending into said reservoir in contact with liquid material contained therein, and two doctor blades attached to said reservoir and engaging said peripheral surface, said doctor blades acting to limit the amount of liquid coating material applied onto said peripheral surface from said reservoir;

a supply conduit connecting said supply in flow communication with said reservoir;

a return conduit connecting said reservoir in flow communication with said supply; and,

a first pump coupled in series flow relation with said return conduit for inducing suction flow return of liquid material from said reservoir to said supply.

21. A sheet-fed, offset rotary printing press including: at least one printing station having a blanket cylinder and an impression cylinder disposed for printing wet ink onto sheets passing therebetween;

a delivery conveyor system for pulling freshly printed sheets from the impression cylinder and transporting the printed sheets toward a sheet delivery stacker, the delivery system including a delivery drive shaft;

a delivery cylinder mounted to said delivery drive shaft and having an outer peripheral support surface adapted to engage and support a sheet being transported by said delivery conveyor system;

a coating apparatus including a supply of liquid material, a rotatable pickup roller having an outer peripheral surface of substantially cylindrical shape, and means for applying liquid material from said supply onto the peripheral surface of said pickup roller;

means for mounting said coating apparatus to the press adjacent said delivery cylinder, with a portion of said peripheral surface of said pickup roller engaged with said delivery cylinder, whereby liquid material applied to the peripheral surface of said pickup roller is transferred to said delivery cylinder and then to said freshly printed sheet;

said coating apparatus including an elongated reservoir containing liquid material, said reservoir being disposed to extend parallel with said pickup roller with a portion of said peripheral surface extending into the reservoir in contact with liquid material contained therein, and two doctor blades attached to said reservoir and engaging said peripheral surface, said doctor blades acting to limit the amount of liquid coating material applied onto said peripheral surface from said reservoir;

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a supply conduit connecting said supply in flow communication with said reservoir;
a return conduit connecting said reservoir in flow communication with said supply; and,
a first pump coupled in series flow relation with said 5

return conduit for inducing suction flow return of liquid material from said reservoir to said supply.
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United States Patent [19]
DeMoore et al.



US005335596A

[11] Patent Number: 5,335,596
[45] Date of Patent: * Aug. 9, 1994

- [54] COATING APPARATUS FOR SHEET-FED, OFFSET ROTARY PRINTING PRESSES
[75] Inventors: Howard W. DeMoore, 10954 Shady Trail, Dallas, Tex. 75220; Steven M. Person, Seagoville, Tex.
[73] Assignee: Howard W. DeMoore, Dallas, Tex.
[*] Notice: The portion of the term of this patent subsequent to May 4, 2010 has been disclaimed.
[21] Appl. No.: 52,763
[22] Filed: Apr. 26, 1993

Related U.S. Application Data

- [63] Continuation of Ser. No. 879,841, May 6, 1992, Pat. No. 5,207,159, which is a continuation-in-part of Ser. No. 752,778, Aug. 30, 1991, Pat. No. 5,176,077.
[51] Int. Cl.³ B41F 31/00
[52] U.S. Cl. 101/350; 101/351; 101/367; 101/147; 118/261
[58] Field of Search 101/350, 351, 352, 137, 101/147, 148, 157, 167, 169, 207, 208, 219, 329, 330, 331, 348, 349, 364, 365, 366, 367; 118/602, 612, 236, 242, 259, 261, 262

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Primary Examiner—Eugene H. Eickholt
Attorney, Agent, or Firm—Dennis T. Griggs

[57] ABSTRACT

A coating apparatus for use in a sheet-fed or web-fed, offset rotary or flexographic printing press to apply a protective and/or decorative coating to the surface of freshly printed sheets includes a doctor blade coating unit coupled to a pickup roller for supplying liquid material from a reservoir to the surface of a pickup roller mounted on a press delivery drive shaft. Liquid material is circulated through the reservoir of the doctor blade unit by suction flow produced by a return pump. This prevents the buildup of a positive pressure differential within the doctor blade reservoir. The doctor blade reservoir is maintained at below ambient pressure level, thereby preventing leakage through the end seals. A vacuum sensor circuit provides a visual indication of air vacuum pressure in the doctor blade reservoir chamber, and a vacuum sensor switch applies electrical power to an audio transducer. The audio transducer produces an audible alarm in response to an increase in doctor blade chamber pressure, thereby providing advance warning of an impending end seal failure or a worn doctor blade condition.

10 Claims, 9 Drawing Sheets

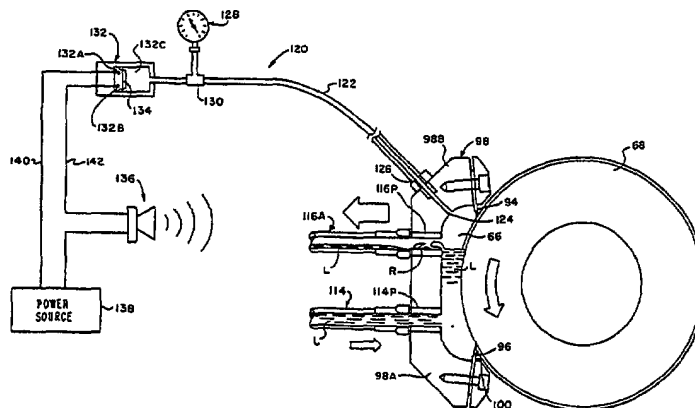


FIG. 1

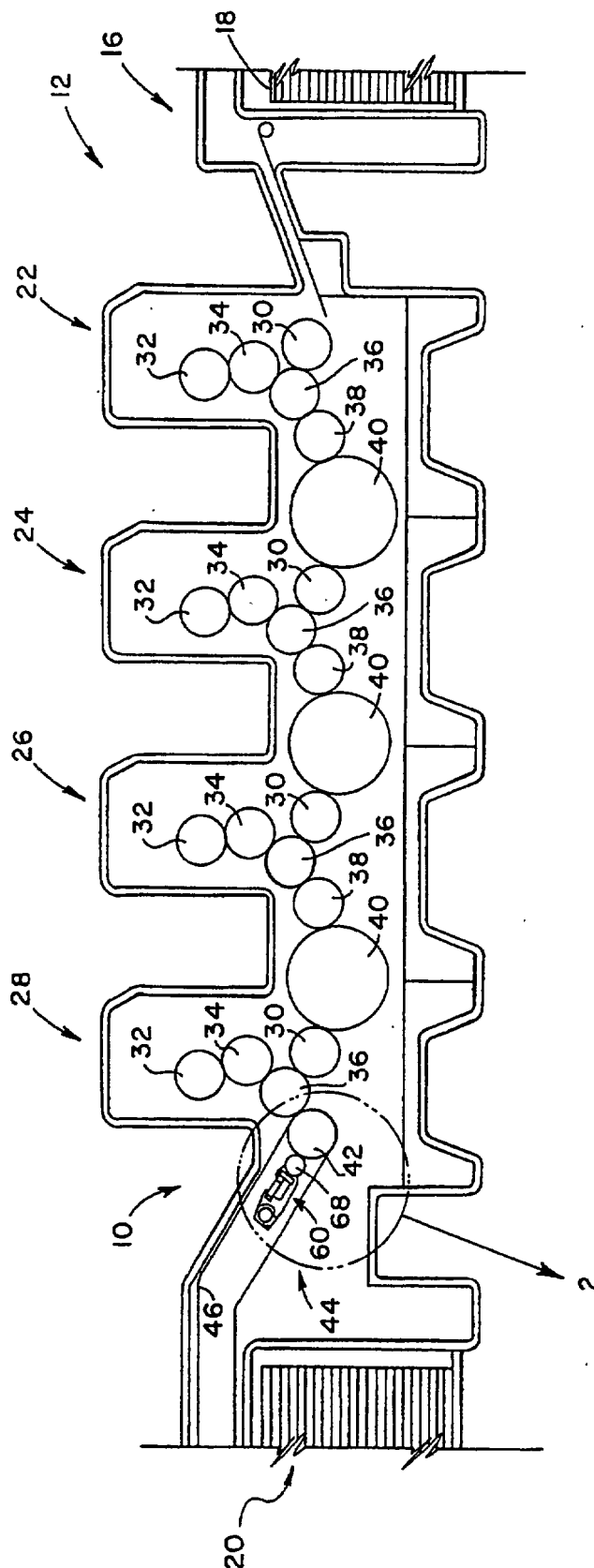


FIG. 2

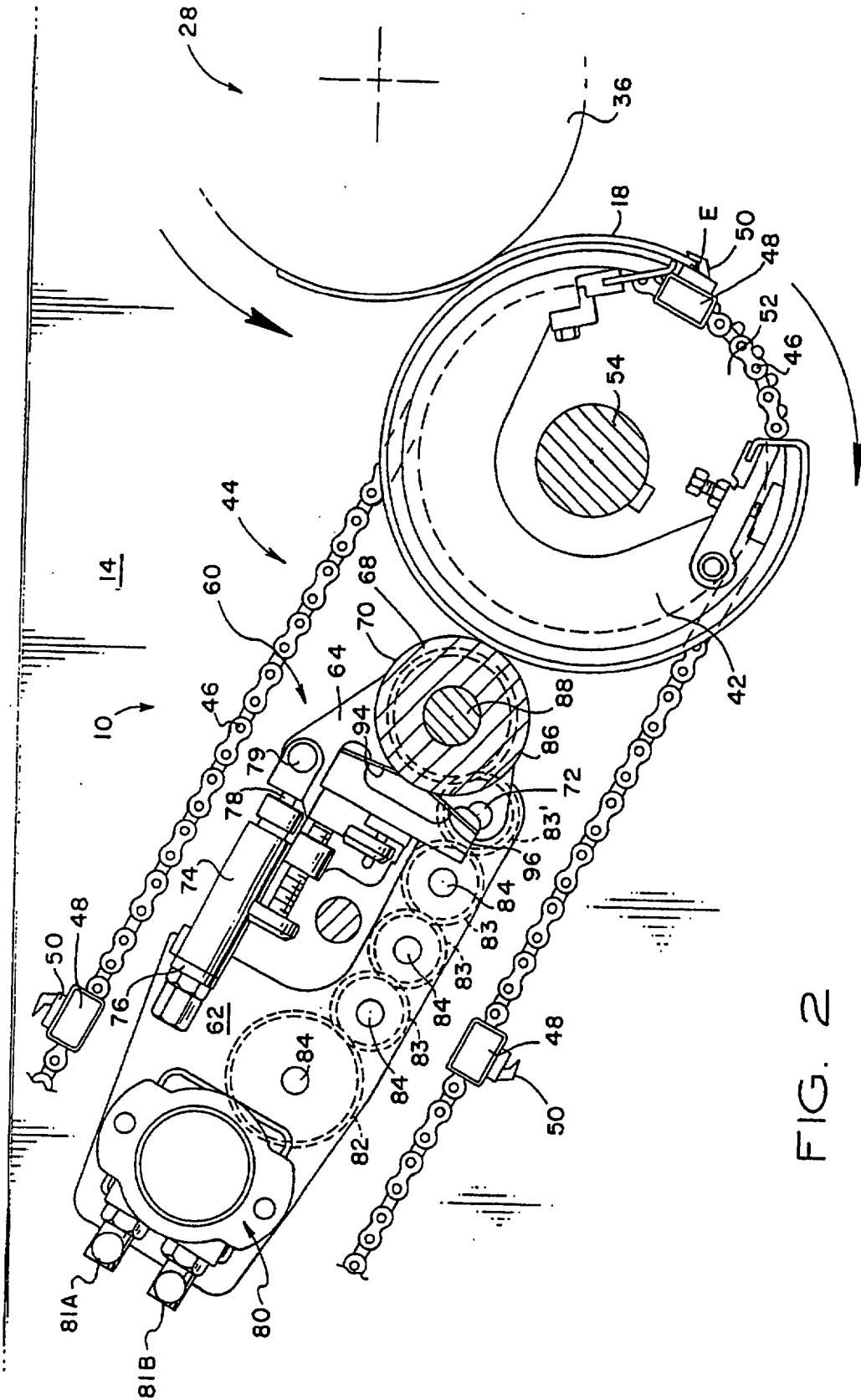


FIG. 2

FIG. 3

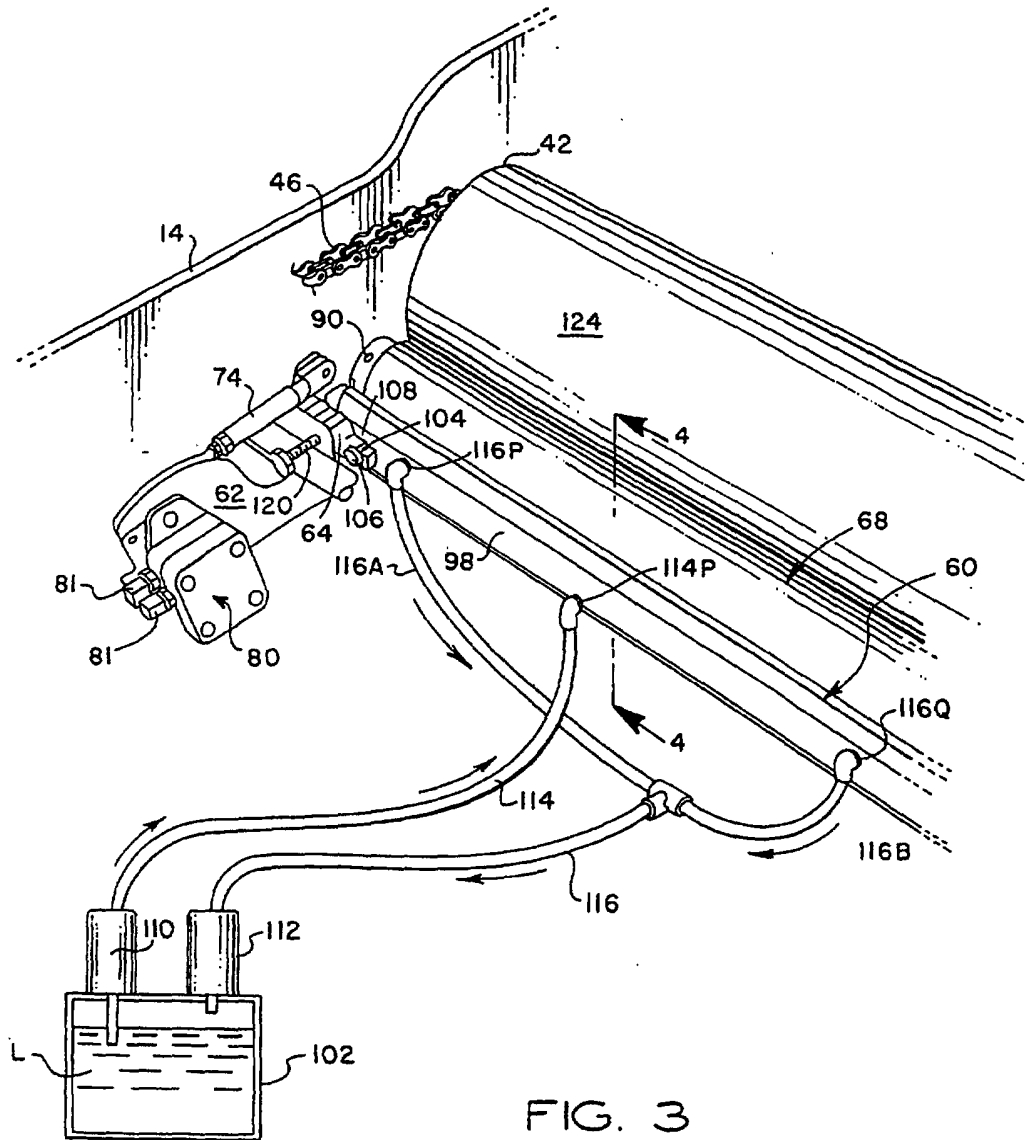


FIG. 3

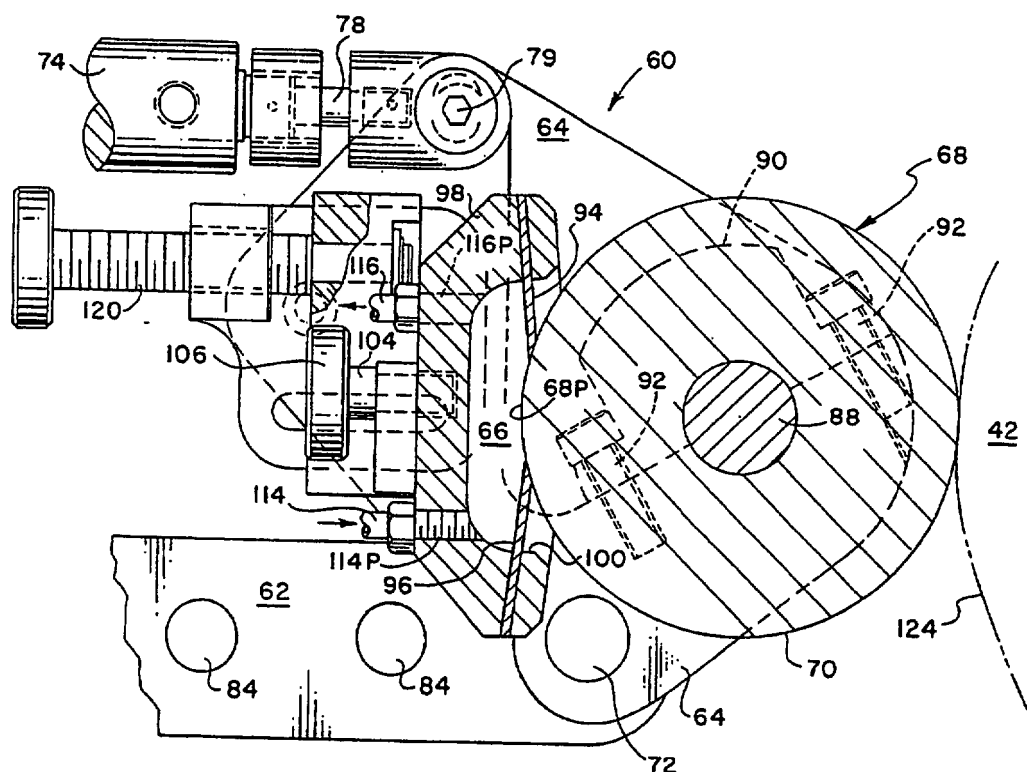


FIG. 4

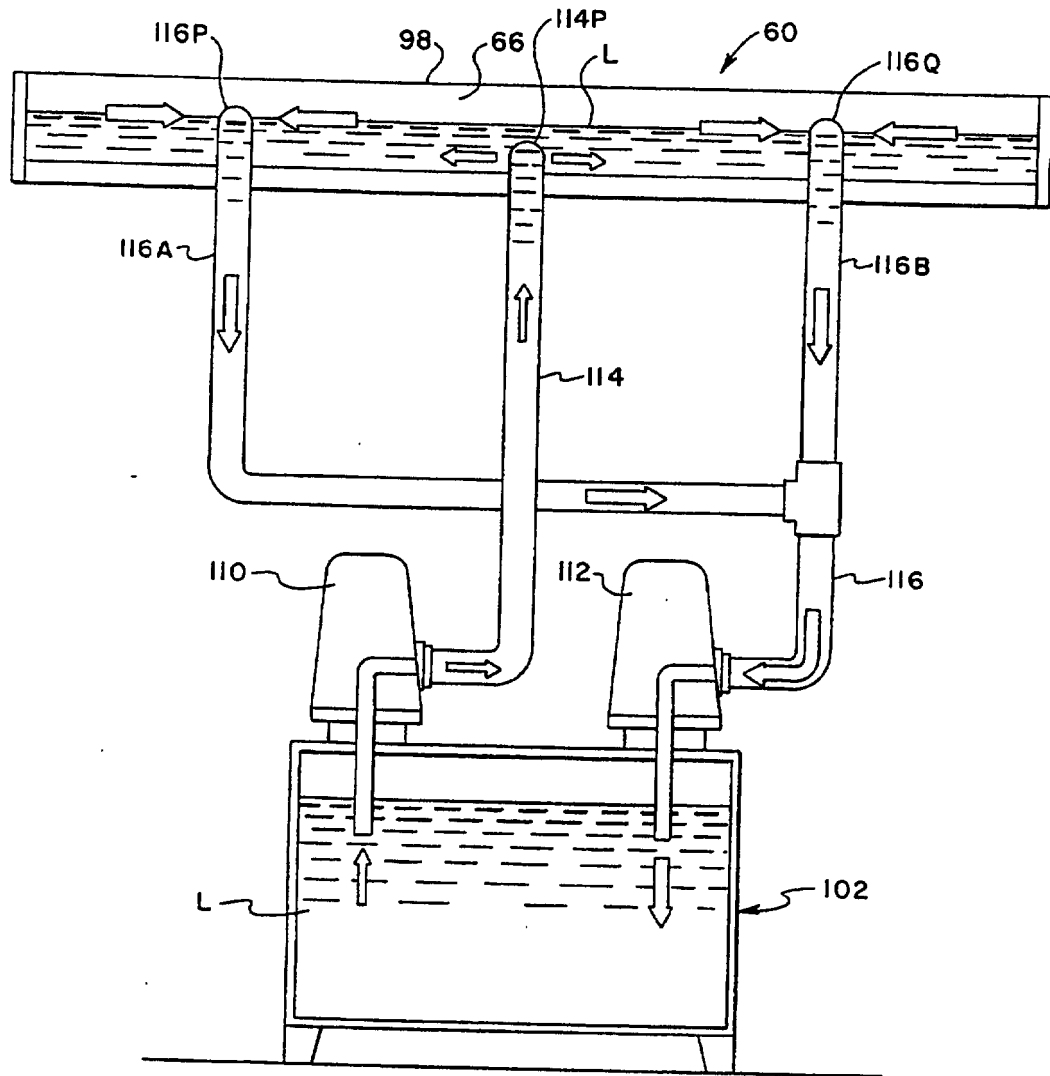


FIG. 5

FIG. 6

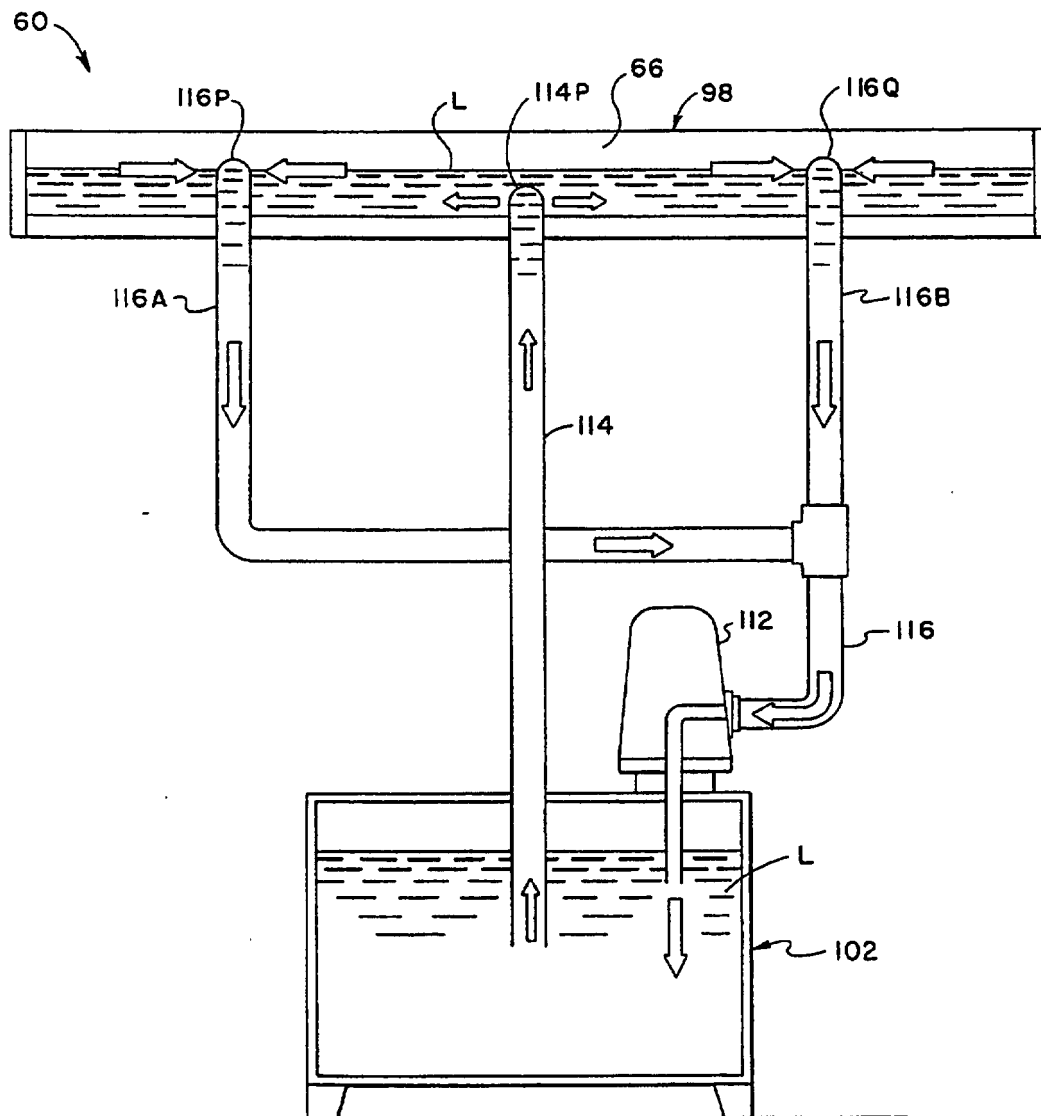
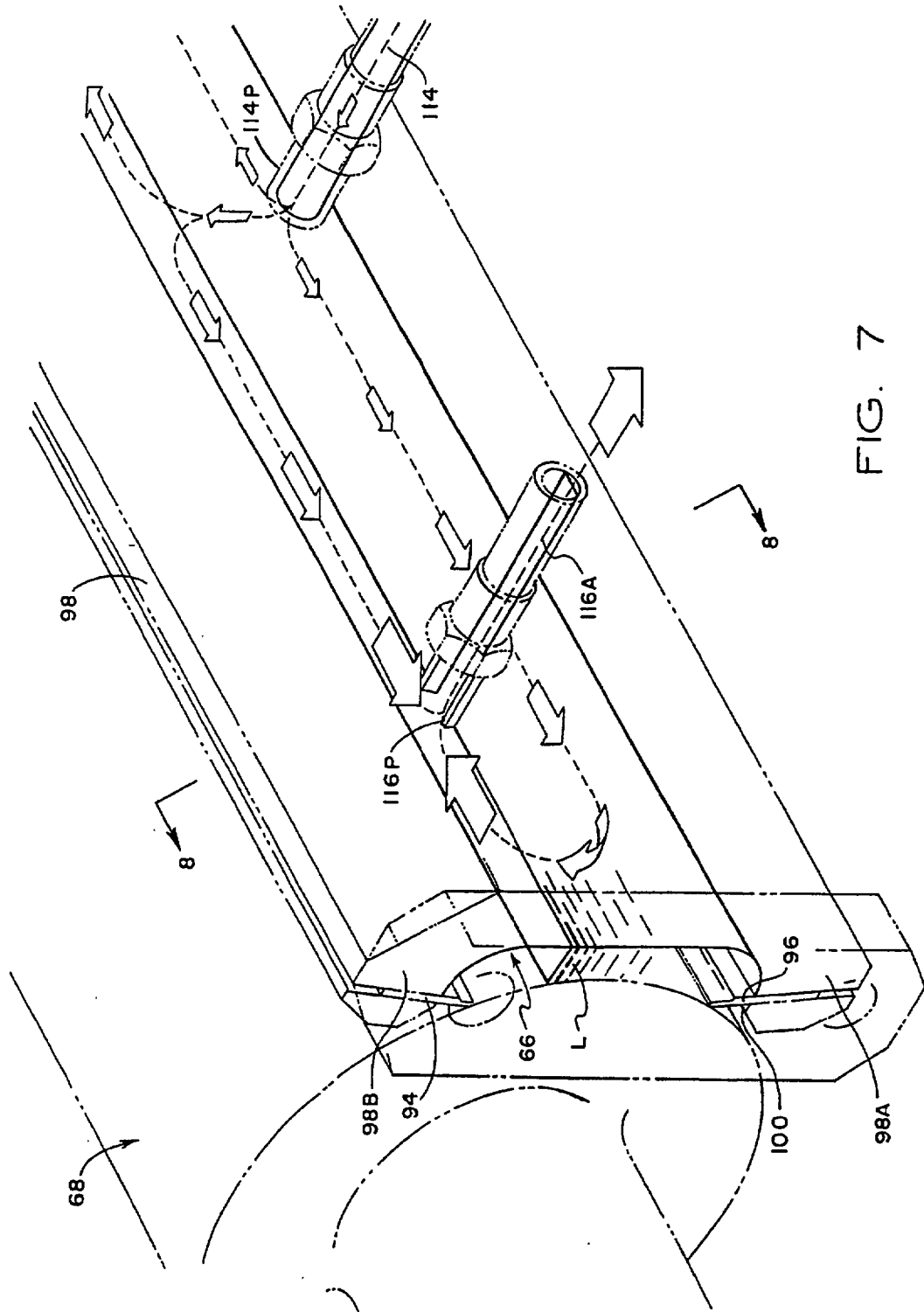


FIG. 6

FIG. 7



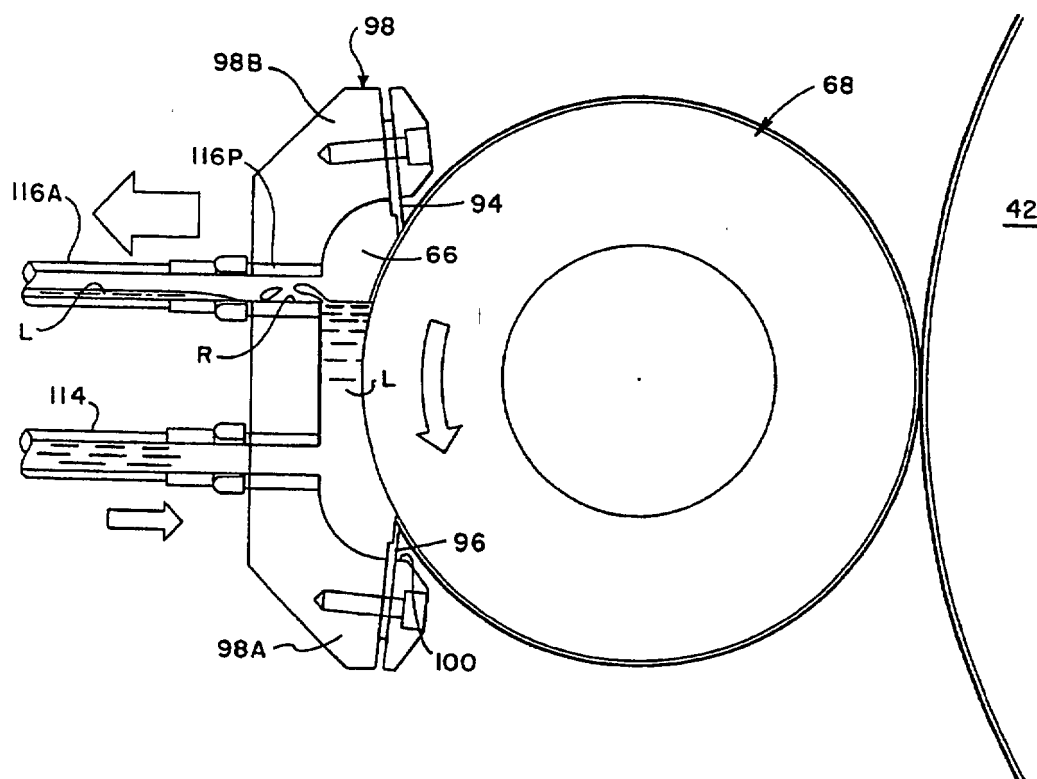


FIG. 8

FIG. 9

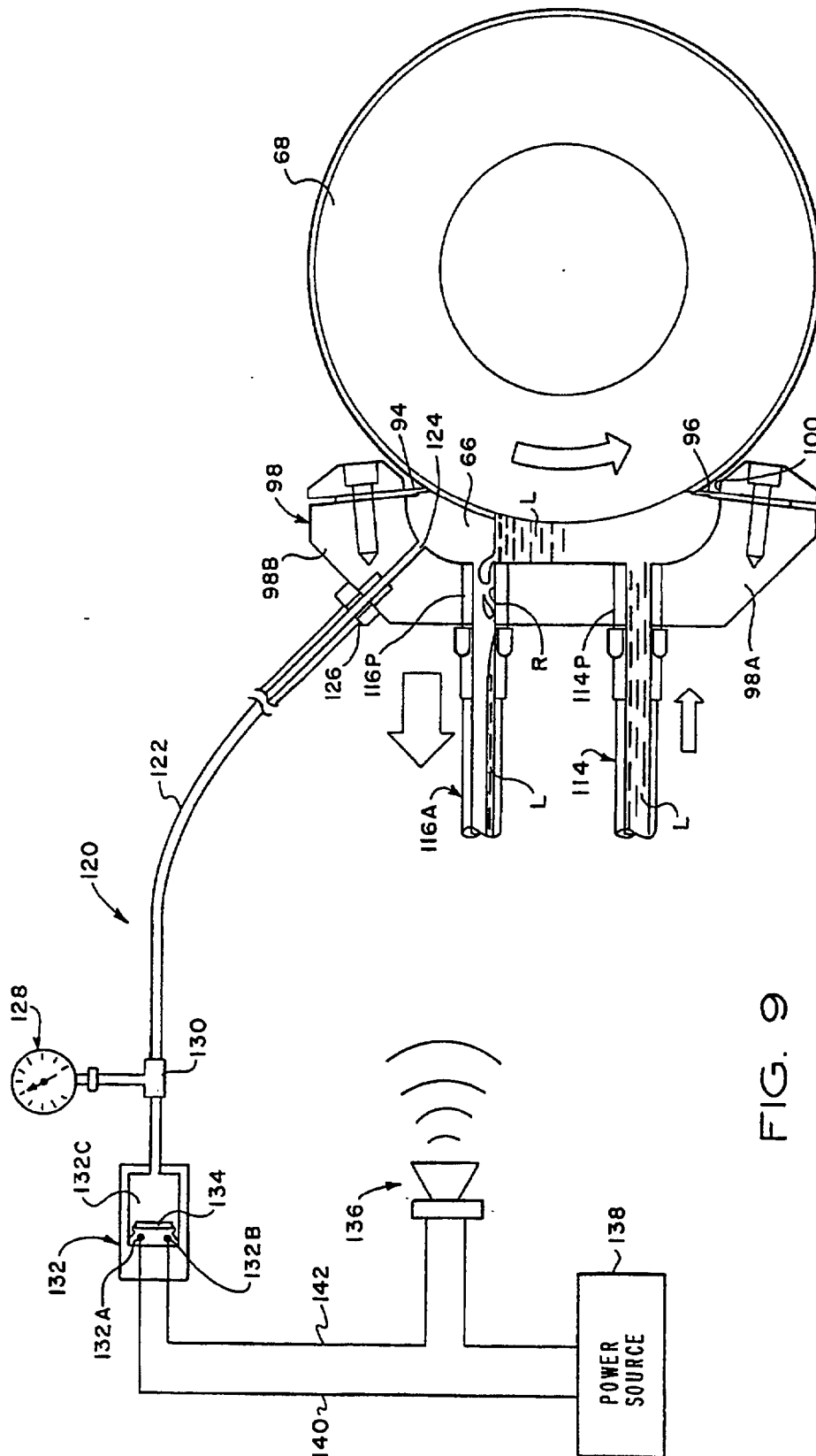


FIG. 9

COATING APPARATUS FOR SHEET-FED, OFFSET ROTARY PRINTING PRESSES

CROSS REFERENCE TO RELATED APPLICATION

This is a continuation of application Ser. No. 07/879,841, filed May 6, 1992 now U.S. Pat. No. 5,207,159 which is a continuation-in-part of application Ser. No. 07/752,778 filed Aug. 30, 1991 now U.S. Pat. No. 5,176,077.

FIELD OF THE INVENTION

This invention relates to sheet-fed or web-fed, offset rotary or flexographic printing presses, and more particularly, to a new and improved apparatus for the in-line application of protective and decorative coatings or inks to the printed surface of freshly printed sheets or web.

BACKGROUND OF THE INVENTION

Conventional sheet-fed, offset rotary printing presses typically include one or more printing stations through which individual sheets are fed and printed with wet ink. After final printing, the sheets are fed by a delivery conveyor system to the delivery end of the press where the freshly printed sheets are collected and stacked. In a typical sheet-fed, offset rotary printing press such as the Heidelberg Speedmaster line of presses, the delivery conveyor system includes a pair of endless gripper chains carrying spaced laterally disposed gripper bars and grippers which are used to grip and pull freshly printed sheets from the impression cylinder and convey the sheets toward the sheet delivery stacker. The gripper chains are driven in precisely timed relation to the impression cylinder by gripper chain sprocket wheels which are laterally spaced between a delivery drive shaft mounted on opposite sides of the press frame. The delivery drive shaft is mechanically coupled by gears for synchronous rotation with the impression cylinder.

Since the inks used with offset type printing presses typically remain wet and tacky for some time after printing, special precautions must be taken to insure that the wet inked surface of the freshly printed sheets is not marked or smeared as the sheets are transferred from one printing station to another, and through the delivery system to the sheet delivery stacker. The printed surface of the paper dries relatively slowly and can be smeared during subsequent processing, particularly when the printed sheets are stacked. In order to minimize smearing, a dryer may be mounted along the delivery path of the printed sheets, or an anti-offset spray powder may be sprayed on the printed surface.

In some printing applications, it is desirable that the press be capable of applying a protective and/or decorative coating over all or a portion of the surface of the printed sheets. Typical coating solutions include varnish, lacquer, dye, moisturizers and ink. Such coatings typically are formed of a UV-curable or water-soluble resin applied as a liquid solution or emulsion by an applicator roller over the freshly printed sheets to protect the ink and improve the appearance of the sheets. Use of such coatings is particularly desirable when decorative or protective finishes are required such as in the production of posters, record jackets, brochures, magazines, folding cartons and the like. In cases where a liquid coating is to be applied, the coating operation is

carried out after the final ink printing has been performed, most desirably by an in-line coating application.

DESCRIPTION OF THE PRIOR ART

Various suggestions have been made for applying the coating as an in-line press operation by using the final printing station of the press as the coating application station. For example, in U.S. Pat. Nos. 4,270,483, 4,685,414 and 4,779,557, there are disclosed coating apparatus which can be moved into position to allow the blanket cylinder of the last printing station of a press to be used to apply a coating material to the sheets. In U.S. Pat. No. 4,796,556, there is disclosed a coating apparatus which can be selectively moved between the blanket cylinder or the plate cylinder of the last printing station of the press so that the station can be used as a coating station for the press.

Suggestions for overcoming the problem of the loss of a printing station when coating is desired have also been made, such as that set forth in U.S. Pat. No. 4,934,305 which discloses a coating apparatus having a separate timed applicator roller positioned to apply the coating material to the printed sheet while the sheet is on the last impression cylinder of the press. This is said to allow the last printing station to be operated simultaneously as both an ink application station and a coating station so that no loss of press printing unit capability results. Another approach to providing a coating station without losing the printing capabilities of the last printing station is to provide a totally separate coating unit downstream of the last printing station so that the coating is applied to the sheets after final printing and before the sheets have reached the sheet delivery stacker. Such an approach is suggested in U.S. Pat. Nos. 4,399,767 and 4,706,601.

Conventional coating apparatus which is operable as an in-line press operation utilizes an engraved transfer roller, with the liquid coating being applied to the engraved roller by means of a doctor blade assembly. The doctor blade assembly includes an elongated housing having a reservoir chamber extending the length of the transfer roller for holding a volume of coating liquid in wetting contact with the circumferential surface of the transfer roller. A pair of circumferentially spaced doctor blades extend longitudinally along the reservoir housing on either side of the chamber. The doctor blades are angled tangentially toward the transfer roller surface, and seal the reservoir chamber against the roller surface and wipe the roller surface to deposit liquid in the cells of the engraved transfer surface.

The reservoir chamber is pressurized with coating liquid, which is pumped from a remote supply drum into the upper region of the pressure chamber. After the pressure chamber fills to a certain level, it is returned to the remote drum by gravity flow. Occasionally, the doctor blade reservoir chamber becomes completely filled with the coating liquid when the volume of coating liquid being delivered to the doctor blade reservoir chamber exceeds the gravity flow return rate. The positive pressure may cause the seals at the ends of the roller to leak, allowing the coating liquid to drip onto the floor or onto adjacent press parts. Occasionally, the coating liquid may be slung from the roller onto adjacent press equipment and operator areas. Moreover, the buildup of positive pressure within the doctor blade reservoir chamber accelerates the wear of the end seals.

It will be appreciated that the transfer roller may be operated at high speeds, for example, on the order of

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1,000 linear feet per minute, and that the end seals of the doctor blade assembly will tend to wear quickly. The end seal wear is accelerated by the buildup of positive pressure within the doctor blade chamber. Low volume drip leakage can be collected in a drip pan or catch tray, but as the end seals wear, the coating liquid will be slung from the transfer roller, thereby causing a difficult cleanup problem. When this occurs, the press must be shut down, the doctor blade head must be removed, and the end seals replaced. The steps of rebuilding or replacing the end seals and realigning the doctor blade head causes an unacceptable amount of press downtime.

One approach for overcoming the problem of end seal wear is to provide stationary end seals which are mounted on the press frame, and which bear in sealing engagement against the ends of the transfer roller, so that the doctor blade head may form a seal with stationary seals rather than with the dynamic seals carried on the transfer roller. Another approach is to use rotary end seals which include an end plate which is resiliently engaged against the end surface of the transfer roller, with a seal member being secured between the end plate and the end portions of the roller by quick removal mounting lugs.

While the foregoing mechanical approaches to limiting end seal wear and thereby avoiding leakage have been moderately successful, and some arrangements have reduced downtime by quick change mounting features, the end seals nevertheless are still experiencing accelerated wear and early failure, thereby causing frequent replacements and unacceptable downtime for correction of end seal leakage.

OBJECTS OF THE INVENTION

Accordingly, there exists a need for a new and improved in-line coating apparatus for use in a sheet-fed or web-fed, offset rotary or flexographic printing press for applying a protective and/or decorative coating to the printed surface of freshly printed sheets which does not require any expensive or substantial press modification or result in any impairment of normal press operating capability.

Specifically, the principal object of the present invention is to provide a new and improved in-line coating and/or inking apparatus of the character described which achieves a reduction in end seal leakage.

SUMMARY OF THE INVENTION

The present invention provides a new and improved in-line doctor blade apparatus for applying a protective and/or decorative coating and/or inking to the surface of freshly printed sheets in a sheet-fed or web-fed, offset rotary or flexographic printing press which is highly reliable and effective in use, yet which does not require any expensive or substantial press modification or result in any impairment of normal press operating capability.

The reservoir of a doctor blade head is supplied with coating material from a remote supply drum. To insure that an adequate supply of coating liquid is always present within the doctor blade reservoir, the coating material is drawn from the remote supply drum and is circulated by suction flow constantly through the reservoir. In contrast to the conventional approach of positively pressurizing the doctor blade reservoir with liquid coating pumped from the remote drum to the reservoir, the coating material is instead circulated through the reservoir by suction flow. That is, instead of charging the reservoir with coating liquid pumped from the remote

drum and thereby creating a positive pressure condition within the doctor blade reservoir, circulation through the reservoir is induced by suction flow provided by a suction pump having an input connected for drawing coating liquid from the doctor blade reservoir, and returning it by forced (positive pressure) flow to the remote supply drum, rather than by gravity flow return.

As a result of the suction flow arrangement, the liquid material is drawn from the remote supply drum at a greater rate than the rate of withdrawal of the liquid material by the pickup roller, and a substantially constant supply of liquid material will always be present within the doctor blade reservoir. A benefit of the suction flow arrangement is that a positive pressure buildup does not occur within the doctor blade chamber. Moreover, liquid material which rises above a predetermined fill level is drawn out of the doctor blade reservoir by the suction pump, and is returned to the remote drum. Consequently, the end seals are not subjected to high pressure differential conditions. Instead, the suction flow arrangement produces a negative pressure differential, with the doctor blade chamber being operated at a level below atmospheric. Under negative pressure conditions, leakage of coating liquid is virtually nonexistent, and the operating life of the end seals is substantially increased.

According to another aspect of the present invention, visual and audible alerts are provided by a vacuum sensor line which is coupled to the vacuum space within the doctor blade chamber. The sensor line is coupled to a vacuum gauge which provides a visual indication of the suction pressure within the doctor blade chamber. A vacuum sensor switch is also coupled to the chamber for selectively applying electrical power to an audio transducer when the pressure within the vacuum chamber rises above a predetermined safe operating suction level.

Other features and advantages of the present invention will become more apparent from the following detailed description taken in conjunction with the accompanying drawings which disclose, by way of example, the principles of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a schematic side elevational view of a sheet-fed, offset rotary printing press having a coating apparatus embodying the present invention;

FIG. 2 is an enlarged fragmentary side elevational view taken substantially within the circular area designated "2" in FIG. 1 and showing the coating apparatus of the present invention during coating operation;

FIG. 3 is an enlarged fragmentary perspective view showing one side of the coating apparatus mounted in the press and illustrating the fluid path of coating material from a remote supply drum to the doctor blade reservoir of the coating unit;

FIG. 4 is an enlarged fragmentary sectional view taken substantially along the line 4—4 of FIG. 3;

FIG. 5 is a simplified flow diagram which illustrates a dual pump arrangement for circulating coating liquid from a remote supply drum to the doctor blade reservoir and return;

FIG. 6 is a simplified flow diagram which illustrates a single pump arrangement for circulating coating liquid by suction flow from a remote supply drum to the doctor blade reservoir and return;

FIG. 7 is an enlarged fragmentary perspective view of one end portion of the doctor blade coating apparatus of the present invention;

FIG. 8 is an enlarged sectional view taken substantially along the line 8—8 of FIG. 7; and,

FIG. 9 is a view similar to FIG. 8 which includes a suction pressure sensing circuit for providing a visual indication of suction pressure and an audible alert when the suction/vacuum pressure inside the doctor blade rises above a safe operating level, thereby signaling an impending end seal failure.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line doctor blade apparatus, herein generally designated 10, for use in applying a protective and/or decorative coating or inks to the freshly printed surface of sheets printed in a sheet-fed or web-fed, offset rotary or flexographic printing press, herein generally designated 12. In this instance, as shown in FIG. 1, the doctor blade coating apparatus 10 is illustrated as installed in a four color printing press 12, such as that manufactured by Heidelberger Druckmaschinen AG of the Federal Republic of Germany under its designation Heidelberg Speedmaster 102V (40"), and which includes a press frame 14 coupled at one end, herein the right end, with a sheet feeder 16 from which sheets, herein designated 18, are individually and sequentially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the finally printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical sheet printing stations 22, 24, 26 and 28 which can print different color inks onto the sheets as they are moved through the press 10.

As illustrated, each of the printing stations 22, 24, 26 and 28 is substantially identical and of conventional design, herein including a sheet-fed cylinder 30, a plate cylinder 32, a blanker cylinder 34 and an impression cylinder 36, with each of the first three printing stations 22, 24 and 26 having a transfer cylinder 38 disposed to withdraw the freshly printed sheets from the adjacent impression cylinder and transfer the freshly printed sheets to the next printing station via a transfer drum 40. The final printing station 28 herein is shown as equipped with a delivery cylinder 42 which functions to support the printed sheet 18 as it is moved from the final impression cylinder 36 by a delivery conveyor system, generally designated 44, to the sheet delivery stacker 20.

The delivery conveyor system 44 as shown in FIG. 2 is of conventional design and includes a pair of endless delivery gripper chains 46, only one of which is shown carrying at regular spaced locations along the chains, laterally disposed gripper bars 48 having gripper elements 50 used to grip the leading edge of a sheet 18 after it leaves the nip between the delivery cylinder 42 and impression cylinder 36 of the last printing station 28. As the leading edge E of the sheet 18 is gripped by the grippers 50, the delivery chains 46 pull the sheet away from the impression cylinder 36 and convey the freshly printed sheet to the sheet delivery stacker 20 where the grippers release the finally printed sheet.

The endless delivery chains 46 are driven in synchronous timed relation to the impression cylinder 36 by sprocket wheels 52 fixed adjacent the lateral ends of a delivery drive shaft 54 which has a mechanically geared

coupling (not shown) to the press drive system. The delivery drive shaft 54 extends laterally between the sides of the press frame 14 adjacent the impression cylinder 36 of the last printing station 28, and is disposed to be parallel with the axis of the impression cylinder. In this instance, the delivery cylinder 42, which is constructed to allow adjustments in diameter by suitable means, is attached to the delivery drive shaft 54 so that the delivery cylinder is also rotated in precise timed relation with the impression cylinder.

In this respect, it is important to note that when the freshly printed sheets 18 are conveyed away from the impression cylinder 36 of the final printing station 28 by the gripper 50 carried by the delivery chains 46, the wet inked surfaces of the sheets face the delivery drive shaft 54 and the sheets must be supported such that the ink is not smeared as the sheets are transferred. Typically, such support is provided by skeleton wheels or cylinders mounted to the press delivery drive shaft 54, or as is now more commonly used, net equipped delivery cylinders marketed by Printing Research, Inc. of Dallas, Tex. under its registered trademark SUPERBLUE. That system, which is made and sold under license, is manufactured in accordance with and operates as described in U.S. Pat. No. 4,402,267, issued Sep. 6, 1983, to Howard W. DeMoore, the disclosure of which is incorporated herein by this reference.

More recently, vacuum transfer apparatus of the type disclosed in co-pending application Ser. No. 07/630,308, filed Dec. 18, 1990, entitled "Vacuum Transfer Apparatus for Sheet-Fed Printing Presses", which is also incorporated herein by reference, has been used. The vacuum transfer apparatus disclosed in that application can be used in place of delivery cylinders or skeleton wheels to pull the unprinted side of the sheet away from the delivery drive shaft 54 so that the wet ink surface of the sheets do not come into contact with any press apparatus.

In accordance with the present invention, the in-line doctor blade coating apparatus 10 for applying the protective or decorative coating or ink to the sheets 18 enables the press 12 to be operated in the normal manner without the loss of the final printing station 28, and without requiring any substantial press modifications by employing the existing press delivery drive shaft 54 as the mounting location for the coating applicator roller. In presses having delivery systems such as skeleton wheels mounted on the delivery drive shaft 54 or a vacuum transfer apparatus as disclosed in the aforementioned co-pending application Ser. No. 07/630,308, conversion to a coating operation can be quickly and easily achieved by mounting on the press delivery drive shaft in place of the skeleton wheels or in addition to the vacuum transfer apparatus, a suitable support cylinder capable of performing the combined function of a coating applicator roller and a net enhanced delivery cylinder 42. By utilizing the delivery cylinder 42 mounted on the delivery drive shaft 54 to also act as a coating applicator roller, protective coating will be applied to the printed sheet 18 in precise timed registration, and will permit the press to be operated with its full range of printing stations.

Toward these ends, the coating apparatus 10 of the present invention includes a relatively simple, positive acting and economical doctor blade coating unit, generally designated 60, mounted to the press frame 14 downstream of the delivery drive shaft 54 and positioned to apply liquid coating material to the support surface of a

delivery cylinder 42 mounted on the delivery drive shaft. As can best be seen in FIGS. 2, 3 and 4, the doctor blade coating unit 60 herein comprises a pair of side frames 62, only one of which is shown, it being understood that the other side frame is substantially the same as that of the side frame illustrated, attached to each side of the press frame 14. Pivotally mounted to one end of each of the side frames 62 is a support bracket 64 carrying one end of a liquid material reservoir 66 and cooperating liquid material pickup roller 68 each disposed to extend laterally across the press 12 parallel with the delivery drive shaft 54. The coating unit 60 is mounted between the upper and lower runs of the delivery chains 46 downstream of the delivery drive shaft 54, and positioned so that the outer peripheral surface 70 of the pickup roller 68 can be engaged with the support surface of a delivery cylinder 42 mounted on the delivery drive shaft.

As best seen in FIGS. 2 and 3, the support bracket 64 is pivotally attached to the end of the side frame 62 by a shaft 72 disposed at the lower end portion of the bracket, and can be pivoted about the shaft by an extensible cylinder 74, herein shown as a pneumatic cylinder, one end 76 of which is secured such as by welding to the side frame, and the opposite end 78 of which is coupled through a pivot shaft 79 to the upper end portion of the bracket. By extending or retracting the cylinder 74, the extent of engagement of the pickup roller 68 against the surface of the applicator roller 42 can be controlled, and the pickup roller can be completely disengaged from the applicator roller 42.

The coating pickup roller 68, which is of conventional design and preferably one such as the Anilox rollers manufactured by A.R.C. International of Charlotte, N.C. and sold under the name "PRINTMASTER" having an engraved ceramic or chrome outer peripheral surface 70, is designed to pick up a predetermined uniform thickness of liquid coating material or ink from the reservoir 66, and then uniformly transfer the coating material to the support surface of the applicator roller 42. To effect rotation of the pickup roller 68, a suitable motor 80, herein a hydraulic motor, is attached to one of the side frames 62 and coupled to a suitable hydraulic fluid source (not shown) through fittings 81A, 81B. Attached to the output of the motor 80 is an output gear which is drivingly coupled through a cluster gear 82 and a series of idler gears 83 each mounted on stub axles 84, to a drive gear 86 attached to the end of a shaft 88 on which the pickup roller 68 is concentrically mounted. The shaft 88 of the pickup roller 68 is, in turn, journaled at each end to the brackets 64 through a releasable semicircular collar 90 attached by bolts 92 to the bracket. Herein, the axle of the terminal idler gear, designated 83', also serves as the shaft 72 for pivotally mounting the support bracket 64 to the side frame 62 so that when the bracket is rotated about the shaft, the terminal idler gear remains engaged with the drive gear 86 of the pickup roller 68.

In this instance, as can best be seen in FIG. 4, the pickup roller 68 has a peripheral surface portion 68P which projects radially into the reservoir 66 containing the supply of coating material or ink. A pair of upper and lower inclined doctor blades 94 and 96 attached to the doctor blade head 98 on shoulders 98A, 98B engage the roller surface to doctor the excess liquid coating material or ink picked up from the reservoir by the engraved surface 70 of the roller. The reservoir cavity 66 herein is formed within an elongated doctor blade

head 98 having a generally C-shaped cross-section with an opening 100 extending longitudinally along one side facing the pickup roller 68. The reservoir 66 is supplied with liquid material or ink from a supply drum 102 disposed in a remote location within or near the press 12. Preferably, the doctor blade head 98 is removably attached to the brackets 64, herein by bolts 104 having enlarged, knurled heads 106, and which can be threaded through slots 108 formed in the brackets to clamp the reservoir in place on the brackets.

To insure that an adequate supply of liquid coating material is always present within the reservoir 66 and to prevent coagulation and clogging of the doctor blades 94 and 96 by the liquid coating material or ink, the coating material or ink is circulated through the reservoir by two pumps 110 and 112 as shown in FIG. 5. Pump 110 draws the liquid material L from the supply drum 102 via a supply line 114 and discharges it into a bottom region of the reservoir 66 through a delivery port 114P, and the other pump 112 acts to provide suction to a pair of return lines 116A, 116B coupled adjacent a top region of the reservoir through return ports 116P, 116Q for withdrawing excess liquid coating material or ink from the reservoir. By supplying the coating material or ink from the supply drum 102 at a greater rate than the rate of withdrawal of material by the pickup roller 68, a substantially constant supply of coating material or ink will always be present within the reservoir 66. The excess coating material or ink which rises above the liquid level of the return port R (FIG. 8) is suctioned away by the suction return pump 112.

The general arrangement of the pickup roller 68, doctor blades 94 and 96, and reservoir 66 is similar to that disclosed in U.S. Pat. No. 4,821,672 entitled "Doctor Blade Assembly With Rotary End Seals and Interchangeable Heads", the disclosure of which provides details concerning the end seal structure and operation of a pickup roller and reservoir usable with the present invention. According to an important feature of the present invention, however, the doctor blade reservoir 66 is not pressurized as taught by the prior art. Instead, coating liquid or ink is supplied to the doctor blade reservoir 66 by the suction flow produced by the pump 112. In this arrangement, the suction pump 112 applies a vacuum or suction force in the reservoir which draws liquid material L from the supply through the supply conduit 114 to the reservoir and draws excess liquid material L from the doctor blade reservoir 66 through the return conduit 116 into the remote reservoir 102 at a rate which is greater than the rate that liquid coating material or ink is being supplied to the doctor blade reservoir through the supply conduit 114. Because the suction return flow rate is greater than the supply flow rate, a positive pressure condition within the doctor blade reservoir is avoided, and a below atmospheric vacuum pressure level is provided.

Referring to FIG. 5, FIG. 6, FIG. 7 and FIG. 8, the liquid material is delivered into the lower region of the doctor blade reservoir 66, and is withdrawn from the doctor blade reservoir near an upper region of the chamber through the return conduits 116A, 116B. The liquid level elevation of the return port is preferably selected to provide for the accumulation of liquid coating material or ink in more than about half of the doctor blade chamber, thereby insuring that the engraved surface of the pickup roller 68 will be thoroughly wetted by the coating material or ink L as it turns through the doctor blade chamber 66. The reservoir 66 is bounded

vertically by lower and upper doctor head shoulders 98A, 98B. Accordingly, the return ports 116P, 116Q of return lines 116A, 116B are located at a liquid level R intermediate the limits established by the lower and upper shoulders. Any excess liquid coating material or ink which rises above the liquid level R of the return ports will be suctioned away by the pump 112.

It will be appreciated that the supply pump 110 is optional, and that the suction circulation system can be operated effectively with only the single suction pump 112 as shown in FIG. 6. In the single pump configuration, it may be necessary to prime the supply conduit 114 to obtain satisfactory operation. The two pump arrangement as shown in FIG. 5 is preferred for those installations in which the supply drum 102 is located at a distance that is too far from the press to achieve adequate suction flow. The auxiliary supply pump 110 provides positive flow input to the doctor blade reservoir at a fixed flow rate. The return suction pump 112 has a faster suction flow rate than the supply flow rate. Consequently, a positive pressure buildup in the doctor blade reservoir cannot occur. By utilizing two pumps as shown in FIG. 5, the liquid level within the doctor blade chamber 66 can be closely controlled, without positive pressure buildup, thereby reducing leakage through the end seals.

Referring to FIG. 8, it will be appreciated that the doctor blade chamber 66 is maintained at a pressure level below atmospheric by the suction action of the return flow pump 112. The coating liquid L rises to the liquid level of the return port R and is drawn off immediately by the suction pump 112. Additionally, air within the doctor blade chamber 66 is also evacuated, thereby reducing the doctor blade chamber pressure to a level below atmospheric. This negative pressure differential condition opposes leakage of coating liquid L through the end seals. Since the doctor blade chamber 66 is not positively pressurized, the end seals are operated under favorable pressure differential conditions, thereby extending their useful lifetime. Moreover, the negative pressure differential doctor blade assembly will accommodate a pickup roller having a chipped corner, which would leak under positive pressure conditions, but does not leak because of the negative pressure reservoir condition established by suction flow.

It is useful for the press operator to have an advance warning of an impending end seal failure. With advance warning, the press operator can schedule repair and/or replacement of the doctor blades and the end seals at a convenient time, for example between press runs or before undertaking the next printing job. Apparatus for monitoring the suction/vacuum condition within the doctor blade chamber 66 is provided by a pneumatic sensor circuit 120 as shown in FIG. 9. The pneumatic sensor circuit 120 includes a pneumatic sensor line 122 which is coupled in fluid communication with the doctor blade chamber 66 through a vacuum sensor bore 124 formed through the upper doctor head shoulder 98B. The vacuum sensor line 122 is coupled to the sensor bore 124 by a threaded fitting 126.

Continuous monitoring of the vacuum/suction condition within the doctor blade chamber 66 is provided by a vacuum gauge 128 which can be of any conventional design, for example a Bourdon gauge which is calibrated for dry air and covers the range from about zero to about twenty torrs. The vacuum gauge 128 is coupled into the sensor line 122 by a tee coupling 130. According to this arrangement, the press operator re-

ceives a continuous visual indication of the vacuum/suction condition within the doctor blade chamber 66.

According to another feature of the invention, the vacuum/suction line 122 is coupled to a vacuum switch 132. The vacuum switch 132 has a conductive, movable diaphragm 134 which moves into and out of electrical contact with switch electrodes 132A, 132B. That is, the diaphragm 134 is pulled out of contacting engagement with the switch electrodes 132A, 132B when the vacuum/suction level in the doctor blade chamber 66 is below a predetermined level. When the pressure level within the doctor blade chamber 66 rises above that preset level, for example in response to leakage of air through the end seals or around a worn doctor blade 94, the vacuum force within the vacuum chamber 132C of the sensor switch also rises, thereby permitting the conductive switch element 134 to engage the switch electrodes 132A, 132B.

When switch closure occurs, electrical power is applied to an audio transducer 136 from a power source 138. Electrical current is conducted through the pneumatic switch 132 to the audio transducer 136 through power conductors 140, 142. According to this arrangement, the press operator will receive an audible alert as soon as the suction/vacuum pressure in the doctor blade chamber rises above a safe operating level, thereby signaling wear failure of the doctor blades and/or an impending failure of the end seals.

From the foregoing, it should be apparent that the coating apparatus 10 of the present invention provides a highly reliable, effective and economical in-line apparatus for applying coating material to the freshly printed sheets 18 in a sheet-fed, offset rotary printing press 12 which allows the final printing station to continue to be used as a print station, yet which does not require any substantial press modification or the addition of a separate timed applicator roller. While a particular form of the present invention has been illustrated and described, it should be apparent that variations and modifications therein can be made without departing from the spirit and scope of the invention.

What is claimed is:

1. Coating apparatus for applying liquid material from a supply drum to an applicator roller which is engagable in an operative position with a doctor blade head having an elongated reservoir for receiving liquid material from the supply drum, said doctor blade head being adapted to extend in parallel with the applicator roller in the operative position with a portion of the peripheral surface of the applicator roller extending into said reservoir for wetting contact with liquid material contained therein, characterized in that:

seal means are coupled to the doctor blade head for sealing engagement against the applicator roller in the operative position, whereby the doctor reservoir is sealed with respect to atmospheric pressure; and,

circulation means are coupled to the doctor reservoir for inducing the flow of liquid material from said supply drum into the doctor reservoir, for returning liquid material by suction flow from the doctor reservoir to the supply drum, and for maintaining the doctor reservoir at a pressure level below atmospheric pressure.

2. Coating apparatus as defined in claim 1, said circulation means being characterized by a supply conduit connecting the supply drum in flow communication with the doctor reservoir;

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a return conduit connecting the doctor reservoir in flow communication with the supply drum; and, a first pump coupled in series flow relation with the return conduit for inducing suction flow of liquid material from the doctor reservoir through the return conduit into the supply drum.

3. Coating apparatus as defined in claim 2, characterized in that the return conduit is coupled in flow communication with the doctor reservoir at a first liquid level location and the supply conduit is coupled in flow communication with the doctor reservoir at a second liquid level location, the first liquid level location of the return conduit being higher in elevation than the second liquid level location of the supply conduit when the doctor blade head is in the operative position.

4. Coating apparatus as defined in claim 1, said circulation means being characterized by:

a second pump coupled in series flow relation with said supply conduit for pumping liquid material from the supply drum to the doctor reservoir.

5. Coating apparatus as defined in claim 4, characterized in that the suction return flow rate provided by said first pump is greater than the supply flow rate provided by said second pump.

6. Coating apparatus as defined in claim 1, wherein the doctor blade head having first and second shoulders forming lower and upper liquid level boundaries for said reservoir, respectively, characterized in that said circulation means includes a return conduit coupled in flow communication with said reservoir at a liquid level location disposed intermediate the liquid level boundaries established by said first and second shoulders.

7. Coating apparatus as defined in claim 1, characterized in that a pneumatic conduit is coupled to the doctor reservoir for sensing air vacuum pressure within the doctor reservoir, and a vacuum gauge is coupled to the pneumatic conduit for providing a visual indication of air vacuum pressure in the doctor reservoir.

8. Coating apparatus as defined in claim 1, characterized in that a pneumatic conduit is coupled to the doctor reservoir for sensing air vacuum pressure within the doctor reservoir, a vacuum responsive switch having

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switch electrodes is coupled to said pneumatic sensor conduit, and an audio transducer is electrically connected to the switch electrodes for making and breaking an electrical circuit from a power source to said audio transducer.

9. Coating apparatus as defined in claim 1, characterized in that means are coupled to the doctor reservoir for supplying and evacuating liquid material to and from the doctor reservoir at differential flow rates, respectively, whereby a lower chamber region of the doctor reservoir is maintained in a filled condition and an upper chamber region of the reservoir is maintained in an evacuated condition.

10. Coating apparatus for applying liquid material from a supply drum to an applicator roller which is engagable in an operative position with a doctor blade head having an elongated reservoir for receiving liquid material from the supply drum, said doctor blade head being adapted to extend in parallel with the applicator roller in the operative position with a portion of the peripheral surface of the applicator roller extending into said reservoir for wetting contact with liquid material contained therein, and including doctor blade means attached to the doctor blade head for engagement against the peripheral surface of the applicator roller in the operative position, characterized in that:

circulation means are coupled to the doctor reservoir for inducing the flow of liquid material from said supply drum into the doctor reservoir and for returning liquid material by suction flow from the doctor reservoir to the supply drum; and

means are provided for mounting the coating apparatus on the side frame of a printing press adjacent to a transfer delivery cylinder, a liquid material coating blanket is secured to the transfer delivery cylinder, and including means for extending the applicator roller into engagement with the coating blanket in the operative position and for retracting the applicator roller out of engagement with the coating blanket in an idle position.

* * * * *

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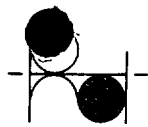
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TOP SECRET



Printing Research, Inc.

"Mark-less" Super Blue®

June 25, 1993

Mr. Bill Davis
Williamson Printing
PO Box 36622
6700 Denton Drive
Dallas TX 75235

214-904-2100 (Phone)

Dear Bill,

It was a great pleasure meeting with you and Bob Emrick. We have enclosed product information and the following **Super Blue** proposal for installation on your:

- Package 1
- A. Komori Lithrone, 6 color, 40 inch press
 - B. Komori Lithrone, 6 color, 40 inch press
 - C. OMCSA, 6 color, 40 inch press
 - D. OMCSA, 5 color, 40 inch press

- A **Super Blue** anti-marking system for installation at each of the wet transfers.

- Package 2 A, B, C & D presses as above
A & B

- A **Super Blue** anti-marking system for installation at the wet transfers.
- A **Super Blue** BV BacVac Delivery Vacuum Transfer System for installation at the delivery transfer.
- C & D
- A **Super Blue** anti-marking system for installation at the wet transfers.

- Package 3 Komori Lithrone, 6 color, 40 inch press

- A **Super Blue** PBC Plate/Blanket Coater for installation at the last printing unit.
- A **Super Blue** CII Combination II 2KW Air Knives and Exhaust Infra-Red Drying System for installation in the delivery.
- A **Super Blue** CUV 'Cold' UV Drying System for installation in the delivery.
- A **Super Blue** Vent-A-Hood System for installation on the delivery.
- A **Super Blue** HV High Velocity Hot Air Drying System for installation between printing units.

Page 2
Williamson Printing
June 25, 1993

Package 4 OMCSA, 2 color, 40 inch press

- A Super Blue PBC Plate/Blanket Coater on printing units one and for installation at the last printing unit.
- A Super Blue BV BacVac Delivery Vacuum Transfer System for installation between printing units and at the delivery transfer.
- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units and in the delivery.
- A Super Blue CUV 'Cold' UV Drying System for installation in the delivery.
- A Super Blue Vent-A-Hood System for installation on the delivery.

Package 5 Komori Lithrone, 6 color, 40 inch press

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.

We look forward to serving your needs and thank you for your interest in our **Super Blue** range of products.

Sincerely yours,

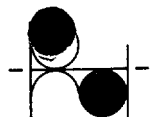


John Bird
Product Manager

JB:nw

Enclosure

cc: Bob Emrick - Williamson Printing
Steve Baker



Printing Research, Inc.

"Mark-less" Super Blue®

Williamson Printing
June 25, 1993

SUMMARY OF PROPOSAL

for
PACKAGE 1

<u>QTY</u>	<u>EQUIPMENT</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
	<u>A. KOMORI LITHRONE 6 COLOR, 40 INCH</u>		
6	SUPER BLUE DOUBLE SIZE TRANSFER/DELIVERY KITS	\$ 1,100.	\$ 6,600.
	<u>B. KOMORI LITHRONE 6 COLOR, 40 INCH</u>		
6	SUPER BLUE DOUBLE SIZE TRANSFER/DELIVERY KITS	1,100.	6,600.
	<u>C. OMCSA 6 COLOR, 40 INCH</u>		
	SUPER BLUE DOUBLE SIZE TRANSFER/DELIVERY KITS	1,100.	8,800.
	<u>D. OMCSA 5 COLOR, 40 INCH</u>		
	SUPER BLUE DOUBLE SIZE TRANSFER/DELIVERY KITS	1,100.	<u>6,600.</u>
	TOTAL EQUIPMENT (FOB Factory)		\$28,600.

FREIGHT PREPAID AND ADDED TO INVOICE, INSTALLATION AND
TRAINING CHARGED AT \$575. PER DAY PER MAN PLUS AIRFARES

<u>QTY</u>	<u>RECOMMENDED SPARE PARTS</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
1	NONE REQUIRED		

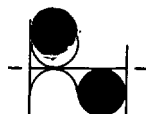
PROPOSAL, TERMS AND CONDITIONS OF SALE ON REVERSE SIDE ACCEPTED BY:

NAME _____

TITLE _____

SIGNATURE _____

DATE _____



Printing Research, Inc.

"Mark-less" Super Blue®

SB 093988
Williamson Printing
June 25, 1993

PROPOSAL

SUPER BLUE ANTI-MARKING SYSTEM PACKAGE 1

<u>QTY</u>	<u>EQUIPMENT</u>	<u>UNIT PRICE</u>	<u>EXTENTION</u>
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A. KOMORI LITHRONE, 6 COLOR, 40 INCH

6	Double Size Transfer/Delivery Kits @	\$1,100.	\$ 6,600.
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B. KOMORI LITHRONE, 6 COLOR, 40 INCH

6	Double Size Transfer/Delivery Kits @	\$1,100.	\$ 6,600.
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C. OMCSA, 6 COLOR, 40 INCH

8	Double Size Transfer/Delivery Kits @	\$1,100.	\$ 8,800.
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D. OMCSA, 5 COLOR, 40 INCH

6	Double Size Transfer/Delivery Kits @	\$1,100.	\$ 6,600.
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TRAINING AND INSTALLATION: (PER MAN/PER DAY PLUS AIRFARE)			\$ 575.
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Training and installation prices are based on performing work between 6:00 am and 6:00 pm. Work scheduled to begin other than between those times or on weekends is subject to a premium charge above the quoted price for training and installation.

PAYMENT TERMS AND/OR SPECIAL NOTATIONS:

30-day money back guarantee when training and installation is provided by Printing Research, Inc.

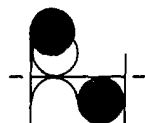
Terms are 1/3 prior to shipment, balance due in two equal payments 30 and 60 days after shipment with approved credit. Extended payment Program available to qualified participants offering below-market interest rate.

Prices and terms quoted above are valid for 60 days from the date of quotation. Pricing in this quote supersedes any previous quote you may have received. All prices are FOB Dallas, TX.

We will be happy to proceed immediately upon receipt of your approval.

Super Blue "Wash-Free" Anti-Marking System

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> Top grade machined aluminum delivery cylinder with frictionless cylinder surface to which is attached a movable ink and water repellant net covering preventing paper, water and ink from contacting with cylinder surface 	<ul style="list-style-type: none"> Virtually eliminates all marking Eliminates skeleton wheels and all associated systems, and adjustments i.e. star bars, bird cage arrangements Skeleton wheel adjustments are no longer necessary Avoids running oversized sheets for wheel placement Full cylinder gives better support to printed sheet Prevents re-stripping of jobs in order to have a place to run wheels Eliminates the need to run a wheel in the center of the sheet Press can be operated at maximum speeds More creative in layout (allows nesting), with no limitations 	<ul style="list-style-type: none"> Reduces paper waste and cost Full ink coverage even on coated stock Increased profitability and productivity Non-stop production with optimum profits Expanded customer base with paper savings
<ul style="list-style-type: none"> A frictionless base cover placed on transfer drums to which is attached a movable, ink and water repellant net covering preventing paper, water and ink from contacting with cylinder surface. 	<ul style="list-style-type: none"> Virtually eliminates all marking Reduces makeready Eliminates all transfer drum washing Aids in transferring difficult stock from unit to unit 	<ul style="list-style-type: none"> Reduces paper waste and cost Increased profitability and productivity Increased print flexibility
<ul style="list-style-type: none"> Vetiro mounting borders 	<ul style="list-style-type: none"> Quick and simple net replacement 	<ul style="list-style-type: none"> Minimized installation error
<ul style="list-style-type: none"> "Wash-free" nets and maintenance free base covers 	<ul style="list-style-type: none"> Near perfect total maintenance free system 	<ul style="list-style-type: none"> Increased productivity and profitability
<ul style="list-style-type: none"> Less than six month return on investment 	<ul style="list-style-type: none"> Sales force can sell benefits of "Mark-less" printing 	<ul style="list-style-type: none"> Excellent investment which yields more competitive pricing and expanded capabilities
<ul style="list-style-type: none"> Guaranteed to perform 	<ul style="list-style-type: none"> 30 day money back guarantee Endorsed by major press manufacturers Over 100,000 cylinders sold 	<ul style="list-style-type: none"> Risk free Peace of mind
<ul style="list-style-type: none"> Complete training of staff by PRI professionals (Including complete Instructions) 	<ul style="list-style-type: none"> Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> Increased productivity due to responsive training program by PRI Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

Williamson Printing
June 25, 1993

SUMMARY OF PROPOSAL

for
PACKAGE 2

<u>QTY</u>	<u>EQUIPMENT</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
	<u>A. KOMORI LITHRONE 6 COLOR, 40 INCH</u>		
1	SUPER BLUE BACVAC		
	VACUUM DELIVERY SYSTEM (BV)	\$ 11,611.	\$ 11,611.
5	SUPER BLUE DOUBLE SIZE		
	TRANSFER KITS	1,100.	5,500.
	<u>B. KOMORI LITHRONE 6 COLOR, 40 INCH</u>		
1	SUPER BLUE BACVAC		
	VACUUM DELIVERY SYSTEM (BV)	11,611.	11,611.
	SUPER BLUE DOUBLE SIZE		
	TRANSFER KITS	1,100.	5,500.
	<u>C. OMCSA 6 COLOR, 40 INCH</u>		
	SUPER BLUE DOUBLE SIZE		
	TRANSFER KITS	1,100.	8,800.
	<u>D. OMCSA 5 COLOR, 40 INC</u>		
	SUPER BLUE DOUBLE SIZE		
	TRANSFER KITS	1,100.	6,600.
	TOTAL EQUIPMENT (FOB Factory)		\$49,622.

FREIGHT PREPAID AND ADDED TO INVOICE, INSTALLATION AND
TRAINING CHARGED AT \$575. PER DAY PER MAN PLUS AIRFARES

<u>QTY</u>	<u>RECOMMENDED SPARE PARTS</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
1	NONE REQUIRED		

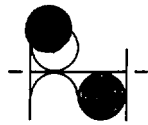
PROPOSAL, TERMS AND CONDITIONS OF SALE ON REVERSE SIDE ACCEPTED BY:

NAME

TITLE

SIGNATURE

DATE



Printing Research, Inc.

"Mark-less" Super Blue®

SB 093988
Williamson Printing
June 25, 1993

PROPOSAL

SUPER BLUE ANTI-MARKING SYSTEM PACKAGE 2

<u>QTY</u>	<u>EQUIPMENT</u>	<u>UNIT PRICE</u>	<u>EXTENTION</u>
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A. KOMORI LITHRONE, 6 COLOR, 40 INCH

5	Double Size Transfer Kits	@ \$ 1,100.	\$ 5,500.
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B. KOMORI LITHRONE, 6 COLOR, 40 INCH

5	Double Size Transfer Kits	@ \$ 1,100.	\$ 5,500.
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C. OMCSA, 6 COLOR, 40 INCH

8	Double Size Transfer Kits	@ \$ 1,100.	\$ 8,800.
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D. OMCSA, 5 COLOR, 40 INCH

6	Double Size Transfer Kits	@ \$ 1,000.	\$ 6,600.
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TRAINING AND INSTALLATION: (PER MAN/PER DAY PLUS AIRFARE)			\$ 575.
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Training and installation prices are based on performing work between 6:00 am and 6:00 pm. Work scheduled to begin other than between those times or on weekends is subject to a premium charge above the quoted price for training and installation.

PAYMENT TERMS AND/OR SPECIAL NOTATIONS:

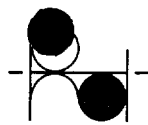
30-day money back guarantee when training and installation is provided by Printing Research, Inc.

Terms are 1/3 prior to shipment, balance due in two equal payments 30 and 60 days after shipment with approved credit. Extended payment Program available to qualified participants offering below-market interest rate.

Prices and terms quoted above are valid for 60 days from the date of quotation. Pricing in this quote supersedes any previous quote you may have received. All prices are FOB Dallas, TX. We will be happy to proceed immediately upon receipt of your approval.

Super Blue "Wash-Free" Anti-Marking System

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> Top grade machined aluminum delivery cylinder with frictionless cylinder surface to which is attached a movable ink and water repellant net covering preventing paper, water and ink from contacting with cylinder surface 	<ul style="list-style-type: none"> Virtually eliminates all marking Eliminates skeleton wheels and all associated systems, and adjustments i.e. star bars, bird cage arrangements Skeleton wheel adjustments are no longer necessary Avoids running oversized sheets for wheel placement Full cylinder gives better support to printed sheet Prevents re-stripping of jobs in order to have a place to run wheels Eliminates the need to run a wheel in the center of the sheet Press can be operated at maximum speeds More creative in layout (allows nesting), with no limitations 	<ul style="list-style-type: none"> Reduces paper waste and cost Full ink coverage even on coated stock Increased profitability and productivity Non-stop production with optimum profits Expanded customer base with paper savings
<ul style="list-style-type: none"> A frictionless base cover placed on transfer drums to which is attached a movable, ink and water repellant net covering preventing paper, water and ink from contacting with cylinder surface. 	<ul style="list-style-type: none"> Virtually eliminates all marking Reduces makeready Eliminates all transfer drum washing Aids in transferring difficult stock from unit to unit 	<ul style="list-style-type: none"> Reduces paper waste and cost Increased profitability and productivity Increased print flexibility
<ul style="list-style-type: none"> Velcro mounting borders 	<ul style="list-style-type: none"> Quick and simple net replacement 	<ul style="list-style-type: none"> Minimized installation error
<ul style="list-style-type: none"> "Wash-free" nets and maintenance free base covers 	<ul style="list-style-type: none"> Near perfect total maintenance free system 	<ul style="list-style-type: none"> Increased productivity and profitability
<ul style="list-style-type: none"> Less than six month return on investment 	<ul style="list-style-type: none"> Sales force can sell benefits of "Mark-less" printing 	<ul style="list-style-type: none"> Excellent investment which yields more competitive pricing and expanded capabilities
<ul style="list-style-type: none"> Guaranteed to perform 	<ul style="list-style-type: none"> 30 day money back guarantee Endorsed by major press manufacturers Over 100,000 cylinders sold 	<ul style="list-style-type: none"> Risk free Peace of mind
<ul style="list-style-type: none"> Complete training of staff by PRI professionals (Including complete Instructions) 	<ul style="list-style-type: none"> Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> Increased productivity due to responsive training program by PRI Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

BV 093988
Williamson Printing
June 25, 1993

PROPOSAL

PACKAGE 2

SUPER BLUE BACVAC DELIVERY VACUUM TRANSFER SYSTEM

<u>QTY</u>	<u>PRESS</u>	<u>PRICE</u>
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A. KOMORI LITHRONE, 6 COLOR, 40 INCH

1	BacVac Vacuum Delivery System	\$ 11,611.
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B. KOMORI LITHRONE, 6 COLOR, 40 INCH

1	BacVac Vacuum Delivery System	\$ 11,611.
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PURPOSE

- Optimized press speeds with minimal risk of marking varnish, water based or U.V. coatings.
- Stop unnecessary delivery wheel makeready.
- Eliminate starwheel and stop press adjustments.

APPLICATION

Paper, Card, Carton Board, Plastic, Foil

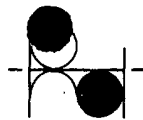
CONFIGURATION

A vacuum transfer system which eliminates marking completely for sheet fed presses. The press grippers pull the sheet, dry side against the BACVAC rollers, which are contoured to the original cylinder path. The vacuum holds the sheets against the rollers, ensuring that the printed and or coated side of the sheet does not come into contact with any surface whatsoever.

Enclosures: Sales Terms
Features Table

Super Blue BacVac

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> ✱ Vacuum Transfer System with frictionless free wheeling roller support 	<ul style="list-style-type: none"> ✱ Assures markfree printed or coated sheets at delivery transfer ✱ Provides ability to print or coat any thickness or grain direction of stock. ✱ Any stock adheres to vacuum transfer at full press speeds ✱ Decreases need to purchase special stock ✱ Non-printed or non-coated side of sheet is held by vacuum to the contour of the BacVac rollers ✱ Printed or coated side of sheet does not make contact with any surface ✱ Fully automatic, maintenance free, no adjustments ✱ No special tools, no stop press adjustments, no delivery adjustments necessary 	<ul style="list-style-type: none"> ✱ Optimized press speed assures higher productivity and profitability. ✱ Creates total flexibility in choice of stock ✱ Guaranteed quality of heavy ink coverage, varnished or coated work. ✱ Reduced spoilage and over runs ✱ Provides added value to finished sheets ✱ Maximizes ink, varnish or coating applications without marking ✱ Full coverage without scratching or marking. ✱ Eliminates make ready down time at delivery transfer increasing productivity and profitability
<ul style="list-style-type: none"> ✱ Energy efficient vacuum motor ✱ Automatic on/off 	<ul style="list-style-type: none"> ✱ Continuous controlled air flow ✱ No adjustments necessary 	<ul style="list-style-type: none"> ✱ Low cost energy consumption
<ul style="list-style-type: none"> ✱ Complete training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> ✱ Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> ✱ Increased productivity due to responsive training program by PRI ✱ Ability to produce saleable sheets immediately after training.



Printing Research, Inc.

"Mark-less" Super Blue®

Williamson Printing
June 25, 1993

SUMMARY OF PROPOSAL

for

PACKAGE 3

KOMORI LITHRONE 6 / 40

<u>QTY</u>	<u>EQUIPMENT</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
A 1	SUPER BLUE PLATE BLANKET COATER (PBC)	\$ 76,530.	\$ 76,530.
B 1	SUPER BLUE COMBINATION II 2KW AIR KNIVES EXHAUST IR DRYER (CII)	30,770.	30,770.
C 1	SUPER BLUE THREE LAMP 'COLD' UV DRYING SYSTEM (CUV)	87,806.	87,806.
D 1	SUPER BLUE VENT-A-HOOD EXHAUST SYSTEM (VH)	4,000.	4,000.
E 1	SUPER BLUE HIGH VELOCITY HOT AIR DRYING SYSTEM (HV)	39,992.	<u>39,992.</u>
TOTAL EQUIPMENT (FOB Factory)			\$239,098.
FREIGHT PREPAID AND ADDED TO INVOICE, INSTALLATION AND TRAINING CHARGED AT \$575. PER DAY PER MAN PLUS AIRFARES			

<u>QTY</u>	<u>RECOMMENDED SPARE PARTS</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
A 1	SPARE APPLICATOR ROLL (per inch)	70.	\$ 2,800.
1	SPARE METERING ROLL (per inch)	45.	1,800.
B 1	SPARE BOX OF LAMPS (10 per box)	104.	1,040.
C 3	SPARE U.V. LAMPS	338.	1,014.
2	FILTER TUBES	587.	1,174.
3	DEIONIZING RESIN CARTRIDGES	50.	150.
D/E	NONE REQUIRED		
TOTAL RECOMMENDED SPARE PARTS			\$ 7,978.

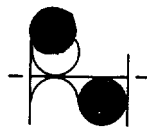
PROPOSAL, TERMS AND CONDITIONS OF SALE ON REVERSE SIDE ACCEPTED BY:

NAME

TITLE

SIGNATURE

DATE



Printing Research, Inc.

"Mark-less" Super Blue®

PBC 093988
Williamson Printing
June 25, 1993

PROPOSAL
PACKAGE 3

SUPER BLUE PBC PLATE AND BLANKET COATER

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>PRICE</u>
KOMORI LITHRONE	6 / 40	\$ 76,530.

RECOMMENDED SPARE PARTS:

Spare Rolls:	Applicator (per inch)	\$ 70.
	Metering (per inch)	\$ 45.
Spare Pump Stand:	If intention is to run both aqueous and UV	\$ 4,000.

PURPOSE

Application of aqueous or UV coatings to either the plate or blanket cylinder of a press unit, for spot or area coating with exceptional uniformity, clean edges and precise registration.

APPLICATION

Paper, Card, Carton Board, Corrugated, Plastic, Foil

CONFIGURATION

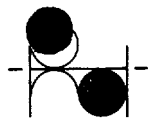
Speed control is maintained via throttling valves mounted on the control cabinet. Start/stop controls are interlocked with press controls to suit. All rolls are variable speed and are ramped to match the selected percentage of surface speed. Applicator roll normally drives slower than plate or blanket surface speed, while metering roll and pick up or pan roll are always less than the applicator. The applicator roll automatically follows the direction of the plate or blanket.

The metering and applicator rollers are rubber, while the pick up roll is chromed microfinished. The metering roll has left and right hand adjustments for on-off contact with pick-up roll and independent manual screw adjustments to set profile. Each roll has vernier indicators for gap adjustment. A stainless steel coater pan is designed for recirculation of coating via a diaphragm pump with a large diameter hose used to return the coating to a 55 gallon drum. The diaphragm pump is plumbed and is installed on a stainless steel coating drum cover incorporating a hinged plexiglass viewing window and an adjustable, audible, and visual warning system.

Enclosures: Sales Terms
Features Table

Super Blue PBC Plate Blanket Coater

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> Fully retractable Spot Plate or Blanket coating 	<ul style="list-style-type: none"> Ability to spot or overall coat In-line coating flexibility without dedicating the last printing unit to coating 	<ul style="list-style-type: none"> Maximum utilization of printing units
<ul style="list-style-type: none"> Application of coating from plate cylinder 	<ul style="list-style-type: none"> Elimination of lengthy downtime due to registering coating to image Negates need to cut blankets while press down Sharp clean, crisp image definition Water-based coating can replace and surpass press varnish Coatings have higher scuff resistance than press varnish and are non-yellowing 	<ul style="list-style-type: none"> Simple precise register control Increased productivity and profitability Insurmountable quality Value added to printed sheets Increased product durability and cosmetic quality
<ul style="list-style-type: none"> Application of coating from blanket cylinder 	<ul style="list-style-type: none"> Fast makeready since overall coating directly applied from blanket cylinder Heavy overall coating film weights easily applied Functional coatings such as remoistenable gum and blister pack coatings easily applied 	<ul style="list-style-type: none"> Increased productivity and profitability Optimizing gloss and physical properties Added value to printed work and increased product range capabilities
<ul style="list-style-type: none"> Sheer application of coatings 	<ul style="list-style-type: none"> Uniform thickness of coating from the plate cylinder Minimizes slinging or misting of coatings Allows the widest range of viscosities to be used Water based coatings will stay open indefinitely on coater while circulating 	<ul style="list-style-type: none"> The best coating lay characteristics for optimized added value Prevents costly cleanups Optimizes gloss and physical properties Minimizes downtime through wash-ups, operators can concentrate on press operation creating higher productivity
<ul style="list-style-type: none"> Coating pump stand with run dry protection 	<ul style="list-style-type: none"> Visual and audible warning of low coating level in barrel 	<ul style="list-style-type: none"> Complete operator awareness alert and non-stop production
<ul style="list-style-type: none"> Complete training of staff by PRI professionals (Including complete Operator's and Pre-Installation Manuals) 	<ul style="list-style-type: none"> Knowledgeable operators at completion of installation and training Recommendation of all production consumables available for start-up. 	<ul style="list-style-type: none"> Increased productivity due to responsive training program by PRI Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

CII 093988

Williamson Printing

June 25, 1993

**PROPOSAL
PACKAGE 3**

SUPER BLUE COMBINATION II 2KW AIR KNIVES/EXHAUST IR DRYER

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>MAX KW OUTPUT</u>	<u>PRICE</u>
KOMORI LITHRONE	6 / 40	48	\$ 30,770.

RECOMMENDED SPARE PARTS:

2KW Lamps (10 lamps per box) \$ 1,040.

PURPOSE

Accelerates the drying of inks, reduces the need for spray powder, dries aqueous coatings on paper, card, corrugated and carton board.

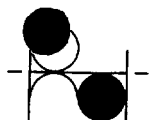
CONFIGURATION

The unique Super Blue Combination II infra-red dryer is installed in the delivery of the press with 18 inch 2KW short wave infra-red lamps. The dryer is linked to impression of the press and automatically switches lamps off when the press is off impression and automatically switches lamps on when the press is on impression. The lamp ends are cooled with air which is ducted through airknives built into the dryer and a separate airknife is also supplied to drive moisture off the sheet surface. A separately supplied exhaust system ensures no build up of moisture within the drying area of the press. A water cooled reflector pan with a closed loop heat exchanger further protects the press and printed work. Standard control system including diagnostics and thermometer is supplied as a press mounting module.

Enclosures: Sales Terms
Features Table

Super Blue Combination II Air Knives/Exhaust Infra-Red Dryer

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> ★ Combination of air knives/exhaust and shortwave infra-red 	<ul style="list-style-type: none"> ★ Assures accelerated drying of ink ★ Minimizes spray powder consumption ★ Assures drying of water based coatings ★ Most effective in driving moisture out of ink and coating ★ High scrubbing action of air knives makes removal of moisture laden air easily achievable ★ Will not dry out stock, will not shrink sheet, will not cause loss of register for 2nd pass or post press operations 	<ul style="list-style-type: none"> ★ Increases productivity and profitability ★ Assures highest quality levels for value added
<ul style="list-style-type: none"> ★ Unique 18 inch 2kw short wave infra-red lamps ★ Lamp life rated at 5000 hours and are individually replaceable 	<ul style="list-style-type: none"> ★ Desired stack temperatures easily achieved on any stock at full press speeds ★ 25% more energy output and 50% more dwell time than any other dryer ★ Instantaneous on/off response - less than 1 second ★ Longer life, less maintenance 	<ul style="list-style-type: none"> ★ Highest possible productivity ★ Improve lay characteristics of coatings ★ Maximum energy efficiency ★ Optimizes energy efficiency ★ Improved safety. Minimal chance of fire if sheet touches lamps ★ Cost effective, economical
<ul style="list-style-type: none"> ★ Water cooled (closed loop) reflector plate 	<ul style="list-style-type: none"> ★ Prevents heat build-up of delivery pan ★ No special plumbing needed 	<ul style="list-style-type: none"> ★ Assures controllable stack temperature for greater efficiency. ★ Prevents damage to press mechanisms. ★ Prevents metal fatigue
<ul style="list-style-type: none"> ★ Complete training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> ★ Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> ★ Increased productivity due to responsive training program by PRI ★ Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

CUV 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 3**

SUPER BLUE 'COLD' UV DRYING SYSTEM

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>LAMPS</u>	<u>RATING</u>	<u>PRICE</u>
KOMORI LITHRONE	6 / 40	3	300 watt/inch	\$ 87,806.

RECOMMENDED SPARE PARTS:

UV Lamps (each)	\$338.
Filter Tubes (each)	\$587.
Deionizing Resin Cartridge (each)	\$ 50.

PURPOSE

Curing (drying) UV inks, varnishes or coating on sheet or web fed presses.

APPLICATION

Paper, Card, Carton Board, Corrugated, Plastic, Foil

CONFIGURATION

Curing heads are linked to impression of press and automatically switch to standby mode when press is off impression for five minutes. If no further action is taken, then lamps automatically turn off; if the press is put back into impression, the lamps automatically return to full power.

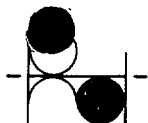
Standard Control Unit contains all necessary switchgear and controls to provide individual lamp selection, full and reduced individual power switching, elapsed life meters, lamp indicators and emergency stop button.

Main power transformer, capacitor banks and closed loop exchanger plant are supplied as floor standing modules. Full safety interlock circuits are fitted throughout. Ozone and heat extraction from the press are not normally required.

Enclosures: Sales Terms
Features Table

SUPER BLUE 'COLD' UV DRYING SYSTEM

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> ★ Quartz Filter Tubes carrying deionized distilled water 	<ul style="list-style-type: none"> ★ Allows 98-99% of the UV to pass through ★ Filters most of the unwanted heat ★ Ensures low stack temperatures 	<ul style="list-style-type: none"> ★ Maximizes curing efficiency which results in full production press speeds ★ Minimizes risk of fire and resultant downtime ★ Eliminates risk of distortion of heat sensitive stock
<ul style="list-style-type: none"> ★ Closed Loop Deionizing chilled water system 	<ul style="list-style-type: none"> ★ Allows complete temperature control of water recirculation system 	<ul style="list-style-type: none"> ★ No costly losses of heating or cooling energy from the plant
<ul style="list-style-type: none"> ★ Low Volume Compressed Air Lamp Cooling 	<ul style="list-style-type: none"> ★ Ensures minimal ozone production ★ Ensures lamp running temperatures are precise 	<ul style="list-style-type: none"> ★ Creates a safe work place environment meeting all OSHA and EPA standards ★ Assures optimum efficiency level of UV output
<ul style="list-style-type: none"> ★ Heat Exhaust System (HES) installed between printing units 	<ul style="list-style-type: none"> ★ Reduces heat build-up created by chemical reaction of inks ★ Reduces tack levels of ink ★ Prevents heat build-up between printing units 	<ul style="list-style-type: none"> ★ Eliminates expensive downtime caused by ink piling on the blankets ★ Decreases risk of hickies and the cost of downtime to remove hickies on work and turn ★ Protects press functions and operators
<ul style="list-style-type: none"> ★ Water cooled UV lamp head and delivery reflector pan 	<ul style="list-style-type: none"> ★ Absorbs most of the unwanted heat ★ Prevents heat build-up of delivery stack 	<ul style="list-style-type: none"> ★ Prevents risk of press damage ★ Eliminates risk of stock distortion in stack ★ Decreases risk of waste sheets caused by offsetting of C2S stock when printed or coated first side
<ul style="list-style-type: none"> ★ Complete Training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> ★ Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> ★ Increased productivity due to responsive training program by PRI ★ Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

VH 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 3**

SUPER BLUE VENT-A HOOD EXHAUST SYSTEM

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>COATING/DRYING</u>	<u>PRICE</u>
KOMORI LITHRONE	6 / 40	PBC/CH	\$ 4,000.

PURPOSE

To be installed on the delivery of the press to exhaust moisture laden air, lowering the humidity within the delivery area. Reduces the need for spray powder increasing the efficiency of the existing dryer.

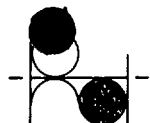
FEATURES

This specially designed exhaust system utilizes a high output fan with variable power speed control at the delivery of your press. The Vent-A-Hood exhaust helps minimize the build up of moisture within the drying area of the press.

BENEFITS

- Enhances the capabilities of your current dryer.
- Help remove excess spray powder.
- Minimizes unpleasant odors at the delivery.
- Reduces the need for spray powder.

Enclosures: Sales Terms
Features Table



Printing Research, Inc.

"Mark-less" Super Blue®

HV 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 3**

SUPER BLUE HV™ HIGH VELOCITY HOT AIR DRYING SYSTEM

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>MAX KW OUTPUT</u>	<u>MAXIMUM CFM/ HEAT OUTPUT</u>	<u>PRICE</u>
KOMORI LITHRONE	6 / 40	42 Per Cabinet	650/250°F Per Cabinet	\$ 39,992. Per Cabinet

One HV cabinet feeding air knives and exhaust between printing units 1/2, 2/3, 5/6

PURPOSE

- Allow work and turn and post processing in minutes, not hours.
- Flashing off solvent and water in conventional inks between printing units.
- Minimize if not eliminate spray powder, when coating.
- Minimizing gloss back or dry back when coating.
- Enhancing drying of inks.
- Improving coating lay.
- Drying aqueous coatings between printing units prior to spot coating.
- Improving paper stability.

APPLICATION

Paper, Card, Carton Board, Corrugated

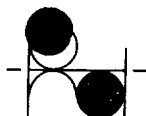
CONFIGURATION

- Air knives, exhaust and mounting brackets, with HV cabinet and pre-heater.
- HV cabinet contains switch gear and control components.
- Controls are interlocked with printing impression and emergency stop which turns dyers on and off.
- Dryer and electrical control cabinet are prewired to terminal boards to allow for faster installation.

Enclosures: Sales Terms
Features Table

Super Blue HVL High Velocity Hot Air Drying System

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> ★ High velocity hot air knives ★ Air knife exhaust system 	<ul style="list-style-type: none"> ★ Scrubs volatiles such as water and alcohol from paper surface and ink film prior to coating ★ Reduces drying time of ink under coating ★ Minimizes if not eliminates spray powder when coating ★ Provides ability to print and coat full loads at optimum press speeds ★ Increases temperature of stock which reduces viscosity of coating on contact ★ Dries water based coating at various positions on the press ★ Ink applied by previous unit is set ★ Removes volatiles from press and production area 	<ul style="list-style-type: none"> ★ Increases gloss levels of coatings by minimizing dry back ★ Minimizes downtime by allowing faster commencement of work and turn and post press operations ★ Increased productivity due to less press maintenance ★ Dramatically increases productivity and profitability ★ Optimizes gloss levels ★ Allows for coating application with near perfect lay characteristics ★ Increases variety of saleable product ★ Improved dot definition ★ Better ink trapping ★ Helps prevent gas ghosting ★ Decreases drying or setting time ★ Protects press functions and operators
<ul style="list-style-type: none"> ★ Time delay on air knife and exhaust knife shut-off 	<ul style="list-style-type: none"> ★ Interstation areas are completely heat evacuated when press is stopped 	<ul style="list-style-type: none"> ★ Comfortable operator makeready and wash-up environment ★ Comprehensive press protection
<ul style="list-style-type: none"> ★ Complete training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> ★ Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> ★ Increased productivity due to responsive training program by PRI ★ Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

Williamson Printing
June 28, 1993

SUMMARY OF PROPOSAL

for

PACKAGE 4

OMCSA 2 / 40

<u>QTY</u>	<u>EQUIPMENT</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
A 2	SUPER BLUE PLATE BLANKET COATER (PBC)	\$ 76,530.	\$153,060.
B 1	SUPER BLUE BACVAC VACUUM DELIVERY SYSTEM (BV)	12,586.	12,586.
C 1	SUPER BLUE HIGH VELOCITY HOT AIR DRYING SYSTEM (HV)	39,992.	39,992.
D 1	SUPER BLUE THREE LAMP 'COLD' UV DRYING SYSTEM (CUV)	87,806.	87,806.
E 1	SUPER BLUE VENT-A-HOOD EXHAUST SYSTEM (VH)	4,000.	<u>4,000.</u>
TOTAL EQUIPMENT (FOB Factory)			\$297,444.
FREIGHT PREPAID AND ADDED TO INVOICE, INSTALLATION AND TRAINING CHARGED AT \$575. PER DAY PER MAN PLUS AIRFARES			
<u>QTY</u>	<u>RECOMMENDED SPARE PARTS</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
A 1	SPARE APPLICATOR ROLL (per inch)	70.	\$ 2,800.
1	SPARE METERING ROLL (per inch)	45.	1,800.
B/C/E	NONE REQUIRED		-----
D 3	SPARE U.V. LAMPS	338.	1,014.
2	FILTER TUBES	587.	1,174.
3	DEIONIZING RESIN CARTRIDGES	50.	<u>150.</u>
TOTAL RECOMMENDED SPARE PARTS			\$ 6,938.

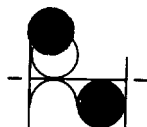
PROPOSAL, TERMS AND CONDITIONS OF SALE ON REVERSE SIDE ACCEPTED BY:

NAME

TITLE

SIGNATURE

DATE



Printing Research, Inc.

"Mark-less" Super Blue®

PBC 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 4**

SUPER BLUE PBC PLATE AND BLANKET COATER

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>PRICE</u>
OMCSA	2 / 40	\$ 76,530. (each)

One on printing unit one and one on printing unit two

RECOMMENDED SPARE PARTS:

Spare Rolls:	Applicator (per inch)	\$ 70.
	Metering (per inch)	\$ 45.
Spare Pump Stand:	If intention is to run both aqueous and UV	\$ 4,000.

PURPOSE

Application of aqueous or UV coatings to either the plate or blanket cylinder of a press unit, for spot or area coating with exceptional uniformity, clean edges and precise registration.

APPLICATION

Paper, Card, Carton Board, Corrugated, Plastic, Foil

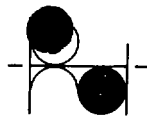
CONFIGURATION

Speed control is maintained via throttling valves mounted on the control cabinet. Start/stop controls are interlocked with press controls to suit. All rolls are variable speed and are ramped to match the selected percentage of surface speed. Applicator roll normally drives slower than plate or blanket surface speed, while metering roll and pick up or pan roll are always less than the applicator. The applicator roll automatically follows the direction of the plate or blanket.

The metering and applicator rollers are rubber, while the pick up roll is chromed microfinished. The metering roll has left and right hand adjustments for on-off contact with pick-up roll and independent manual screw adjustments to set profile. Each roll has vernier indicators for gap adjustment. A stainless steel coater pan is designed for recirculation of coating via a diaphragm pump with a large diameter hose used to return the coating to a 55 gallon drum. The diaphragm pump is plumbed and is installed on a stainless steel coating drum cover incorporating a hinged plexiglass viewing window and an adjustable, audible, and visual warning system.

Super Blue PBC Plate Blanket Coater

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> Fully retractable Spot Plate or Blanket coating 	<ul style="list-style-type: none"> Ability to spot or overall coat In-line coating flexibility without dedicating the last printing unit to coating 	<ul style="list-style-type: none"> Maximum utilization of printing units
<ul style="list-style-type: none"> Application of coating from plate cylinder 	<ul style="list-style-type: none"> Elimination of lengthy downtime due to registering coating to image Negates need to cut blankets while press down Sharp clean, crisp image definition Water-based coating can replace and surpass press varnish Coatings have higher scuff resistance than press varnish and are non-yellowing 	<ul style="list-style-type: none"> Simple precise register control Increased productivity and profitability Insurmountable quality Value added to printed sheets Increased product durability and cosmetic quality
<ul style="list-style-type: none"> Application of coating from blanket cylinder 	<ul style="list-style-type: none"> Fast makeready since overall coating directly applied from blanket cylinder Heavy overall coating film weights easily applied Functional coatings such as remoistenable gum and blister pack coatings easily applied 	<ul style="list-style-type: none"> Increased productivity and profitability Optimizing gloss and physical properties Added value to printed work and increased product range capabilities
<ul style="list-style-type: none"> Sheer application of coatings 	<ul style="list-style-type: none"> Uniform thickness of coating from the plate cylinder Minimizes slinging or misting of coatings Allows the widest range of viscosities to be used Water based coatings will stay open indefinitely on coater while circulating 	<ul style="list-style-type: none"> The best coating lay characteristics for optimized added value Prevents costly cleanups Optimizes gloss and physical properties Minimizes downtime through wash-ups, operators can concentrate on press operation creating higher productivity
<ul style="list-style-type: none"> Coating pump stand with run dry protection 	<ul style="list-style-type: none"> Visual and audible warning of low coating level in barrel 	<ul style="list-style-type: none"> Complete operator awareness alert and non-stop production
<ul style="list-style-type: none"> Complete training of staff by PRI professionals (Including complete Operator's and Pre-Installation Manuals) 	<ul style="list-style-type: none"> Knowledgeable operators at completion of installation and training Recommendation of all production consumables available for start-up. 	<ul style="list-style-type: none"> Increased productivity due to responsive training program by PRI Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

BV 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 4**

SUPER BLUE BACVAC DELIVERY VACUUM TRANSFER SYSTEM

PRESS

COLOR/SIZE

PRICE

OMCSA

2 / 40

\$ 12,586.

PURPOSE

- Optimized press speeds with minimal risk of marking varnish, water based or U.V. coatings.
- Stop unnecessary delivery wheel makeready.
- Eliminate starwheel and stop press adjustments.

APPLICATION

Paper, Card, Carton Board, Plastic, Foil

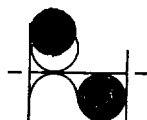
CONFIGURATION

A vacuum transfer system which eliminates marking completely for sheet fed presses. The press grippers pull the sheet, dry side against the BACVAC rollers, which are contoured to the original cylinder path. The vacuum holds the sheets against the rollers, ensuring that the printed and or coated side of the sheet does not come into contact with any surface whatsoever.

Enclosures: Sales Terms
Features Table

Super Blue BacVac

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> ❖ Vacuum Transfer System with frictionless free wheeling roller support 	<ul style="list-style-type: none"> ❖ Assures markfree printed or coated sheets at delivery transfer ❖ Provides ability to print or coat any thickness or grain direction of stock. ❖ Any stock adheres to vacuum transfer at full press speeds ❖ Decreases need to purchase special stock ❖ Non-printed or non-coated side of sheet is held by vacuum to the contour of the BacVac rollers ❖ Printed or coated side of sheet does not make contact with any surface ❖ Fully automatic, maintenance free, no adjustments ❖ No special tools, no stop press adjustments, no delivery adjustments necessary 	<ul style="list-style-type: none"> ❖ Optimized press speed assures higher productivity and profitability. ❖ Creates total flexibility in choice of stock ❖ Guaranteed quality of heavy ink coverage, varnished or coated work. ❖ Reduced spoilage and over runs ❖ Provides added value to finished sheets ❖ Maximizes ink, varnish or coating applications without marking ❖ Full coverage without scratching or marking. ❖ Eliminates make ready down time at delivery transfer increasing productivity and profitability
<ul style="list-style-type: none"> ❖ Energy efficient vacuum motor ❖ Automatic on/off 	<ul style="list-style-type: none"> ❖ Continuous controlled air flow ❖ No adjustments necessary 	<ul style="list-style-type: none"> ❖ Low cost energy consumption
<ul style="list-style-type: none"> ❖ Complete training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> ❖ Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> ❖ Increased productivity due to responsive training program by PRI ❖ Ability to produce saleable sheets immediately after training.



Printing Research, Inc.

"Mark-less" Super Blue®

HV 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 4**

SUPER BLUE HV™ HIGH VELOCITY HOT AIR DRYING SYSTEM

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>MAX KW OUTPUT</u>	<u>MAXIMUM CFM/ HEAT OUTPUT</u>	<u>PRICE</u>
OMCSA	2 / 40	42 Per Cabinet	650/250°F Per Cabinet	\$ 39,992. Per Cabinet

One HV cabinet feeding air knives and exhaust between printing units 1/2, delivery

PURPOSE

- Allow work and turn and post processing in minutes, not hours.
- Flashing off solvent and water in conventional inks between printing units.
- Minimize if not eliminate spray powder, when coating.
- Minimizing gloss back or dry back when coating.
- Enhancing drying of inks.
- Improving coating lay.
- Drying aqueous coatings between printing units prior to spot coating.
- Improving paper stability.

APPLICATION

Paper, Card, Carton Board, Corrugated

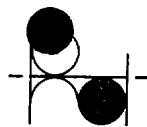
CONFIGURATION

- Air knives, exhaust and mounting brackets, with HV cabinet and pre-heater.
- HV cabinet contains switch gear and control components.
- Controls are interlocked with printing impression and emergency stop which turns dyers on and off.
- Dryer and electrical control cabinet are prewired to terminal boards to allow for faster installation.

**Enclosures: Sales Terms
Features Table**

Super Blue HVL High Velocity Hot Air Drying System

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> ✱ High velocity hot air knives ✱ Air knife exhaust system 	<ul style="list-style-type: none"> ✱ Scrubs volatiles such as water and alcohol from paper surface and ink film prior to coating ✱ Reduces drying time of ink under coating ✱ Minimizes if not eliminates spray powder when coating ✱ Provides ability to print and coat full loads at optimum press speeds ✱ Increases temperature of stock which reduces viscosity of coating on contact ✱ Dries water based coating at various positions on the press ✱ Ink applied by previous unit is set ✱ Removes volatiles from press and production area 	<ul style="list-style-type: none"> ✱ Increases gloss levels of coatings by minimizing dry back ✱ Minimizes downtime by allowing faster commencement of work and turn and post press operations ✱ Increased productivity due to less press maintenance ✱ Dramatically increases productivity and profitability ✱ Optimizes gloss levels ✱ Allows for coating application with near perfect lay characteristics ✱ Increases variety of saleable product ✱ Improved dot definition ✱ Better ink trapping ✱ Helps prevent gas ghosting ✱ Decreases drying or setting time ✱ Protects press functions and operators
<ul style="list-style-type: none"> ✱ Time delay on air knife and exhaust knife shut-off 	<ul style="list-style-type: none"> ✱ Interstation areas are completely heat evacuated when press is stopped 	<ul style="list-style-type: none"> ✱ Comfortable operator makeready and wash-up environment ✱ Comprehensive press protection
<ul style="list-style-type: none"> ✱ Complete training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> ✱ Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> ✱ Increased productivity due to responsive training program by PRI ✱ Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

CUV 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 4**

SUPER BLUE 'COLD' UV DRYING SYSTEM

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>LAMPS</u>	<u>RATING</u>	<u>PRICE</u>
OMSCA	2 / 40	3	300 watt/inch	\$ 87,806.

RECOMMENDED SPARE PARTS:

UV Lamps (each)	\$338.
Filter Tubes (each)	\$587.
Deionizing Resin Cartridge (each)	\$ 50.

PURPOSE

Curing (drying) UV inks, varnishes or coating on sheet or web fed presses.

APPLICATION

Paper, Card, Carton Board, Corrugated, Plastic, Foil

CONFIGURATION

Curing heads are linked to impression of press and automatically switch to standby mode when press is off impression for five minutes. If no further action is taken, then lamps automatically turn off; if the press is put back into impression, the lamps automatically return to full power.

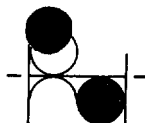
Standard Control Unit contains all necessary switchgear and controls to provide individual lamp selection, full and reduced individual power switching, elapsed life meters, lamp indicators and emergency stop button.

Main power transformer, capacitor banks and closed loop exchanger plant are supplied as floor standing modules. Full safety interlock circuits are fitted throughout. Ozone and heat extraction from the press are not normally required.

Enclosures: Sales Terms
Features Table

SUPER BLUE 'COLD' UV DRYING SYSTEM

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> Quartz Filter Tubes carrying deionized distilled water 	<ul style="list-style-type: none"> Allows 98-99% of the UV to pass through Filters most of the unwanted heat Ensures low stack temperatures 	<ul style="list-style-type: none"> Maximizes curing efficiency which results in full production press speeds Minimizes risk of fire and resultant downtime Eliminates risk of distortion of heat sensitive stock
<ul style="list-style-type: none"> Closed Loop Deionizing chilled water system 	<ul style="list-style-type: none"> Allows complete temperature control of water recirculation system 	<ul style="list-style-type: none"> No costly losses of heating or cooling energy from the plant
<ul style="list-style-type: none"> Low Volume Compressed Air Lamp Cooling 	<ul style="list-style-type: none"> Ensures minimal ozone production Ensures lamp running temperatures are precise 	<ul style="list-style-type: none"> Creates a safe work place environment meeting all OSHA and EPA standards Assures optimum efficiency level of UV output
<ul style="list-style-type: none"> Heat Exhaust System (HES) installed between printing units 	<ul style="list-style-type: none"> Reduces heat build-up created by chemical reaction of inks Reduces tack levels of ink Prevents heat build-up between printing units 	<ul style="list-style-type: none"> Eliminates expensive downtime caused by ink piling on the blankets Decreases risk of hickies and the cost of downtime to remove hickies on work and turn Protects press functions and operators
<ul style="list-style-type: none"> Water cooled UV lamp head and delivery reflector pan 	<ul style="list-style-type: none"> Absorbs most of the unwanted heat Prevents heat build-up of delivery stack 	<ul style="list-style-type: none"> Prevents risk of press damage Eliminates risk of stock distortion in stack Decreases risk of waste sheets caused by offsetting of C2S stock when printed or coated first side
<ul style="list-style-type: none"> Complete Training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> Increased productivity due to responsive training program by PRI Ability to produce saleable sheets immediately after training



Printing Research, Inc.

"Mark-less" Super Blue®

VH 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 4**

SUPER BLUE VENT-A HOOD EXHAUST SYSTEM

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>COATING/DRYING</u>	<u>PRICE</u>
OMCSA	2 / 40	PBC/HV-CUV	\$ 4,000.

PURPOSE

To be installed on the delivery of the press to exhaust moisture laden air, lowering the humidity within the delivery area. Reduces the need for spray powder increasing the efficiency of the existing dryer.

FEATURES

This specially designed exhaust system utilizes a high output fan with variable power speed control at the delivery of your press. The Vent-A-Hood exhaust helps minimize the build up of moisture within the drying area of the press.

BENEFITS

- Enhances the capabilities of your current dryer.
- Help remove excess spray powder.
- Minimizes unpleasant odors at the delivery.
- Reduces the need for spray powder.

Enclosures: Sales Terms
Features Table

1 CUSTOMER FURNISHED ROOF VENTILATION,
CAP & ROOF SEAL.

6 CUSTOMER FURNISHED 6" VENT PIPE
FROM DRYER CABINET TO MAIN DUCT

INPUT POWER

7 CUSTOMER FURNISHED
ELECTRICAL

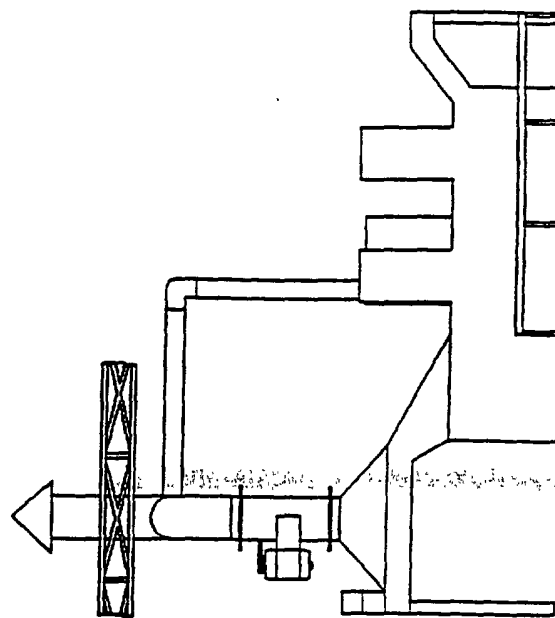
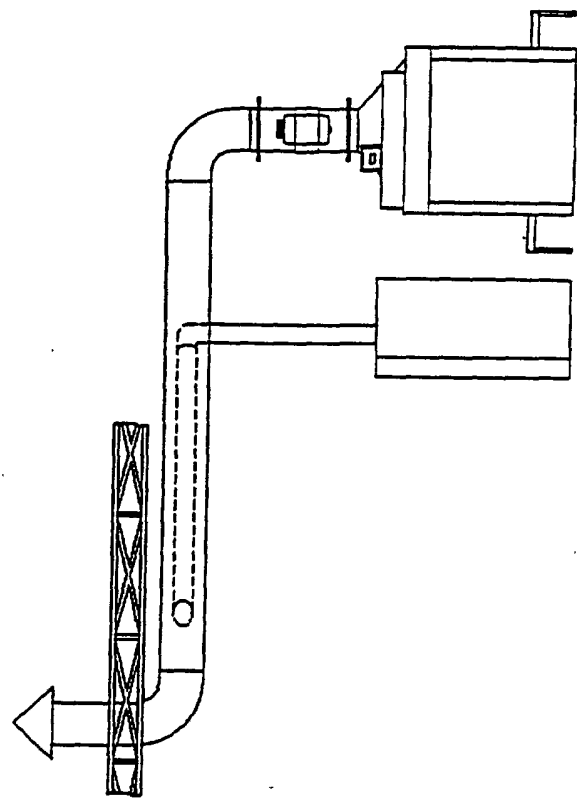
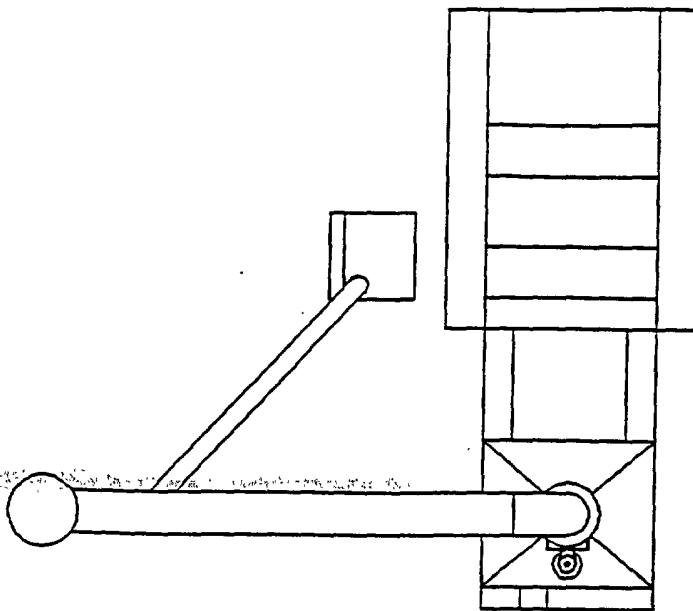
2 CUSTOMER FURNISHED
METAL DUCTING, CLAMPS ETC.

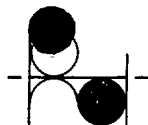
4 PRI FURNISHED
AC VARI DRIVE

3 PRI FURNISHED
TUBEXIAL FAN
12" OR 18" & 3 PHASE
MOTOR, BELTS ETC.

5 PRI FURNISHED CUSTOM DESIGN
VENT-A-HOOD, WITH ACCESS DOORS,
& MTG. HDW. ETC.

THESE 95/5T60





Printing Research, Inc.

"Mark-less" Super Blue®

Williamson Printing
June 25, 1993

SUMMARY OF PROPOSAL
PACKAGE 5

KOMORI LITHRONE 6 / 40

<u>QTY</u>	<u>EQUIPMENT</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
2	SUPER BLUE HIGH VELOCITY HOT AIR DRYER SYSTEM (HV)	\$ 39,992.	<u>\$ 79,984.</u>

TOTAL EQUIPMENT (FOB Factory)

\$ 79,984.

FREIGHT PREPAID AND ADDED TO INVOICE, INSTALLATION AND
TRAINING CHARGED AT \$575. PER DAY PER MAN PLUS AIRFARES

<u>QTY</u>	<u>RECOMMENDED SPARE PARTS</u>	<u>UNIT PRICE</u>	<u>EXTENSION</u>
	NONE REQUIRED		

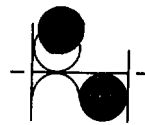
PROPOSAL, TERMS AND CONDITIONS OF SALE ON REVERSE SIDE ACCEPTED BY:

NAME

TITLE

SIGNATURE

DATE



Printing Research, Inc.

"Mark-less" Super Blue®

HV 093988
Williamson Printing
June 25, 1993

**PROPOSAL
PACKAGE 5**

SUPER BLUE HV™ HIGH VELOCITY HOT AIR DRYING SYSTEM

<u>PRESS</u>	<u>COLOR/SIZE</u>	<u>MAX KW OUTPUT</u>	<u>MAXIMUM CFM/ HEAT OUTPUT</u>	<u>PRICE</u>
KOMORI LITHRONE	6 / 40	42 Per Cabinet	650/250°F Per Cabinet	\$ 39,992. Per Cabinet

One HV cabinet feeding air knives and exhaust between printing units 1/2, 2/3, 3/4
One HV cabinet feeding air knives and exhaust between printing units 4/5, 5/6

PURPOSE

- Allow work and turn and post processing in minutes, not hours.
- Flashing off solvent and water in conventional inks between printing units.
- Minimize if not eliminate spray powder, when coating.
- Minimizing gloss back or dry back when coating.
- Enhancing drying of inks.
- Improving coating lay.
- Drying aqueous coatings between printing units prior to spot coating.
- Improving paper stability.

APPLICATION

Paper, Card, Carton Board, Corrugated

CONFIGURATION

- Air knives, exhaust and mounting brackets, with HV cabinet and pre-heater.
- HV cabinet contains switch gear and control components.
- Controls are interlocked with printing impression and emergency stop which turns dyes on and off.
- Dryer and electrical control cabinet are prewired to terminal boards to allow for faster installation.

Enclosures: Sales Terms
Features Table

Super Blue HVL High Velocity Hot Air Drying System

FEATURES	ADVANTAGES	BENEFITS
<ul style="list-style-type: none"> ★ High velocity hot air knives 	<ul style="list-style-type: none"> ★ Scrubs volatiles such as water and alcohol from paper surface and ink film prior to coating ★ Reduces drying time of ink under coating ★ Minimizes if not eliminates spray powder when coating ★ Provides ability to print and coat full loads at optimum press speeds ★ Increases temperature of stock which reduces viscosity of coating on contact ★ Dries water based coating at various positions on the press ★ Ink applied by previous unit is set 	<ul style="list-style-type: none"> ★ Increases gloss levels of coatings by minimizing dry back ★ Minimizes downtime by allowing faster commencement of work and turn and post press operations ★ Increased productivity due to less press maintenance ★ Dramatically increases productivity and profitability ★ Optimizes gloss levels ★ Allows for coating application with near perfect lay characteristics ★ Increases variety of saleable product ★ Improved dot definition ★ Better ink trapping ★ Helps prevent gas ghosting
<ul style="list-style-type: none"> ★ Air knife exhaust system 	<ul style="list-style-type: none"> ★ Removes volatiles from press and production area 	<ul style="list-style-type: none"> ★ Decreases drying or setting time ★ Protects press functions and operators
<ul style="list-style-type: none"> ★ Time delay on air knife and exhaust knife shut-off 	<ul style="list-style-type: none"> ★ Interstation areas are completely heat evacuated when press is stopped 	<ul style="list-style-type: none"> ★ Comfortable operator makeready and wash-up environment ★ Comprehensive press protection
<ul style="list-style-type: none"> ★ Complete training of staff by PRI professionals <p>(Including complete Operator's and Pre-Installation Manuals)</p>	<ul style="list-style-type: none"> ★ Knowledgeable operators at completion of installation and training 	<ul style="list-style-type: none"> ★ Increased productivity due to responsive training program by PRI ★ Ability to produce saleable sheets immediately after training

PRINTING RESEARCH, INC.
TERMS OF PROPOSAL

1. **PRICING:** Prices are based on clear access to and within the press to install our standard equipment. Any variance, deviation or encumbrance will be subject to price review. Installation is priced separately and all electrical, plumbing, engineering or other contracted services including materials to prepare the site for installation are the customers responsibility.
2. **TERMS:** 40% with purchase order and signed sales contract. 50% upon notification of readiness for shipment. Please note in order to release shipments, payment must be received. Balance 30 days after installation or 45 days from delivery, whichever is earlier. Please Note, when payment for a unit is due, it is payable without regard to the status of another unit which might be purchased at the same time.
3. **WARRANTY CONDITIONS:** 12 months on defective parts. **EXCEPTION:** UV Lamps - All guaranteed for 1000 operating hours. If failure occurs prior to 1000 hours of operation, 100% credit or a free replacement lamp will be provided.
4. **CONDITIONS OF SALE:** This quotation is subject to our "General Terms and Conditions Coating and Drying Systems" on reverse of Summary. The company accepts no liability whatsoever for any loss of production, loss of profit or other loss to customer in connection with the equipment and/or its installation.
5. **STANDARD DELIVERY:** Is usually 12 - 16 weeks from receipt of official order and first stage payment. FOB Factory.
6. **INSTALLATION AND TRAINING:** \$575.00 per day per man plus airfare.
7. **ELECTRICAL STANDARD:** 220/460/480 volts, 3 or 4 wire (Delta or Wye) 60 hz.
Note: Electrical services must be specified on the purchase order.
8. **SERVICES TO BE PAID FOR AND PROVIDED BY CUSTOMER:**

GENERAL: Buyer agrees to prepare the press for installation, which may require relocating accessories including spray powder units, static bars, etc. Any relocation or modification of accessories will be the sole responsibility of the buyer. In the event Printing Research (P.R.I.) technicians are requested to modify or relocate any accessory, there will be an additional charge assessed to the buyer based on P.R.I.'s applicable hourly rate. P.R.I. will not warranty the performance of any accessories moved. When applicable, the buyer will supply clean, dry compressed air.

HV/PBC/IR/UV/EZ/BV/VH

The customer agrees to supply and pay for electricians, plumbers, engineering services and all materials required to install and interconnect (if necessary) the equipment being supplied by Printing Research, Inc. The electrical, plumbing, water, compressed air and refrigeration lines being supplied by the customer are to be connected to the equipment being installed. Printing Research, Inc. is responsible for activating the installed systems and will supply the labor necessary in that regard.

9. **ADDITIONAL SPECIFIC SERVICES TO BE PROVIDED BY CUSTOMER:**

HV (High Velocity Hot Air Dryer)

- ☐ Provide duct work and duct work extraction.
- ☐ Provide raised walkplates to cover air supply and return lines lying on the floor.

PBC (Plate Blanket Coater)

- ☐ Provide coating and cleaning agent for testing and training.
- ☐ 55 gallon barrel of hydraulic oil
- ☐ Compressed air line up to 100 p.s.i.
- ☐ Lifting gear to place coater on press
- ☐ Provide relief plate to conduct plate coating test.

UV (Water Cooled and 'Cold' UV)

- ☐ Duct work and extraction, if required
- ☐ Clean, dry compressed air adjacent to within 10 feet of the location of lamps; compressor must be able to deliver 0.5 c.f.m. per linear inch per lamp at up to 100 p.s.i.
- ☐ The chilling system is not precharged with refrigerant due to the variability of installation requirements and is priced accordingly. The customer agrees to pay for all refrigerant needed to complete the installation.

'COLD' UV

- ☐ Provide 25-50 gallons of non-charcoal filtered steam distilled water.

EZ (EZ Impression Cylinder Coater)

- ☐ Compressed air line up to 100 p.s.i.
- ☐ Provide coating and cleaning agent for testing and training.

VH (Vent-A-Hood)

- ☐ Provide all duct work including penetrating and resealing the ceiling and/or roof and electrical interconnections to other equipment.

10. **LOCAL INSPECTIONS, PERMITS OR CERTIFICATIONS:**

- ☐ Any additional local inspections, permits or certifications and the costs thereof are the sole responsibility of the buyer.

Prices are firm 60 days from the date of this proposal.

[illegible]

[54] METALLIC COLOR PRINTING PROCESS

[75] Inventors: Jesse S. Williamson, Dallas; George V. Barnaby, Irving; Gary V. Doughty, Dallas, all of Tex.

[73] Assignee: Williamson Printing Corporation, Dallas, Tex.

[21] Appl. No.: 887,510

[22] Filed: May 22, 1992

[51] Int. Cl.⁵ G03C 7/00; G03C 5/00; G03F 9/00; H04N 1/21

[52] U.S. Cl. 430/358; 430/359; 430/22; 430/30; 358/798; 358/534; 358/536

[58] Field of Search 430/358, 359, 30, 293, 430/301, 21, 143, 43, 44, 347; 106/19 R; 358/75, 80, 534, 536, 298

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Primary Examiner—Charles L. Bowers, Jr.

Assistant Examiner—J. Pasterczyk

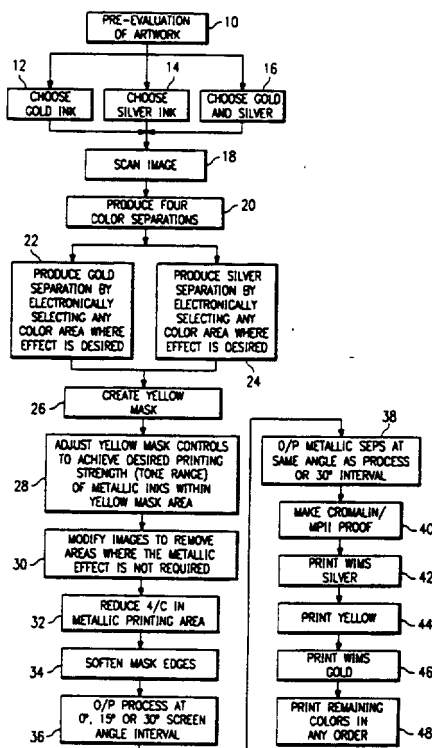
Attorney, Agent, or Firm—Jones, Day, Reavis & Pogue

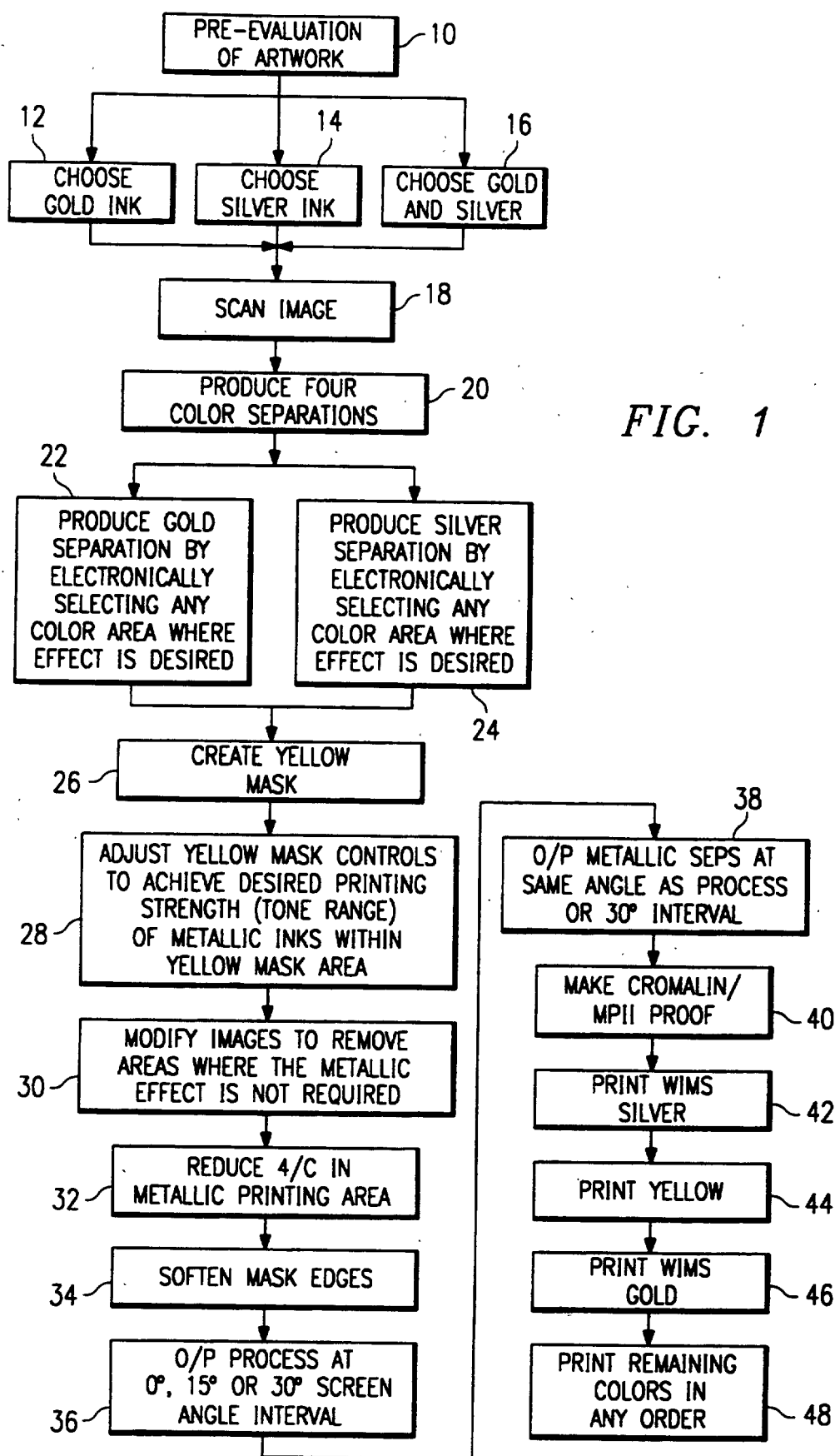
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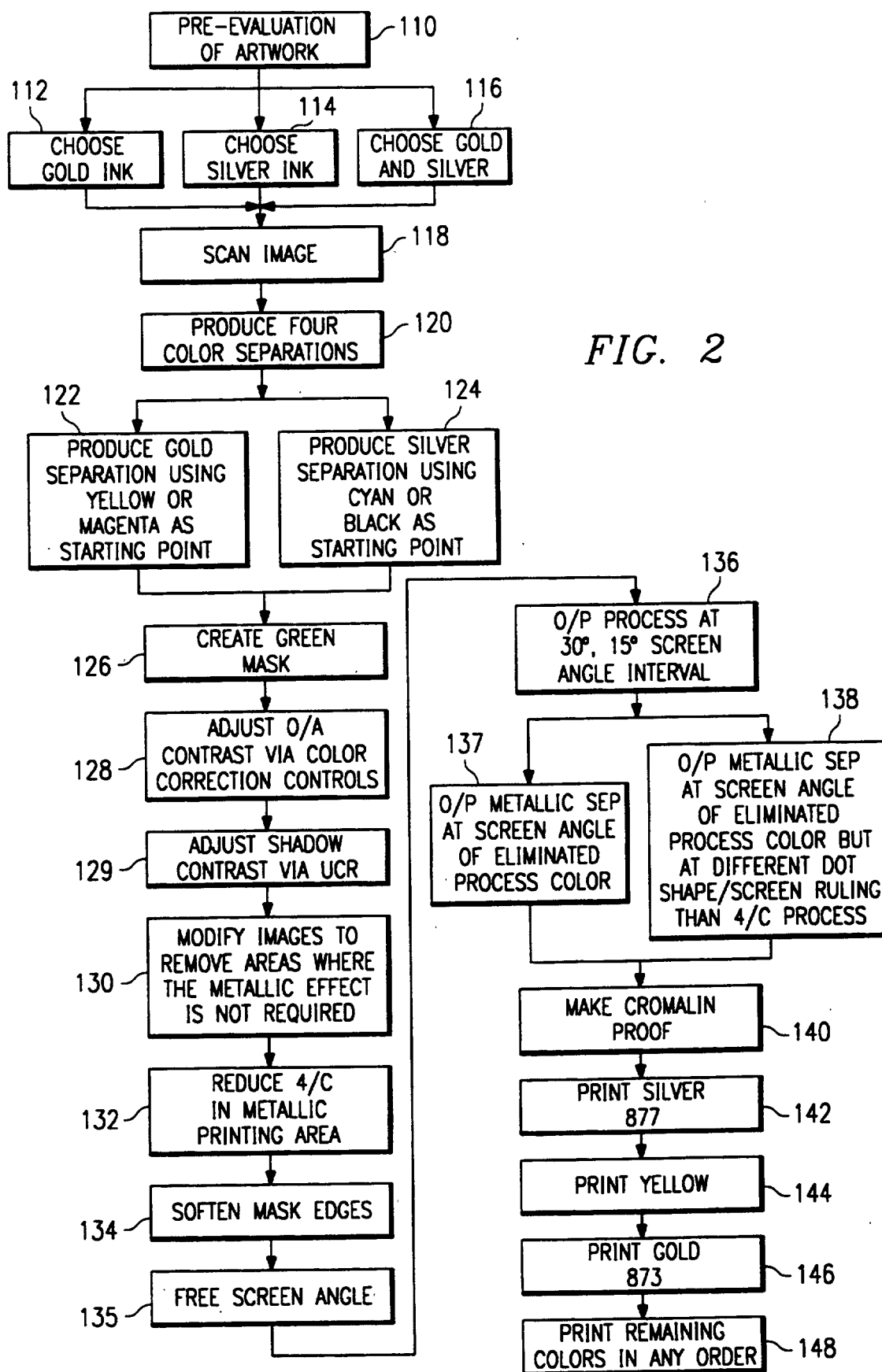
ABSTRACT

A method of reproducing on a substrate an image incorporating metallic inks involves scanning (18) the image to be reproduced and creating (20) four color separations of the scanned image. Metallic gold and/or metallic silver color separations (22, 24) are created by electronically selecting any color area where the effect is desired. Next, the color separations are edited by creating (26) an electronic yellow mask of the image and adjusting (28) the desired tonal range of the metallic areas. The mask edges of each color separation can also be softened (34). The scanner then outputs (36, 38) the separations to film. The image is then reproduced by printing each of the process color separation films (44, 48) and the metallic separation films (42, 46) onto a substrate.

12 Claims, 2 Drawing Sheets







METALLIC COLOR PRINTING PROCESS

TECHNICAL FIELD OF THE INVENTION

The present invention relates to a metallic color printing process. Specifically, this method produces an improved metallic image by printing the subtractive primary colors, black, metallic gold and/or metallic silver at four screen angles.

BACKGROUND OF THE INVENTION

The reproduction of color was first achieved by Scottish physicist James Maxwell in the mid 1850's. Maxwell photographed a scene three times, once through a red filter, once through a green filter, and once through a blue filter. These black-and-white negatives were contacted to produce positives that were then mounted as slides. Each slide was placed in a different projector and the images were focused together on a screen. A red, green, or blue filter was placed over the lens of each respective projector, thus producing a color image on the screen.

The first single film image for color photography was produced by Louis Ducos du Hauron in France in the late 1860's. In his system, the image on a black-and-white panchromatic emulsion was broken up by a series of red, green, and blue transparent dots or lines that formed a screen in front of the emulsion. The dots and lines were so small that they could not be resolved by the eye. After exposure, the film was reversal-processed to yield a colored positive transparency. The additive-color transparency is still used by the Polaroid Corporation with their 35-mm Polachrome slide process.

The development of the subtractive color systems was also pioneered by du Hauron. He suggested making separation negatives through red, green, and blue filters, then making positive transparencies from each, dyeing them with colors that absorb each respective primary color (i.e. cyan, magenta, and yellow). This subtractive method is difficult to use because it requires the accurate registration of the colored positives or the accurate registration of images from dyed positive matrices. The solution was a three-emulsion film, each layer made sensitive to a different color (red, green, or blue) and then dyed a different color (cyan, magenta, or yellow) in processing. The first successful film of this type was Kodachrome, introduced by the Eastman Kodak Company in 1935.

Printed color reproduction is based on many of the same principles as film color reproduction. Instead of a continuous image, allowed by the film medium, a series of dots are printed on a substrate. These dots are printed in the subtractive primary colors of cyan, magenta, and yellow. Additionally, black is used to adjust the contrast of the image. In the subtractive process, a white substrate is used and red, green, and blue are essentially subtracted to achieve black. By contrast, in the additive system, a black background (i.e. a blank TV screen) is used, and red, green, and blue are added to achieve white. In the additive system the following combinations create the following results:

Red + Green = Yellow
Red + Blue = Magenta
Green + Blue = Cyan
Red + Green + Blue = White

In the subtractive process, the following is true:

White + Yellow + Cyan = Green

White + Magenta + Cyan = Blue

White + Magenta + Yellow = Red

White + Yellow + Magenta + Cyan = Black

Moreover, each subtractive primary color when added with white produces that same subtractive primary color.

The objective in printing is to produce yellow, magenta, and cyan printing plates that are negative records of the amounts of blue, green, and red in the original. This is achieved by first photographing the original, in turn, through blue, green, and red filters. These films may then be converted into a halftone dot image suitable for a given printing process. The films are then used to make the image carriers, which may be plates, cylinders, or stencils. Each plate is inked with its appropriate ink, which is then transferred to a white substrate.

The image produced is largely dependant upon dot size and orientation. Orientation is defined primarily by the screen angle of the dot. The screen angle is the angle at which the rulings of a halftone screen are set when making screened images. In other words, the screen angle of a dot is the angle of the line which bisects the often elliptical dots. Standard screen angles have been established for various colors of dots: Magenta (45°), Cyan (75°), Yellow (90°), Black (105°). The interaction of screen angle, color, and dot size effect the quality of the reproduction.

Printing metallic colors, such as metallic gold and metallic silver, poses additional problems. Gold has typically been treated as a shade of yellow, while silver has been treated as a shade of gray. Thus the brilliance of these colors is diminished by the blending of hues which occurs in a four color printing system.

A system known as Metallic Integrated Printing Process (MIPP) has been developed for the reproduction of metallic colors by Eckart-Werke Metal Pigments and Powders of Furth, Bayern, Germany. This system requires numerous steps. First, a designer marks-up the artwork to be copied to designate those areas where the MIPP system is required, i.e. metallic colored areas. Next, a conventional four color separation is produced of the artwork. Each separation is then compared to the original artwork to see which separation gives the best representation of the metallic colors. Based on the object color in the original photograph and the color requirements of the final print, a determination is then made whether gold or silver is required. Most shades of gold can be obtained from silver and yellow. However, a high percentage of yellow on silver greatly reduces the metallic brilliance. In addition, silver has a grey value of approximately 30% that tends also to reduce the metallic brilliance and thereby dirty colors.

After the four color separations are made, two separations used to print the metallic inks must be developed from two of the four separations. Typically the cyan or black separation will give the best basis for developing the silver separation and either the yellow or magenta for the gold separation. The selected separations are then duplicated to become the gold and silver separations. These separations may require modification to remove image areas where a metallic effect is not required. Comparison with the original transparency may indicate the need to enhance some image areas so as to improve the final metallic effect. The MIPP system anticipates the softening of mask edges of the metallic colors to avoid sharp cut-out effects when the final result is printed. In practice, the task of softening of

mask edges can be handled using electronic image processing equipment.

With the MIPP systemic, a screen angle must be freed for each of the metallic inks to avoid problems of screen clash and resulting moire effects. This can be accomplished by using achromatic or Under Color Removal, ("UCR") color separation techniques where the process color with the lowest value is eliminated in favor of black. UCR involves the technique of reducing the cyan, magenta, and yellow content in neutral grey shadow areas of a reproduction and replacing them with black ink so that the reproduction will appear normal but will use less process color ink. (From the Complete Color Glossary by Miles Southworth, Thad McIlroy and Donna Southworth, Copyright 1992; Published by The Color Resource, Livonia, N.Y. ISBN 1-879847-01-9). Often the cyan will have the lowest value and is the color to eliminate. Since both gold and silver have a process color value, the four conventional separations will need to be modified if the finished print is not to look over-colored or dirty. For example PANTONE 873, the MIPP gold standard, has a process color value of approximately 65% yellow, 25% magenta and 5% cyan. So if the gold areas are to look realistic these colors must be reduced proportionately. The separations may also require modification as the metallic inks have a grey scale value and a failure to take this into account may result in a dirtying of the final colors due to a reduction in their metallic brilliance.

A MIPP image is printed using standard screen angle intervals of 30° or 15°. The screen angle used for a metallic ink is the same as that for the process colors eliminated in favor of a metallic ink. The MIPP system may use different dot shapes to reduce the risk of screen clash. A round dot, with no preferred direction, is typically used for the metallic ink, while an elliptical dot works for the standard process inks. The color standards chosen for MIPP come from the PANTONE System of matched metallic inks, with PANTONE 873 as the gold standard and PANTONE 877 as the silver standard.

Because metallic inks are opaque, they are normally printed before the transparent process colors. But with MIPP the sequence is changed slightly so that the first three colors down are silver, yellow, and gold, respectively. The remaining three process colors are printed in any order. The first three colors, in this order, are very important if the finished print is to look realistic. The use of yellow on silver is necessary to obtain yellow, green and orange metallic effects. Yellow, under gold, is also necessary to maintain the correct tonal values in the highlight areas. Yellow, printed in this way, provides a transition from gold to non-metallic pans of the image. On the other hand, if yellow is printed on top of the gold, there is a loss of metallic sheen without any compensating color benefit.

In summary, the MIPP system presents several disadvantages. First, it requires excessive handwork to create the color mash. Second, the MIPP system requires the elimination of one of the subtractive process colors to free up a screen angle for a metallic color. Third, the MIPP system only allows the printing of four screened colors in any given area. Last, the PMS 873 standard gold ink used by the MIPP system is a dirty, or less brilliant gold ink. This dirty look limits the gold color reproduction to the inherent dirty look even if no other color ink is printed in that area. This dirty look also

necessitates additional color correction of the subtractive primaries. Therefore, a need exists for a printing process which maximizes the appearance of metallic colors. Such a process should allow the use of six colors printed at four screen angles. Moreover, such a process should not limit the number of colors in any given area to four as with the MIPP System.

SUMMARY OF THE INVENTION

The present invention relates to the Williamson Integrated Metallic System (WIMS) developed to allow six color printing using yellow, magenta, cyan, black, metallic silver, and/or metallic gold. The WIMS System creates a realistic metallic gold or metallic silver effect using the subtractive primary colors, black, silver and/or gold. The WIMS method comprises a number of steps. The subject to be reproduced is first scanned by a standard scanner and four color separations are created. The original art is then edited to achieve the required metallic effect. Editing comprises the steps of creating a yellow mask, reviewing an electronic version of the image produced by the scanner, determining the amount of contrast between heavy and light metallic regions on the image by one skilled in the art based on past experience, and then sending that contrast information back to the scanner. A "yellow mask" is created to isolate areas where a metallic effect is desired. This "yellow mask" allows the operator to select these areas based on the color and tonal region of the original. For example, those areas appearing neutral are appropriate for silver metallic, while those areas appearing high yellow with a red component are appropriate for the gold metallic. Additional modification of dot size in these isolated areas may be required to avoid moire and reduction in metallic brilliance of the final colors. These colors can be printed at four screen angles: cyan (75°), magenta (45°), silver (45°), gold (75°), yellow (90°), and black (105°).

In the WIMS System, a cleaner, or more brilliant gold color ink is used, wherein the process color value is less than 25% for magenta and less than 5% for cyan. This should diminish any dirtiness caused by the process color values of adjacent primary colors. Additionally, any harsh edge effects caused during printing may be softened during the electronic masking stage. During printing, the silver separation can be printed at the same screen angle as the magenta, while the gold separation can be printed at the same screen angle as the cyan separation.

BRIEF DESCRIPTION OF THE DRAWINGS

For a more complete understanding of the present invention, and for further details and advantages thereof, reference is now made to the following Detailed Description taken in conjunction with the accompanying drawings, in which:

FIG. 1 illustrates a flow chart of the WIMS System for reproduction of metallic color; and

FIG. 2 illustrates a flow chart of the prior art MIPP System.

DETAILED DESCRIPTION OF THE DRAWINGS

The present invention relates to a metallic color printing process, also known as the WIMS System, that overcomes many of the disadvantages found in the prior art. Referring to FIG. 1, a flow chart illustrates the steps involved in the present method.

A first step involves pre-evaluation at step 10 of the subject to determine desired effects and proper placement of metallics in process reproduction. Metallic gold can be chosen at step 12, metallic silver can be chosen at step 14, or a combination of both metallic gold and metallic silver can be chosen at step 16. Next, the image can be scanned at step 18 by a scanner which, in turn, produces at step 20 four color separations which are electronically viewed on the scanner display. The scanner acts as both an input device and an output device. In other words, the artwork is input to the scanner. The scanner can then output color separations or film used to recreate the artwork. The scanning step involves the application of 75% to 100% to the scanner set-up and the scanning of the image. Then, the PCR is removed from the scanner set-up and the image is scanned to an "Imagedit", an electronic color correction machine, produced by the Crosfield Co. of Hemel Hempstead, England.

The original artwork is evaluated in a well known manner by one skilled in the art to determine the color areas in which the metallic effect is desired. A gold separation can be produced at step 22 by electronically selecting any color area where the effect is desired. Likewise, a silver separation can be produced at step 24 by electronically selecting any color area where the effect is desired. Typically, the cyan or black areas of the original art will be the basis for developing the silver printing whereas yellow or magenta areas of the original art will form the starting point for creating the gold printing. It is emphasized that either the gold or silver separations may be produced by selecting any color area where the effect is desired.

Using the Crosfield Imagedit, a "yellow mask" can then be created at step 26 to isolate the areas where a metallic effect is desired from the rest of the separation. The "yellow mask" function gives the ability to select the desired areas electronically based on the tonal region or bandwidth of the original as well as the desired color region. Creating a yellow mask entails several steps. First, an electronic version of the image produced by the scanner displays the contrast between a heavy metallic region and a light metallic region on the image. For example, neutrals are appropriate for silver, while high yellows with a red component are appropriate for gold. The yellow mask controls can be adjusted at step 28 to achieve desired printing strength (tonal range) of metallic inks within the yellow mask area. These controls allow the adjustment of slope, gain, and rolloff of the image within the yellow mask area.

Next, the Imagedit computer creates six revised color separations in a well-known manner; one each for yellow, cyan, magenta, black, gold and silver. Once these electronic masks are created, further modification at step 30 of the isolated area may be required. For example, such modifications may increase or reduce the printing dot size of the metallic separation and/or adjust at step 32 the amount of four color process ink printing over the newly created metallic to compensate for the reduction in brilliance caused by the additional metallic color in the reproduction. Additionally, in a given original, there may be areas of similar color where a metallic effect is desired in one area but not the other. For example, a gold watch requires a, metallic gold, while a golden retriever would not. Due to this anomaly, further electronic manipulation of the image may be required to eliminate metallic ink in unwanted areas. Moreover, because all masking is performed electroni-

cally, it is possible to soften at step 34 any harsh edge effects in the final reproduction via mask smoothing or tonal integration techniques.

Next, this information is sent back to the scanner which outputs at step 36 the subtractive process colors and the metallic separations. The MIPP standard for screening is to eliminate (by hand masking) one of the process colors in metallic areas to free-up a screen angle, or to produce the metallic separations at a line screen resolution different than the process colors to reduce moire effects. However, in the WIMS process, the subtractive process colors are output at step 36 at 0°, 15°, and/or 30° screen angle intervals. An interval is the spacing between any two screen angles. The metallic color separations are output at step 38 at the same angles as the subtractive process colors or at 30° intervals. The gold separation can be produced at the same screen angle as the cyan separation. Likewise, the silver separation can be produced at the same angle as the magenta separation. Therefore, with WIMS reproductions, six colors can be printed at four screen angles. For example, cyan can be printed at 75°, magenta at 45°, silver at 45°, gold at 75°, yellow at 90°, and black at 105°. Both process and metallic separations are produced at the same line screen resolution. Typically, there are no problems with moire effect.

The next step involves metallic inks: a gold ink, a silver ink, or both gold and silver. The Pantone MIPP standard for gold ink is PMS 873. This ink printed solid has a process color value of approximately 65% yellow, 25% magenta and 5% cyan. For WIMS reproduction, however, a much more brilliant gold ink is used, wherein the magenta and cyan process equivalents are greatly reduced. This was selected under the rationale that a pure gold ink area of WIMS gold could be reduced in brilliance, but a pure PMS 873 ink area could not be made any more brilliant than the inherent bronze color of the ink. This same color compensation theory also applies to silver areas where a calculated reduction in cyan or black generally occurs.

Prepress proofing at step 40 is accomplished via a combination of 3M Matchprint II (for process colors) and Dupont Cromalin (for metallics). After proofing, the artwork is reproduced by first printing at step 42 the WIMS standard for silver, then printing at step 44 yellow, then printing at step 46 the WIMS standard for gold, and finally printing at step 48 the remaining subtractive primary colors in any order.

FIG. 2 provides a flow chart of the MIPP process which is discussed in greater detail in the Background Section. In sum, the designer marks up the artwork to be reproduced to show where MIPP is required and the image is scanned at step 118. Based on the object color in the original photograph and the color requirements of the final print, a determination is then made whether to choose at step 112 gold, choose at step 114 silver, or to choose at step 116 both silver and gold. The artwork is then scanned at step 118 by a scanner and a standard four-color separation is produced at step 120. Each separation is compared to the original to determine which gives the best representation of the metallic colors. A gold separation is next produced at step 122 using the screen angle of the process color that was eliminated in that area, as will be discussed in greater detail. Likewise, a silver separation can also be produced at step 124 using the screen angle of the process color that was eliminated in that area.

A green mask is created at step 126 with the scanner and viewed on the scanner display. The overall contrast of the green mask can be adjusted at step 128 via the color correction controls. Shadow contrast can then be adjusted via undercolor removal (UCR). Next, the image is modified at step 130 to remove areas where the metallic effect is not required. The level of the four subtractive process colors can be reduced at step 132 in the metallic printing area. Mask edges can then be softened at step 134.

Next, a screen angle must be freed at step 135 for each of the metallic inks to avoid problems of screen clash and resulting moire effects. In other words, in any one area where a metallic ink is used, the subtractive primary color with the same screen angle must be eliminated or made solid. Thus, no more than four screened colors may appear in any one area of the reproduction. The scanner outputs at step 136 the subtractive process colors to film at 30° and 15° intervals. The scanner can then output at step 137 the metallic separations at a screen angle of an eliminated process color. Alternatively, the scanner can output at step 138 the metallic separations at the screen angle of the eliminated process color but at a different dot shape and/or screen ruling than the four subtractive process colors. Prepress proofing at step 140 is accomplished. After proofing, the artwork is reproduced by first printing at step 142 the PMS 877 standard for silver, then printing at step 144 yellow, then printing at step 146 the PMS 873 standard for gold, and finally printing at step 148 the subtractive primary colors in any order.

Although preferred embodiments of the invention have been described in the foregoing Detailed Description and illustrated in the accompanying drawings, it will be understood that the invention is not limited to the embodiments disclosed, but is capable of numerous rearrangements, modifications, and substitutions of parts and elements without departing from the spirit of the invention. Accordingly, the present invention is intended to encompass such rearrangements, modifications, and substitutions of parts and elements as fall within the scope of the invention.

We claim:

1. In a method of half-tone dot printing a reproduction of a scanned image on a substrate with the four subtractive process colors of magenta, cyan, yellow, and black in a given area of the scanned image at only four screen angles, an improved method of incorporating metallic colors in said reproduction, the improvement comprising the steps of:
 - printing at least one metallic color in said given area at a selected one of the only four screen angles; and
 - printing at least one of said four subtractive process colors in said given area at the same screen angle as said at least one metallic color such that said at least one metallic color and one process color are printed in said given area at the same one of said four screen angles so as to enable at least five colors to be printed at only said four screen angles.
2. A method as in claim 1 further including the steps of:
 - printing a second metallic color in said given area at a second one of said four screen angles; and
 - printing a second one of said four subtractive process colors in said given area at the same second one of said four screen angles as said second metallic color so as to have an additional metallic color and an additional process color printed in said given area

at said second one of said four screen angles so that up to six colors are printed at only said four screen angles.

3. The method of claim 1 of reproducing a scanned image on a substrate including incorporating metallic colors and further comprising the steps of:

producing four process color separations of the scanned image, each at one of said four screen angles;

producing at least one metallic color separation at the same screen angle as a corresponding first one of the four screen angles of the process color separations in said given area;

editing each process color separation and the at least one metallic color separation to obtain metallic color separation information;

outputting each process color separation to film creating a process color separation film;

outputting the at least one metallic color separation to film creating a first metallic color separation film; and

printing a reproduction of the scanned image on a substrate using the process color separation films and the at least one metallic color separation film such that both a metallic color separation and a process color separation are produced at the same screen angle.

4. The method of claim 3 of reproducing a scanned image on a substrate including metallic colors anti further comprising the steps of:

producing a second metallic color separation at the same screen angle as a corresponding second one of the four screen angles of the process color separations in said given area;

editing the second metallic color separation to obtain metallic color separation information;

outputting the second metallic color separation to film creating a second metallic color separation film; and

printing a reproduction of the scanned image on a substrate using the process color separation film and the first and second metallic color separation films such that said first metallic color separation and a first process color separation are produced at an identical first screen angle and the second metallic color separation and second process color separation are produced at a second identical screen angle so as to enable up to six colors to be printed in the given area in only four screen angles.

5. The method of claim 4 wherein the step of producing a first and a second metallic color separation further comprises the steps of:

producing a gold metallic color separation as the first metallic color separation; and

producing a silver metallic color separation as the second metallic color separation.

6. The method of claim 4 wherein the step of producing a first and a second metallic color separation further comprises the steps of:

producing a silver metallic color separation as the first metallic color separation; and

producing a gold metallic color separation as the second metallic color separation.

7. The method of claim 4 wherein the step of editing further comprises the steps of:

reviewing an electronic version of the scanned image to determine regions of the image where metallic color is to be added;

9. The method of claim 4 wherein the step of outputting the second metallic color separation further com-

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THE END OF THE WORLD



Printing Research, Inc.

"Mark-less" Super Blue"

August 31, 1994

Mr. Jesse Williamson
Williamson Printing Corporation
6700 Denton Drive
Dallas, TX 75235

214-904-2100 (Phone)

Dear Jesse,

Further to our various conversations, we have enclosed product information and the following **Super Blue** proposal for installation on your:

1. **Heidelberg Speedmaster CD 102**, 7 color with coating tower, 40 inch press (Press being delivered 9-6-94).

We propose:

- A **Super Blue** HV High Velocity Hot Air Drying System for installation between printing units.
- A **Super Blue** ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery. (PRI to deliver within 3 weeks of 9-6-94)

2. **Heidelberg Speedmaster CD 102**, 6 color with coating tower, 40 inch press (Press being delivered the week of 9-27-94).

We propose:

- A **Super Blue** HV High Velocity Hot Air Drying System for installation between printing units.
- A **Super Blue** ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

3. **Heidelberg Speedmaster CD +L+Y+L 102**, 6 color with coating tower (L), with dummy unit for drying (Y), with second coating tower (L). 40 inch press (Press being delivered January '95).

We propose:

- A **Super Blue** HV High Velocity Hot Air Drying System for installation between printing units.
- A **Super Blue** ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.
- A **Super Blue** CUV 'Cold' UV Drying System for installation in the delivery.

Williamson Printing Corporation
Page 2
August 31, 1994


- 4A. **Heidelberg Speedmaster CD 102**, 8 color with coating tower, 40 inch press
- B. **Heidelberg Speedmaster CD 102**, 8 color with coating tower, 40 inch press
(Both presses being delivered June/July 1995).

We propose:

- A **Super Blue HV High Velocity Hot Air Drying System** for installation between printing units.
- A **Super Blue ABII Air Blanket II 2KW Infra-Red Drying System** for installation in the delivery.

We look forward to serving your needs and thank you for your interest in our **Super Blue** range of products. For more information please contact us at 1-800-627-5537.

Sincerely yours,

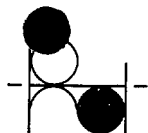


John Bird
Product Manager

JB:J

Enclosures: P1/FAB

cc: Bill Davis - Williamson Printing Corp.
Bob Emrick - Williamson Printing Corp.



Printing Research, Inc.

"Mark-less" Super Blue®

September 6, 1994

Mr. Jesse Williamson
Williamson Printing Corporation
6700 Denton Drive
Dallas, TX 75235

214-904-2100 (Phone)

Dear Jesse,

It was a great pleasure for Howard and me to meet with you, Woody, Bill and Bob. The following confirms the major points discussed and agreed:

Press Purchase 1. Heidelberg Speedmaster CD102, 7 color with coating tower, 40 inch press. PRI equipment to be supplied:

- A **Super Blue** HV High Velocity Hot Air Drying System for installation between printing units.
- A **Super Blue** ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

Special Conditions:

- A. Purchase, delivery, installation and training charges are waived for drying system 1.
- B. PRI to install HV when Williamson Printing Corporation (WPC) signs off on press.
- C. In the unlikely event that PRI fails to dry water based coatings applied in line over 7 colors, we will remove our equipment and purchase a Grafix drying system as previously proposed by Heidelberg.

Press Purchase 2: Heidelberg Speedmaster CD 102, 6 color with coating tower, 40 inch press. PRI equipment to be purchased:

- A **Super Blue** HV High Velocity Hot Air Drying System for installation between printing units.
- A **Super Blue** ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

September 6, 1994

Press Purchase 3: Heidelberg Speedmaster CD 102 L+Y+L, 6 color with coating tower (L) with dummy unit for drying (Y) and with second coating tower (L) 40 inch press. PRI equipment to be purchased:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.
- A Super Blue ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.
- A Super Blue CUV 'Cold' UV Drying System for installation in the delivery.

Press Purchase 4: Heidelberg Speedmaster CD 102, 8 color with coating tower 40 inch press:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.
- A Super Blue ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

Press Purchase 5: Heidelberg Speedmaster CD 102, 8 color with coating tower 40 inch press:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.
- A Super Blue ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

Special Conditions:

A. We have discounted the total PRI drying equipment price of \$528,956 by supplying WPC the drying equipment for Press Purchase 1 at no charge and by allowing a further discount of 20% against the drying equipment for Press Purchases 2, 3, 4, 5.

B. We are supplying three recommended spare parts systems at no charge, all three of which to be supplied with PRI equipment for press purchases 1, 2, and 3.

C. We are extending our standard warranty conditions, Paragraph 3 'Terms of Proposal', Paragraph 6 'Sales Terms and Conditions' from 12 months to 24 months.

The following represents our estimated installation costs:

Press Purchase 1: No charge.

Please note: There will be three exhaust terminations at the press to be completed by the customer. Two PRI and one Heidelberg pan exhaust.

106050" 96257E60

September 6, 1994

Press Purchase 2:

Delivery, installation and training costs priced at:

18 man days at \$400 per day or \$ 7,200

Equipment interconnection costs

including materials and 4 man days at \$ 3,600

Total cost: \$10,800

Please note: There will be three exhaust terminations at the press to be completed by the customer, two PRI and one Heidelberg pan exhaust.

Press Purchase 3:

Delivery, installation and training costs priced at: \$13,600

34 man days at \$400 per day or

Equipment interconnection costs

including plumbing materials and 8 man days at \$11,400

Total cost: \$25,000

Please note: There will be five exhaust terminations at the press to be completed by the customer, four PRI and one Heidelberg pan exhaust.

Press Purchase 4:

Delivery installation and training costs priced at:

20 man days at \$400 per day or \$ 8,000

Equipment interconnection costs

including materials and 5 man days at \$ 4,300

Total cost: \$12,300

Please note: There will be three exhaust terminations at the press to be completed by the customer, two PRI and one Heidelberg pan exhaust.

Press Purchase 5:

Delivery installation and training costs priced at:

20 man days at \$400 per day or \$ 8,000

Equipment interconnection costs

including materials and 5 man days at \$ 4,300

Total cost : \$12,300

Please note: There will be three exhaust terminations at the press to be completed by the customer, two PRI and one Heidelberg pan exhaust.

Total turnkey price to install all PRI equipment on five presses, therefore: **\$60,400.**

Special notes: All above pricing is estimated on the basis of I. Control cabinets and interconnecting is no more than 10 feet from the side of the press. II. Overhead runs of cables etc.. to be no more than 15 feet from the floor line.

091106-150001

Williamson Printing Corporation

Page 4

September 6, 1994

We look forward to serving your needs and thank you for your interest in our **Super Blue** range of products. For more information please contact us at 1-800-627-5537.

Sincerely yours,



John Bird

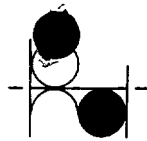
Product Manager

JB:tj

cc: Woody Dixon - Williamson Printing Corporation
Bill Davis - Williamson Printing Corporation
Bob Emrick - Williamson Printing Corporation

FOUO 93 96451660

TOP SECRET



Printing Research, Inc.

"Mark-less" Super Blue®

September 6, 1994

Mr. Jesse Williamson
Williamson Printing Corporation
6700 Denton Drive
Dallas TX 75229

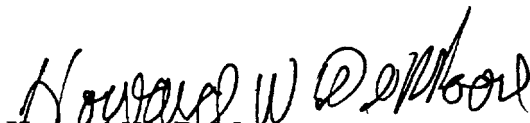
Dear Jesse:

Pursuant to Paragraph 2 of the Settlement Agreement dated October 1, 1993, among Printing Research, Inc. (PRI), Howard W. DeMoore (HWD), Williamson Printing Corporation (WPC), Jerry B. Williamson, III, Jesse Speight Williamson and Buford Roy Williams, WPC agreed to purchase goods and services from PRI on the terms set forth therein. PRI has recently submitted to WPC a proposal pursuant to which PRI would sell certain goods and services to Heidelberg USA for inclusion in printing presses to be purchased by WPC.

This letter will acknowledge and confirm that the sale by PRI to Heidelberg USA of the ABII Air Blanket II 2KW Infrared Dryer as described in Proposal I dated August 31, 1994, for inclusion in the Heidelberg CD102, 7-color with coating tower, 40-inch press to be purchased by WPC, will constitute full and complete satisfaction by WPC of Paragraph 2 of the Settlement Agreement. The terms and provisions of Paragraph 2 of the Settlement Agreement will be deemed fully and completely satisfied by WPC upon PRI's receipt of a binding purchase order from Heidelberg USA for the ABII Air Blanket II 2KW Infrared Dryer regardless of whether such drying system is ultimately accepted by WPC after installation and testing pursuant to the terms of WPC's contract with Heidelberg USA.

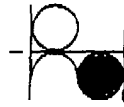
PRI further agrees that, in the event the ABII 2KW Infrared Dryer is not ultimately accepted by WPC after installation and testing pursuant to the terms of WPC's contract with Heidelberg USA, PRI will replace such drying system with the Grafix Dryer originally specified for the press at no charge to WPC.

Best regards,


Howard W. DeMoore,
As President and Individually

HWD:ln

THESE



Printing Research, Inc.

"Mark-less" Super Blue®

TELEFAX MESSAGE FROM PRINTING RESEARCH, INC.

REF FAX NR : 915jb1
DATE : September 15, 1994 **PAGE 1 OF 4**
COMPANY : WILLIAMSON PRINTING CORP.
ATTN : BILL DAVIS

- 17,900

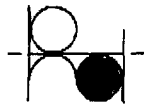
Dear Bill,

Please find the attached letter from Printing Research. Please feel free to contact us if you have any questions. Thank you.

Best Regards,

John Bird
Product Manager

10954 Shady Trail



Printing Research, Inc.

"Mark-less" Super Blue®

September 15, 1994

Mr. Jesse Williamson
Williamson Printing Corporation
6700 Denton Drive
Dallas, TX 75235
214-904-2100 (Phone)

Dear Jesse,

The following confirms our various conversations and the final purchase agreement schedule:

Press Purchase 1. Heidelberg Speedmaster CD102, 7 color with coating tower, 40 inch press. PRI equipment to be supplied:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.
- A Super Blue ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

Special Conditions:

- A. Purchase, delivery, installation and training charges are waived for drying system 1.
- B. PRI to install HV when Williamson Printing Corporation (WPC) signs off on press.
- C. In the unlikely event that the PRI drying system fails to dry water based coatings applied in line over 7 colors to Williamson Printing Corporation's sole satisfaction or if the system is detrimental in any way to the press or process as determined by Williamson Printing Corporation, we will remove our equipment and purchase a Grafix drying system as previously proposed by Heidelberg at no cost to Williamson.

Equipment Cost:	\$81,173
Discount:	<u>\$81,173</u>
	NO CHARGE
Spare Parts, Delivery, Installation, Interconnect, Training	NO CHARGE

Press Purchase 2: Heidelberg Speedmaster CD 102, 6 color with coating tower, 40 inch press. PRI equipment to be purchased:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.
- A Super Blue ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

Equipment Cost:	\$73,281
Less 20%:	<u>\$14,656</u>
	\$58,625
Plus - Spare Parts (Box of 10 Lamps)	NO CHARGE
Plus - Delivery, Installation & Training	<u>\$ 7,200</u>
	\$65,825

September 15, 1994

Press Purchase 3: Heidelberg Speedmaster CD 102 L+Y+L, 6 color with coating tower (L) with dummy unit for drying (Y) and with second coating tower (L) 40 inch press. PRI equipment to be purchased:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.
- A Super Blue ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.
- A Super Blue CUV 'Cold' UV Drying System for installation in the delivery.
Note: Utilizes WPC Chill Water System.

Equipment Cost:	\$181,216
Less 20%:	<u>\$ 36,243</u>
	\$144,973
Plus - Spare Parts (Box of 10 IR Lamps), 3 UV Lamps, 2 Filter Tubes, Deionizing Resin	NO CHARGE
Plus - Delivery, Installation & Training	<u>\$ 13,600</u>
	\$158,573

Press Purchase 4: Heidelberg Speedmaster CD 102, 8 color with coating tower 40 inch press:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.
- A Super Blue ABII Air Blanket II 2KW Infra-Red Drying System for installation in the delivery.

Equipment Cost:	\$ 89,023
Less 20%:	<u>\$ 17,805</u>
	\$ 71,218
Plus - Delivery, Installation & Training	<u>\$ 8,000</u>
	\$ 79,218

Press Purchase 5: Heidelberg Speedmaster CD 102, 8 color with coating tower 40 inch press:

- A Super Blue HV High Velocity Hot Air Drying System for installation between printing units.

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| Equipment Cost: | \$ 89,023 |
| Less 20%: | <u>\$ 17,805</u> |
| | \$ 71,218 |
| Plus - Delivery, Installation & Training | <u>\$ 8,000</u> |
| | \$ 79,218 |

A. We have discounted the total PRI drying equipment price of \$528,956 by supplying WPC the drying equipment for Press Purchase 1 at no charge and by allowing a further discount of 20% against the drying equipment for Press Purchases 2, 3, 4, 5.

B. We are supplying three recommended spare parts systems at no charge, all three of which to be supplied with PRI equipment for press purchases 1, 2, and 3.

C. We are extending our standard warranty conditions, Paragraph 3 'Terms of Proposal', Paragraph 6 'Sales Terms and Conditions' from 12 months to 24 months.

Sincerely yours,

Vehr

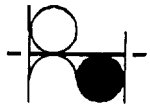
John Bird
Product Manager

JB:tj

cc: Bill Davis - Williamson Printing Corporation
Woody Dixon - Williamson Printing Corporation

THESE DE LA

18



Printing Research, Inc.

"Mark-less" Super BlueSM

December 16, 1994

Mr. Bill Davis
Williamson Printing Corporation
6700 Denton Drive
Dallas TX 75229

Dear Bill,

We have enclosed drawings showing the 5 Heidelberg Speedmaster CD press configurations ordered by yourselves.

We look forward to our test runs on the Super Blue EZ Blanket Coater next week.

Sincerely yours,

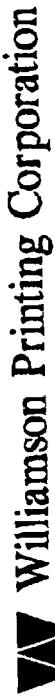
John Bird
Product Manager

JB:ln

Enclosures: DWG

cc: Steve Baker

TECHNOLOGY

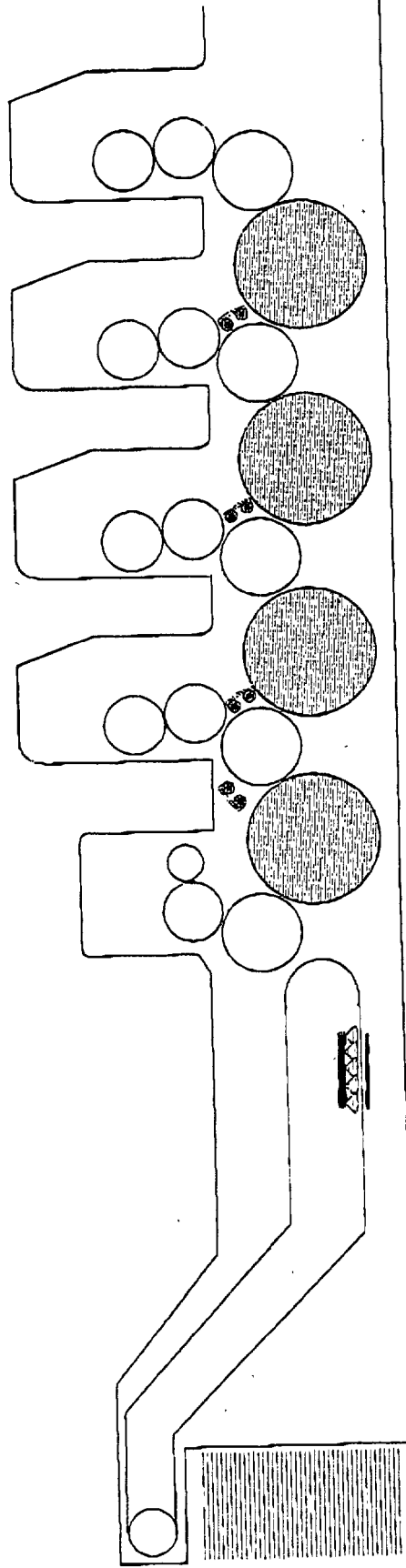


Williamson Printing Corporation


Press No. 1, 2, 4 & 5

Heidelberg Speedmaster CD


with Coating Tower
and Extended Delivery



Legend:

 Super Blue® Wash-Free Anti-Marking Cylinder

 Super Blue® Air Blanket Infrared Dryer

 Super Blue® High Velocity Hot Air Dryer

Printing Research, Inc.

SKP 43033

TÜBINGEN STEB

IR 250-4L
H4 182132

HAK-P8
H4 181629

cold-air-knife
H4 182133

guide plate
H4 181937

connected load: 480V/60Hz
71kW/116A (SG+L)
64kW/104A (SK+L)

SKP 35826

IR/HAK

GRAFIX

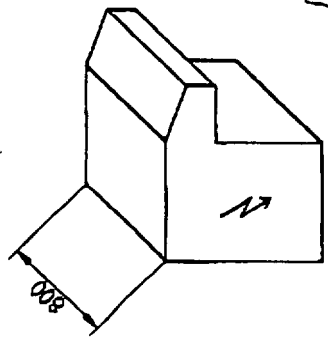
Maßstab 1:20

HDM SG+L+ext.(SK+L+ext.)
with GRAFIX exhaust guide plates

H4 182520

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Zust. Änderung Datum Name



1040 12 K

THE END OF THE

January 25, 1995

Mr. Jesse Williamson
Williamson Printing Corporation
6700 Denton Drive
Dallas TX 75235

214-904-2100 (Phone)

Dear Jesse,

It was a great pleasure speaking with you. We have enclosed product information and the following Super Blue proposal for installation on your:

Heidelberg 102CD+L+Y+L, 6 color, 40 inch press with extension

We propose:

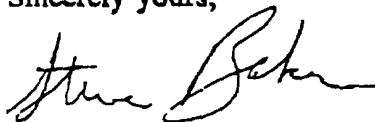
- A Super Blue EZB Blanket Coater for installation at the blanket cylinder.

The benefits to you of installing the Super Blue Coater System are as follows:

- Automatic recirculation system
- Automated wash up procedure
- Consistent overall coating weight
- Sealed doctor blade assembly
- Totally independent of dampening system
- Elimination of lengthy wash up procedures

We look forward to serving your needs and thank you for your interest in our Super Blue range of products. For more information please contact us at 1-800-627-5537.

Sincerely yours,



Steve Baker
District Sales Manager

SB:nw

Enclosures: P/PRO/DWG

cc: Bill Davis - Williamson Printing Corporation
John Bird
Steve Garner

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W F & L
Printing Research, Inc.

"Mark-less" Super Blue®

February 16, 1995

Mr. Jesse Williamson
Williamson Printing Company
6700 Denton Drive
Dallas, Texas 75235

214-904-2100 (Phone)

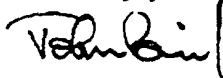
Dear Jesse,

Further to our meeting of 2-11-95 we confirm the following:

- 1066050-96151260
1. We are producing an experimental EZ interstation flexo printer coater for installation on your Heidelberg Speedmaster CD 6 color + LYL, 40 inch press with a target to be installed and operational date of March 15, 1995. This unit for adaptation to the first coating tower of the LYL.
 2. The experimental EZ coater will have a coating face length of 39.5 inches. Production models for the Coater position 'L' will have a coating face length of 40.55 inches and for interstation printing unit positions will have a coating face length of not less than 38 inches.
 3. The experimental EZ coater will be supplied at no charge to Williamson Printing Company. We anticipate that this unit will be replaced by a production unit at a later date.
 4. We have enclosed updated proposals for Super Blue EZ interstation flexo printer coaters for installation on your Heidelberg Speedmaster CD presses.

We look forward to serving your needs and thank you for your interest in our Super Blue range of products. For more information please contact us at 1-800-627-5537.

Sincerely yours,

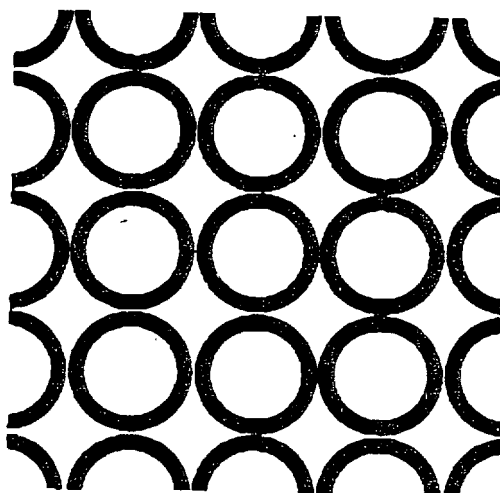


John Bird
Product Manager

JB:tj

cc: Bill Davis - Williamson Printing Company
Howard DeMoore
Steve Garner
Ed Schaffler
Dave Douglas
Steve Baker

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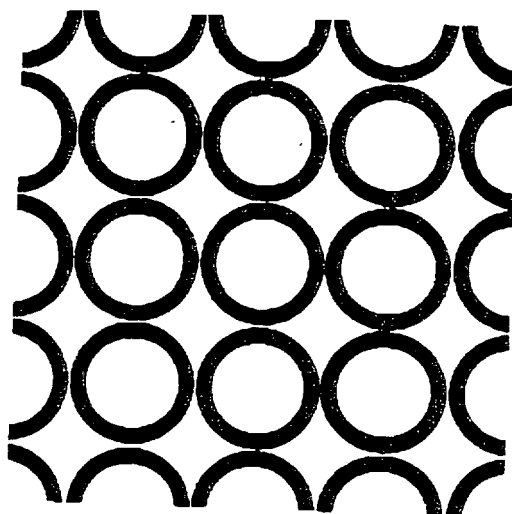


SUPER BLUE

***THE EZ PRINT/
COAT FAMILY***

***MAXIMUM FLEXIBILITY AND
A TOUCH OF BRILLIANCE***





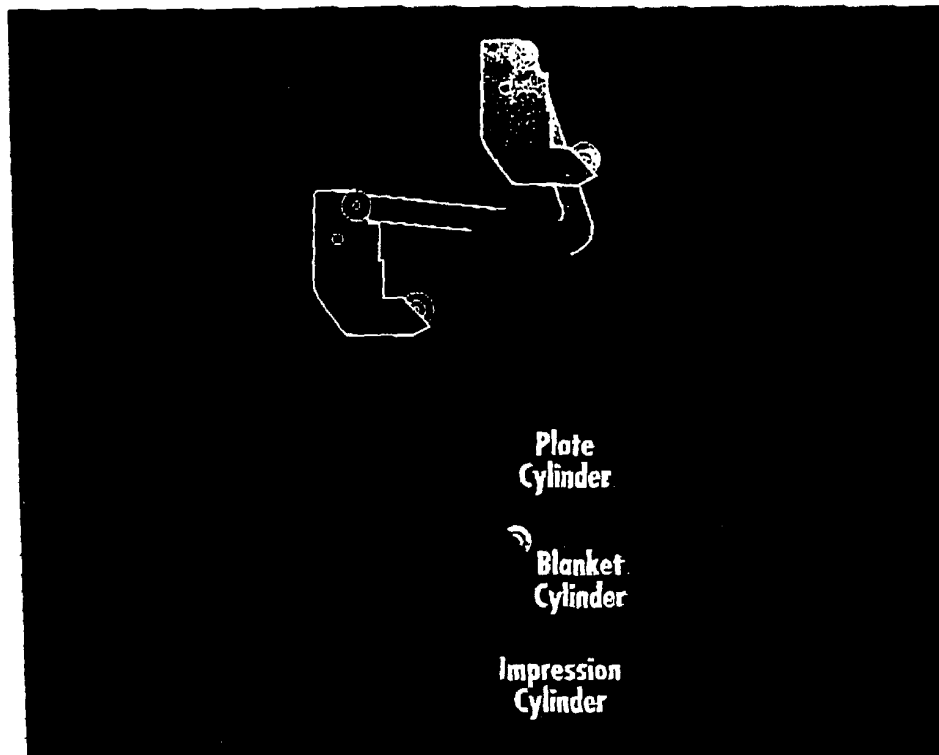
SUPER BLUE

**THE EZ PRINT/
COAT FAMILY**

**MAXIMUM FLEXIBILITY AND
A TOUCH OF BRILLIANCE**



Add Innovative In-Line Interstation and End of Press Printing Coating.



Patents Pending

The Super Blue EZ Interstation Flexo Printer/Coater is installed directly onto a print unit, for applying any one of a number of aqueous or UV based metallic/opaque inks between print units.

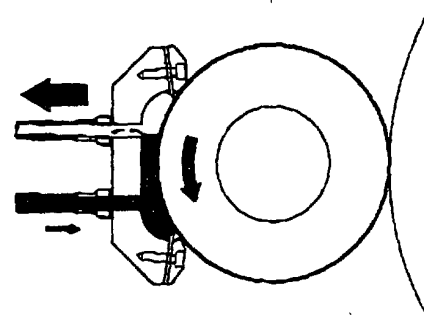
Have you ever wanted to add in-line coating capabilities, metallic, opaque, or other specialized applications to specific print units? Was your decision not to enter this market influenced by mediocre quality, undesirable environmental considerations, or the prohibitive cost?

Search no more ... Your needs and concerns have been resolved!

Printing Research, Inc., invites you to review the patented family of EZ Print/Coat products as described in this brochure. We are confident that you will find the perfect solution to your present and future printing demands.

EZ Interstation Flexo Printer/Coater

The Super Blue EZ Interstation Flexo Printer/Coater is retractable so that it can be swung up and above the print unit for conventional printing or swung into the blanket position to offer complete application variations from job to job. The patented coating head assembly is comprised of two main components. A combination of engraved anilox rolls are offered to provide a consistent overall ink/coating weight. The anilox rolls yield excellent ink/coating release and lay characteristics with no fear of plugging, leaking, or misting due to the unique enclosed doctor blade assembly.



Patent Pending

The EZ Print/Coat Family utilizes a universal coating head configuration for superior ink and coating transfer.

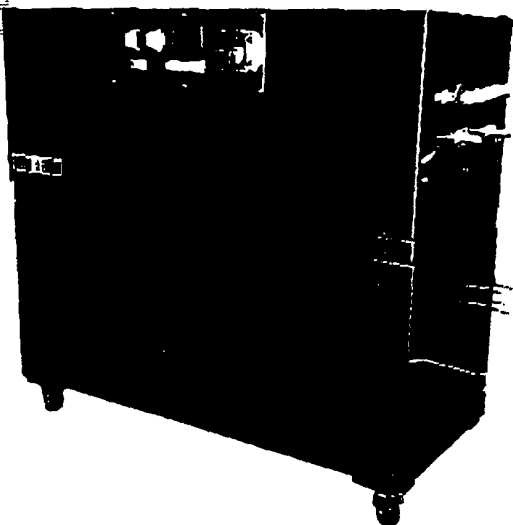
EZ Blanket Coater

The Super Blue EZ Blanket Coater is mounted such that the coating head can be automatically removed from its coating position for conventional use of the last print unit as well as full operator access. Although the EZ Blanket Coater is an end of press retrofit, it offers the same coating release and lay characteristics without fear of plugging, leaking, or slinging due to the same unique enclosed doctor blade assembly.

EZ Automatic Pump and Recirculation System

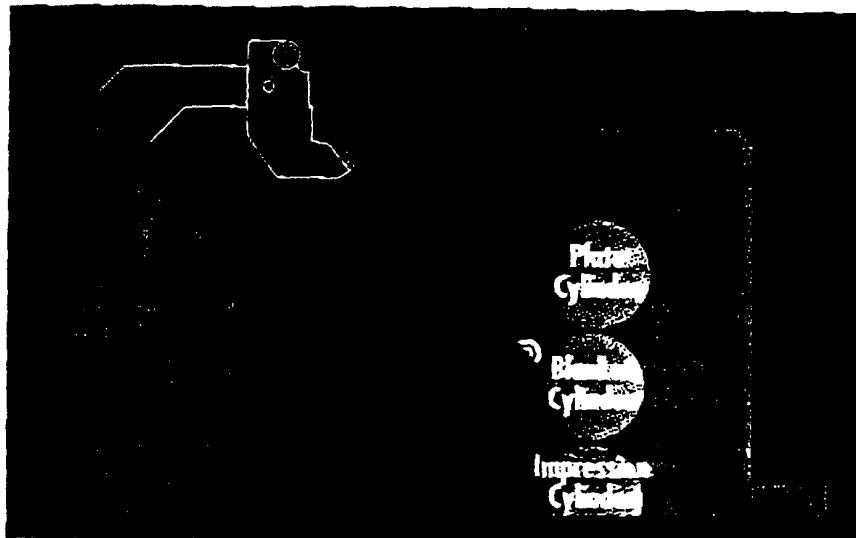
The Super Blue EZ Automatic Pump and Recirculation system is designed to eliminate the headaches associated with other pump systems and complicated wash-up procedures that impact your production time and bottom line. The circulation system is a standard component that allows the operator to push a button and walk away. Whether you are purging, coating, washing-up or by-passing each is fully automated and timed. In addition, the clean-up water reservoir is heated to provide optimum line and head cleaning.

The Super Blue EZ Automatic Pump and Recirculation System is offered as a separate product to suit most anilox coating systems, whether it be a blanket coater, tower coater, flexographic coater or web coater.



Patented

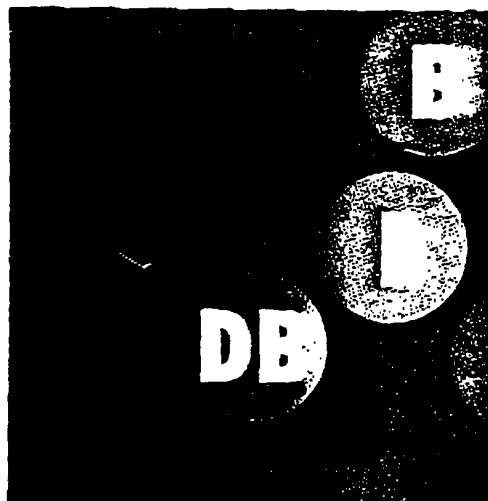
The Super Blue EZ Automatic Pump and Recirculation System is common to the entire EZ Print/Coat Family as a standard component.



Patented and Patents Pending

The Super Blue EZ Blanket Coater is installed directly onto the delivery or coating/dummy unit of your press for applying any one of a number of aqueous or UV coatings or inks at the last print unit blanket cylinder.

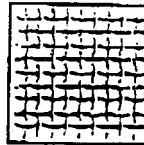
The Super Blue EZ Impression Cylinder Coater is installed between the gripper chain rails of the press delivery, but utilizes its own delivery blanket cylinder to add a coating unit without losing a print unit.



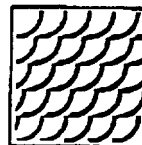
Patented



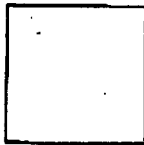
Super Blue® I and II
Anti-Marking Systems



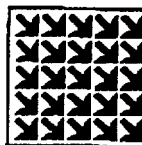
Super Blue® BACVAC
Vacuum Transfer and
Delivery Systems



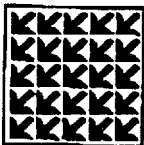
Super Blue® High
Velocity Hot Air Dryers



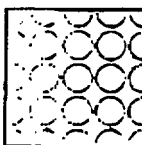
Super Blue® Air Blanket
I and II Infra-Red
Drying Systems



Super Blue® Water Cooled
and 'Cold' UV Dryers



Super Blue® In-Line and
Off-Line Coaters



SUPER BLUE®



TOP SECRET



Printing Research, Inc.

10954 Shady Trail Dallas, Texas 75220 U.S.A.

Telephone: 214-353-9000


Telex: 794028 Superblue dal

Fax: 214-357-5847

1-800-MARK-LESS
(1-800-627-5537)



Another Fine Product From The Makers Of The Patented Super Blue® System



Telephone: 214-353-9000
Telex: 794028 Superblue dal
Fax: 214-357-5847



Another Fine Product From The Makers Of The Patented Super Blue[™] System

TOP SECRET

Instant-drying inks and the elimination of spray powder have been the dream of every printer and printing buyer. The idea was put forward in the 1970's and 80's that it would be possible to print with conventional inks and apply a coating which would dry completely before placement on the delivery stack. This would place a dry skin over the ink, eliminating offsetting, sheet marking and the need for spray powder. The inks dry under the coating.

The advent of the 90's has made the dream a reality. It is now possible to print superior quality with conventional inks and coat the surface in order to deliver a dry, mark-free sheet at full production speeds. This is what the Super Blue products from Printing Research accomplish for you.



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Patented

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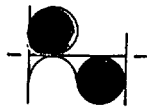
Printing Research, Inc.

10954 Shady Trail Dallas, Texas 75220 U.S.A.

Telephone 214-353-9000
Telex 794028 Superblue dal
Fax 214-357-5847

Patented

THESE



May 12, 1995

Mr. Jerry Williamson
Williamson Printing Corp.
6700 Denton Drive
Dallas TX 75235-4497

Dear Jerry,

It was a great pleasure for Steve Garner and me to meet with you, Jesse Williamson and Bill Davis. The following confirms our discussion:

1. **EZ Interstation Flexo Printer/Coater**

- A. Lithoflex as used by PRI to describe its EZ Printer/Coater process is not in conflict with WPC.
- B. PRI is preparing comment for an upcoming coating article in Graphic Arts Monthly relative to the EZ Printer/Coater family, as well as a presentation for the GATF Sheetfed Conference June 25-27, 1995. Both GAM and GATF would like input from WPC. We are suggesting that they both contact you direct.
- C. An order for one Super Blue EZ Interstation Flexo Printer/Coater (your PO 3315) for installation on the first printing unit of your Heidelberg Speedmaster CD 6+LYL is in hand. We anticipate delivery to be approximately 90 days. The price of the coater is to be negotiated. WPC will continue to use PRI's experimental coater installed on the Heidelberg Speedmaster CD 7+L press until PRI has delivered and installed the EZI.
- D. A separate discussion document addressing exclusivity is attached.

2. **Heidelberg Speedmaster CD 6+LYL (Press #3)**

- A. Gloss readings have been taken of the spot water based primer UV overcoat printing job that had various products (golf club, sports shoe, electrical connectors, etc.). The findings are as follows:
 1. Highlight areas -- 97 points (toe of shoe)
 2. Heavy black solids -- 74 points (electrical connectors)
 3. Solid blue -- 84 points (credit card)

We all concluded that this was a classic case of dry back and that we should press forward with the installation of HV on this press to alleviate such dry back problems and also to dry metallic or specialist water based inks in the future.

Country	Year	Population (millions)	Urban population (millions)	Urban population (%)	Population growth rate (%)	Urban population growth rate (%)	Population density (per sq km)	Urban population density (per sq km)
Algeria	1980	10.5	4.5	42.9	2.5	3.5	105	230
Algeria	1985	11.5	5.5	47.8	2.8	4.0	115	260
Algeria	1990	12.5	6.5	52.0	3.0	4.5	125	290
Algeria	1995	13.5	7.5	55.6	3.2	5.0	135	320
Algeria	2000	14.5	8.5	58.6	3.5	5.5	145	350
Algeria	2005	15.5	9.5	61.3	3.8	6.0	155	380
Algeria	2010	16.5	10.5	63.6	4.0	6.5	165	410
Algeria	2015	17.5	11.5	65.7	4.2	7.0	175	440
Algeria	2020	18.5	12.5	67.6	4.5	7.5	185	470
Algeria	2025	19.5	13.5	69.2	4.8	8.0	195	500
Algeria	2030	20.5	14.5	70.7	5.0	8.5	205	530
Algeria	2035	21.5	15.5	72.1	5.2	9.0	215	560
Algeria	2040	22.5	16.5	73.3	5.5	9.5	225	590
Algeria	2045	23.5	17.5	74.5	5.8	10.0	235	620
Algeria	2050	24.5	18.5	75.5	6.0	10.5	245	650
Algeria	2055	25.5	19.5	76.5	6.2	11.0	255	680
Algeria	2060	26.5	20.5	77.4	6.5	11.5	265	710
Algeria	2065	27.5	21.5	78.2	6.8	12.0	275	740
Algeria	2070	28.5	22.5	78.9	7.0	12.5	285	770
Algeria	2075	29.5	23.5	79.7	7.2	13.0	295	800
Algeria	2080	30.5	24.5	80.3	7.5	13.5	305	830
Algeria	2085	31.5	25.5	81.0	7.8	14.0	315	860
Algeria	2090	32.5	26.5	81.6	8.0	14.5	325	890
Algeria	2095	33.5	27.5	82.1	8.2	15.0	335	920
Algeria	2100	34.5	28.5	82.6	8.5	15.5	345	950
Algeria	2105	35.5	29.5	83.1	8.8	16.0	355	980
Algeria	2110	36.5	30.5	83.6	9.0	16.5	365	1010
Algeria	2115	37.5	31.5	84.0	9.2	17.0	375	1040
Algeria	2120	38.5	32.5	84.4	9.5	17.5	385	1070
Algeria	2125	39.5	33.5	84.8	9.8	18.0	395	1100
Algeria	2130	40.5	34.5	85.2	10.0	18.5	405	1130
Algeria	2135	41.5	35.5	85.5	10.2	19.0	415	1160
Algeria	2140	42.5	36.5	85.9	10.5	19.5	425	1190
Algeria	2145	43.5	37.5	86.2	10.8	20.0	435	1220
Algeria	2150	44.5	38.5	86.5	11.0	20.5	445	1250
Algeria	2155	45.5	39.5	86.8	11.2	21.0	455	1280
Algeria	2160	46.5	40.5	86.9	11.5	21.5	465	1310
Algeria	2165	47.5	41.5	87.2	11.8	22.0	475	1340
Algeria	2170	48.5	42.5	87.4	12.0	22.5	485	1370
Algeria	2175	49.5	43.5	87.7	12.2	23.0	495	1400
Algeria	2180	50.5	44.5	88.1	12.5	23.5	505	1430
Algeria	2185	51.5	45.5	88.3	12.8	24.0	515	1460
Algeria	2190	52.5	46.5	88.6	13.0	24.5		

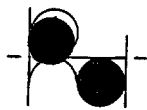
Page 2

- We look forward to a continued successful partnership.**

John Bird

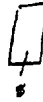
JB:ln

cc: Jesse Williamson/Williamson Printing Corp.
Bill Davis/Williamson Printing Corp. ✓
Bob Emrick/Williamson Printing Corp.
Steve Garner/PRI
Steve Baker/PRI



Printing Research, Inc.

"Mark-less" Super Blue®



**WPC/PRI PARTNERING AGREEMENT FOR THE SUPER BLUE EZ
INTERSTATION FLEXO PRINTER/COATER**



1. PRI agrees to manufacture and supply one Super Blue EZ Interstation Flexo Printer/Coater (PO #3315) on an exclusive basis.
2. Exclusive is to be interpreted to mean that PRI will not supply to printers in the commercial litho offset printing market for a period and territory to be defined.
3. Exclusions include the litho offset printing markets of folding carton, label, and greeting cards.
 - A. North America, including Mexico and Canada, will be exclusive to WPC for 6 months from the date of delivery of the EZ Interstation Flexo Printer/Coater (PO #3315). 12
 - B. Texas and its contiguous states (Louisiana, Arkansas, Oklahoma, New Mexico) and including Arizona and Colorado will be exclusive for a further 6 months, equaling 12 months from the date of delivery of the EZ Interstation Flexo Printer/Coater. 2 1/2
4. PRI defines 6 months and 12 months exclusivity 3A and 3B to mean PRI will not accept an order for a Super Blue EZ Interstation Flexo Printer/Coater for installation on a printing unit prior to the last printing unit of a press.
5. PRI may request during the term of this agreement to supply to other commercial printers and WPC may not ~~reasonably~~ decline.

RECEIVED SEP 10 1993

THESE DOCUMENTS

United States Patent [19]

DeMoore et al.

[11] Patent Number: 5,598,777

[45] Date of Patent: Feb. 4, 1997

[54] RETRACTABLE PRINTING/COATING UNIT
OPERABLE ON THE PLATE AND BLANKET
CYLINDERS[75] Inventors: Howard W. DeMoore, 10954 Shady
Trail, Dallas, Tex. 75220; Ronald M.
Rendleman, Dallas; John W. Bird,
Carrollton, both of Tex.

[73] Assignee: Howard W. DeMoore, Dallas, Tex.

[21] Appl. No.: 538,274

[22] Filed: Oct. 2, 1995

[51] Int. Cl.⁶ B41F 5/02; B41F 5/22;
B41F 31/36

[52] U.S. Cl. 101/177; 101/352

[58] Field of Search 101/349, 350,
101/351, 352, 207, 208-210, 363, 364,
147, 148, 143, 144, 217, 218, 177, 247;
118/258-262, 46, 263

[56] References Cited

U.S. PATENT DOCUMENTS

4,308,796 1/1982 Satterwhite 101/350
4,706,601 11/1987 Jahn 118/211

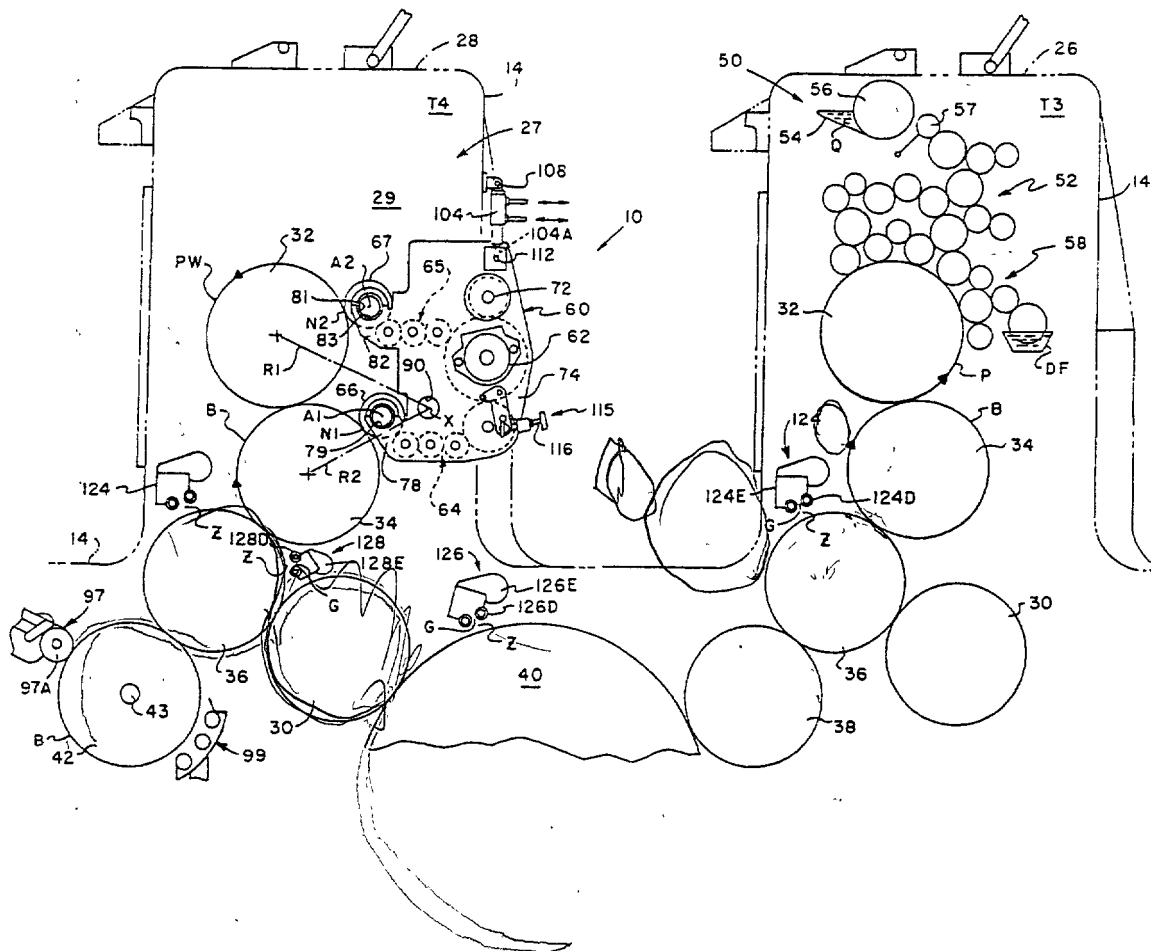
Primary Examiner—J. Reed Fisher

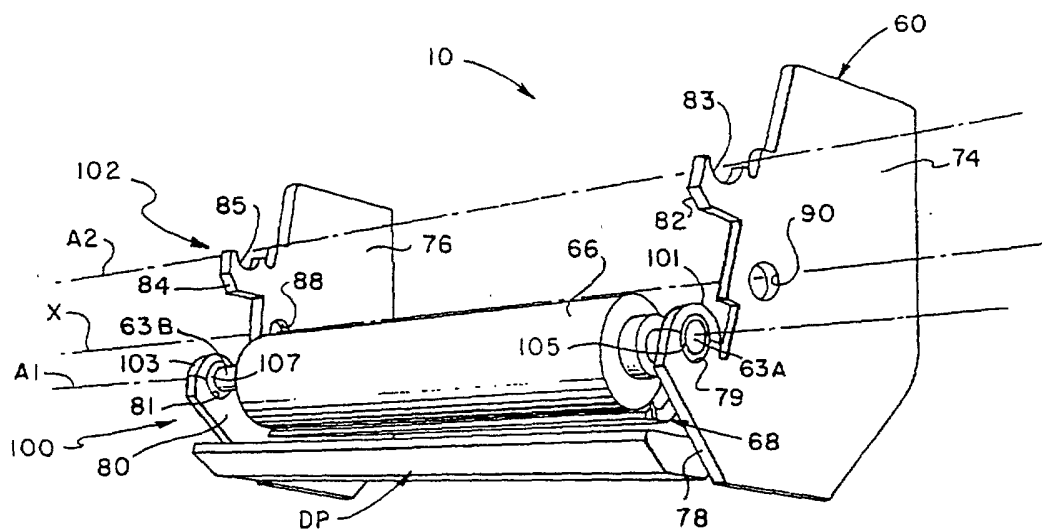
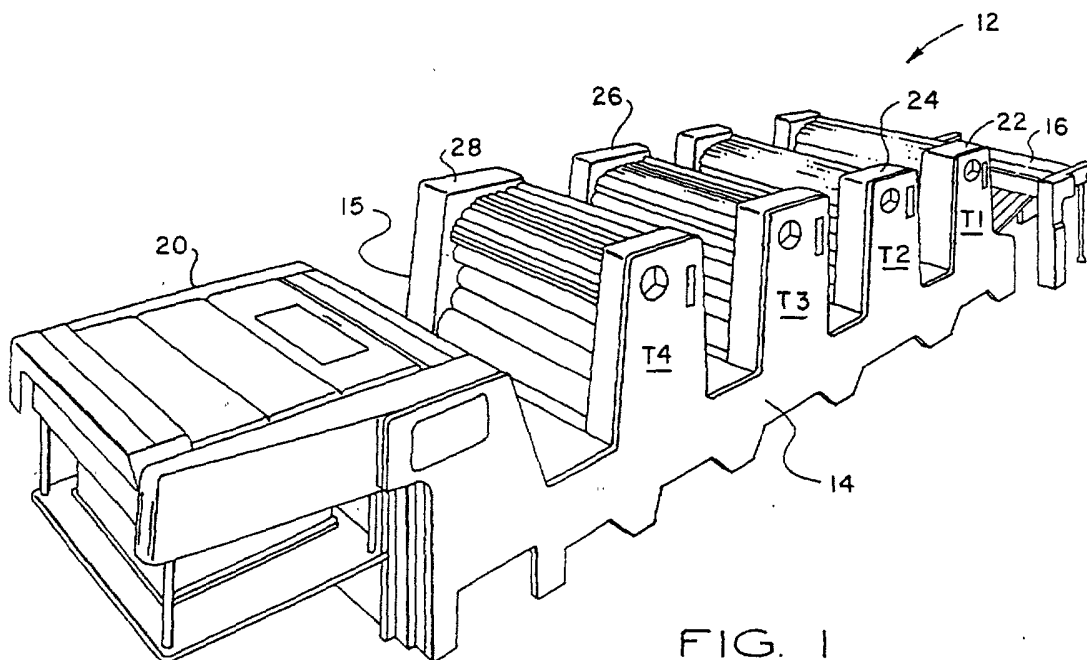
Attorney, Agent, or Firm—Sidley & Austin

[57] ABSTRACT

A retractable in-line inking/coating apparatus can apply either spot or overall inking/coating material to a plate and/or a blanket on the first printing unit or on any consecutive printing unit of any rotary offset printing press. The inking/coating apparatus is pivotally mounted within the conventional dampener space of any lithographic printing unit. The aqueous component of the flexographic printing ink or aqueous coating material is evaporated and dried by high velocity, hot air dryers and high performance heat and moisture extractors so that the aqueous or flexographic ink or coating material on a freshly printed or coated sheet is dry and can be dry-trapped on the next printing unit. The inking/coating apparatus includes dual cradles that support first and second applicator rollers so that the inking/coating apparatus can apply a double bump of aqueous/flexographic or UV-curable printing ink or coating material to a plate on the plate cylinder, while simultaneously applying aqueous, flexographic or UV-curable printing ink or coating material to a plate or a blanket on the blanket cylinder, and thereafter onto a sheet as the sheet is transferred through the nip between the blanket cylinder and the impression cylinder. A triple bump is printed or coated on the last printing unit with the aid of an impression cylinder inking/coating unit.

19 Claims, 10 Drawing Sheets





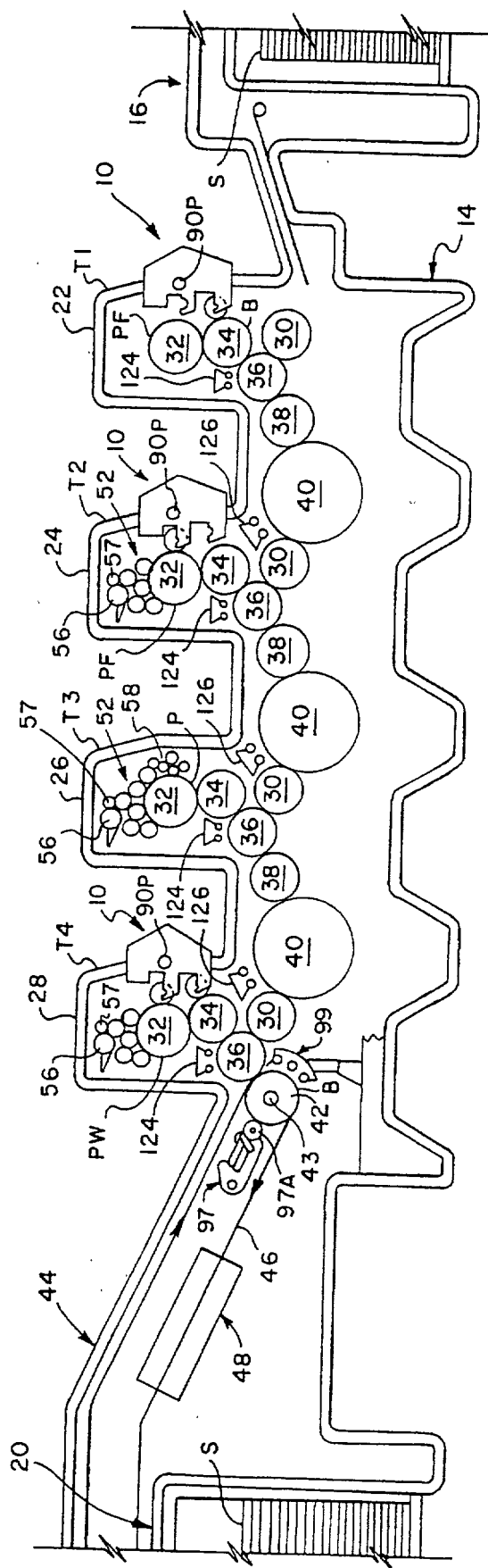


FIG. 3

FIG. 3

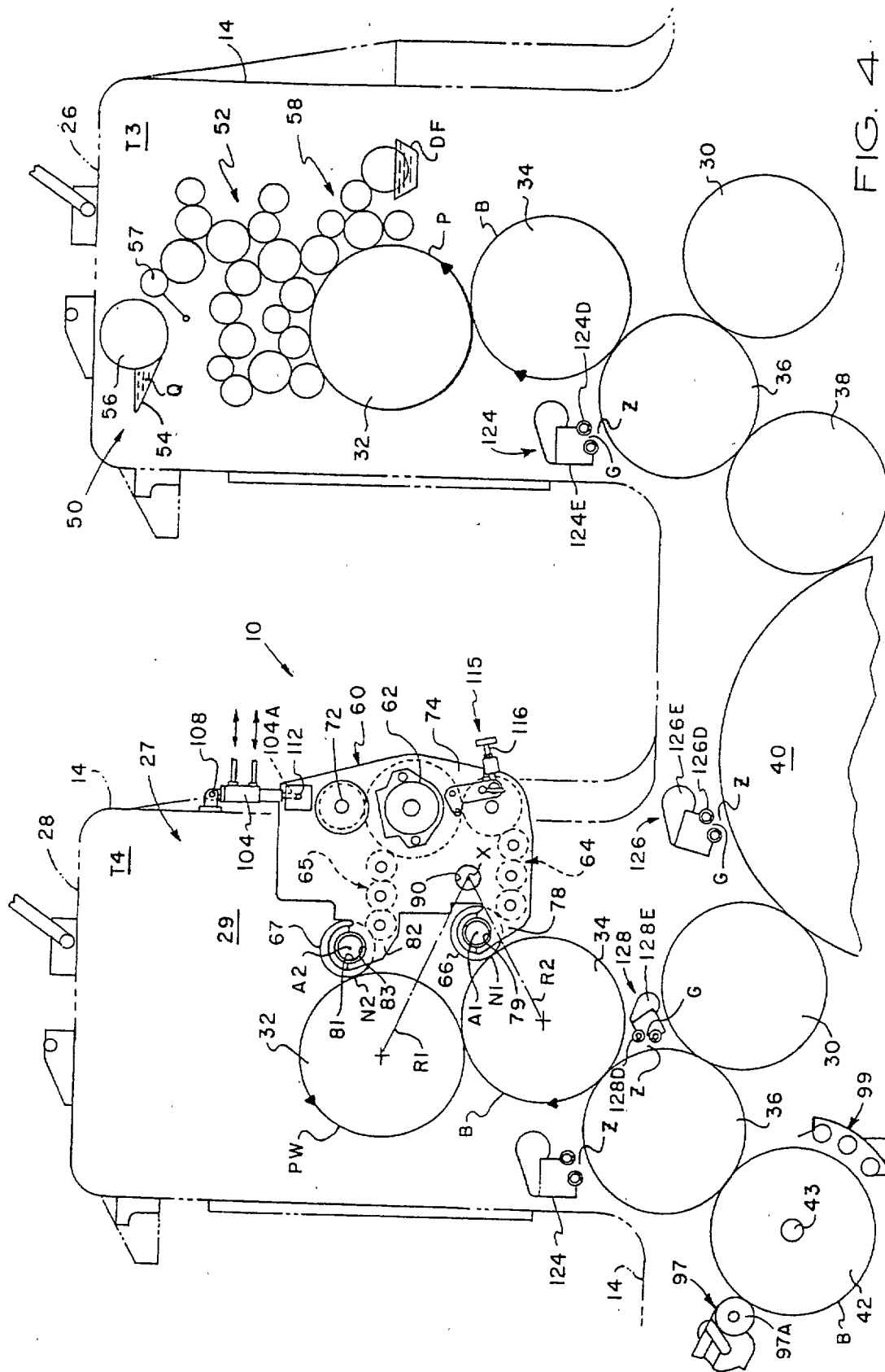


FIG. 4

TOP VIEW OF FIG. 5

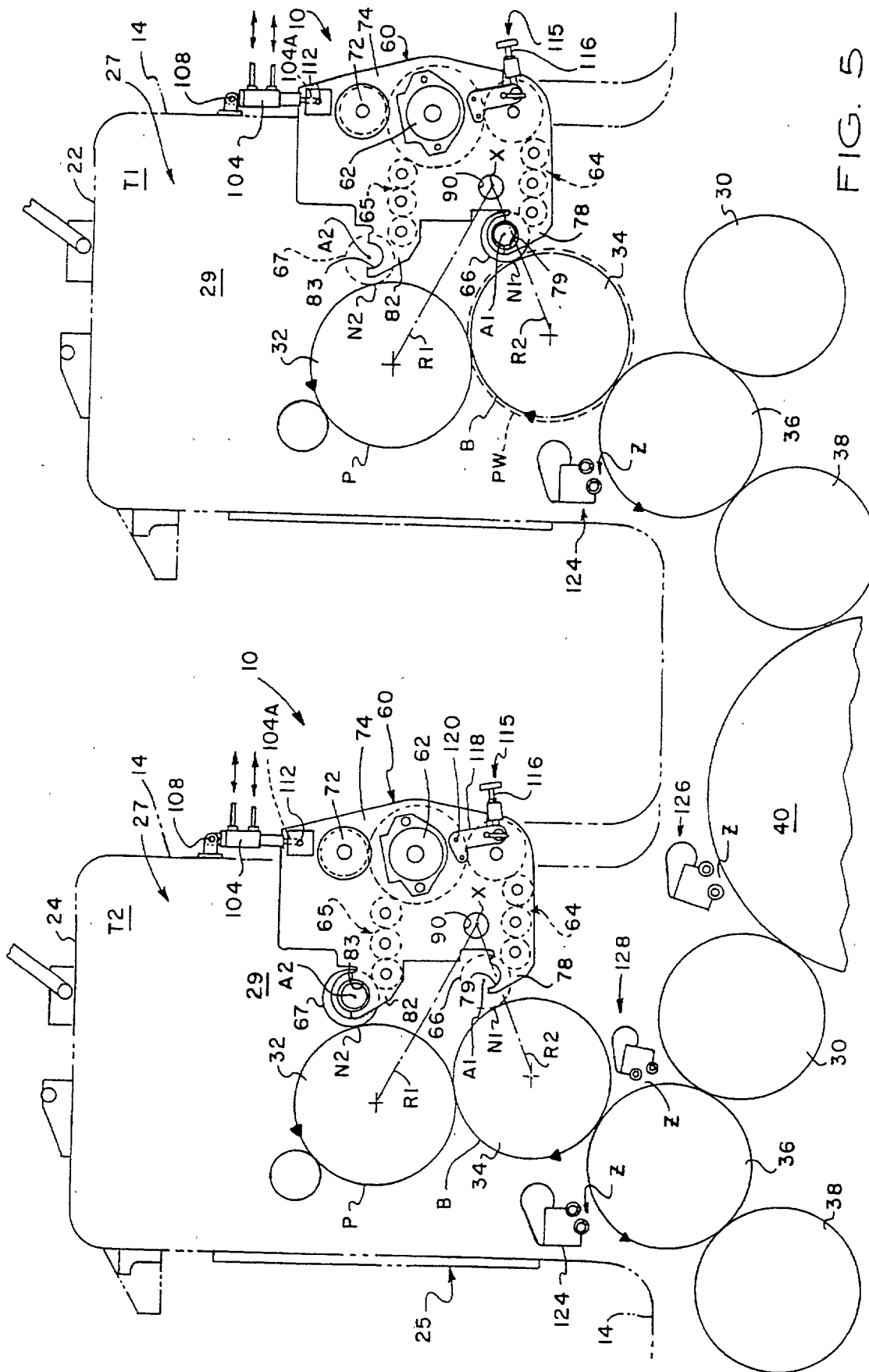


FIG. 5

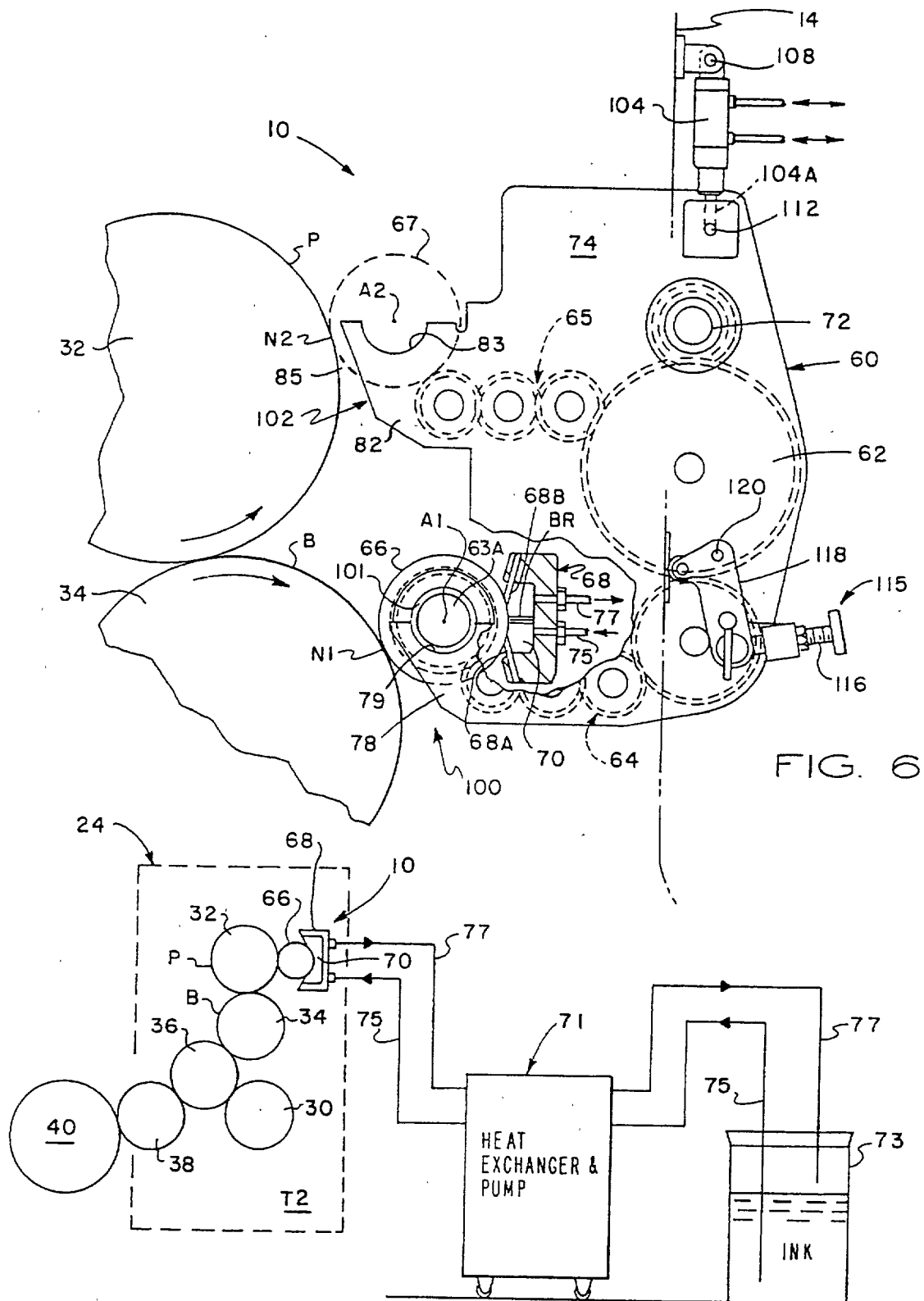


FIG. 7

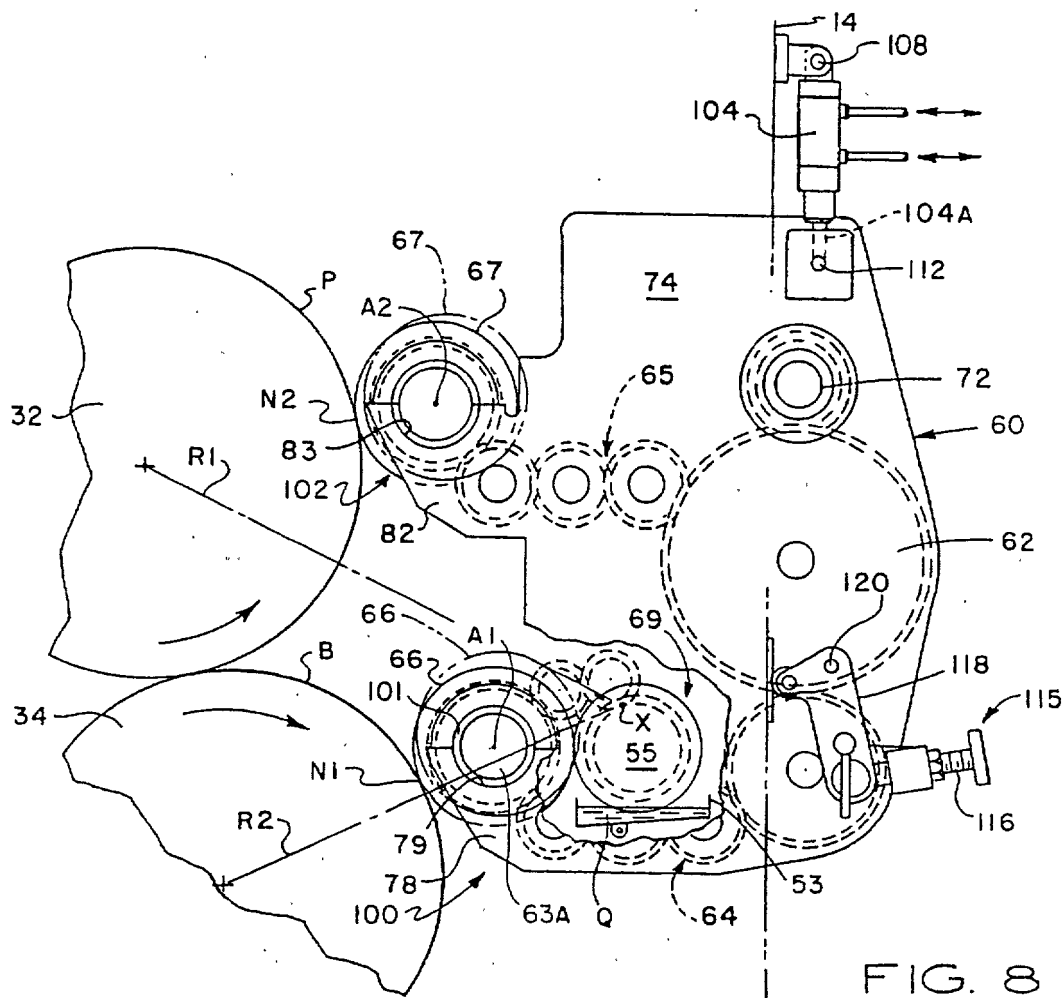


FIG. 8

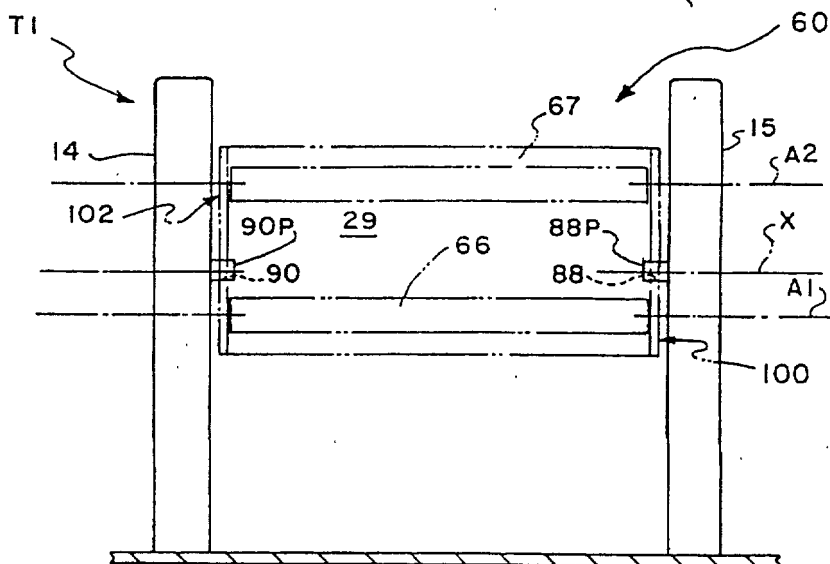


FIG. 9

FIG. 8

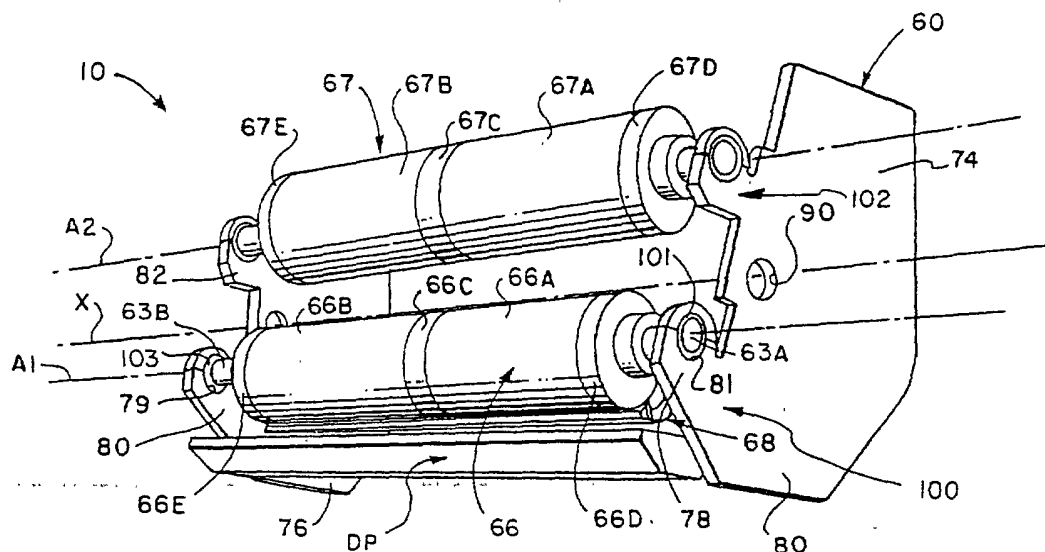


FIG. 10

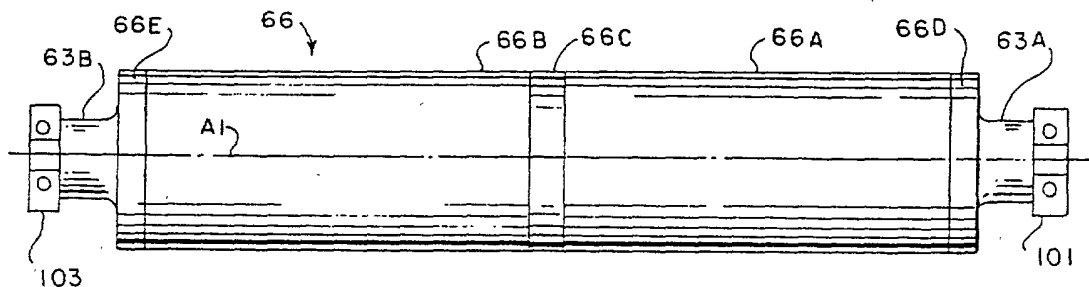


FIG. 11

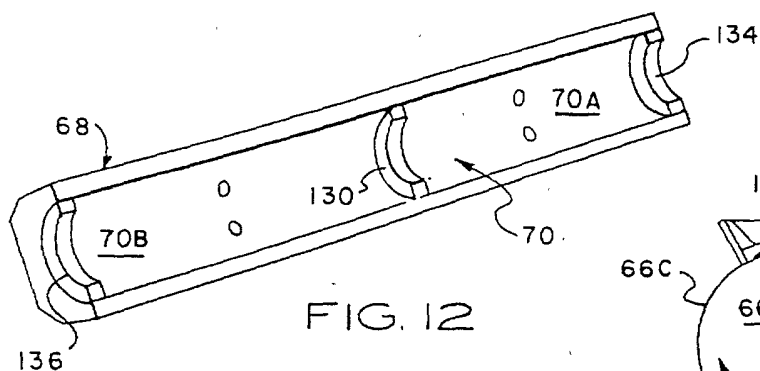


FIG. 12

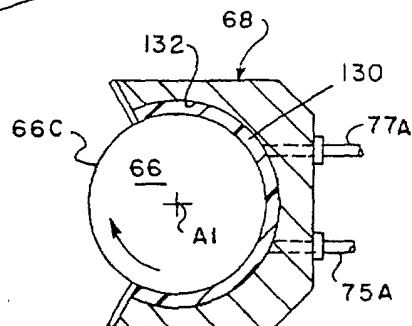


FIG. 13

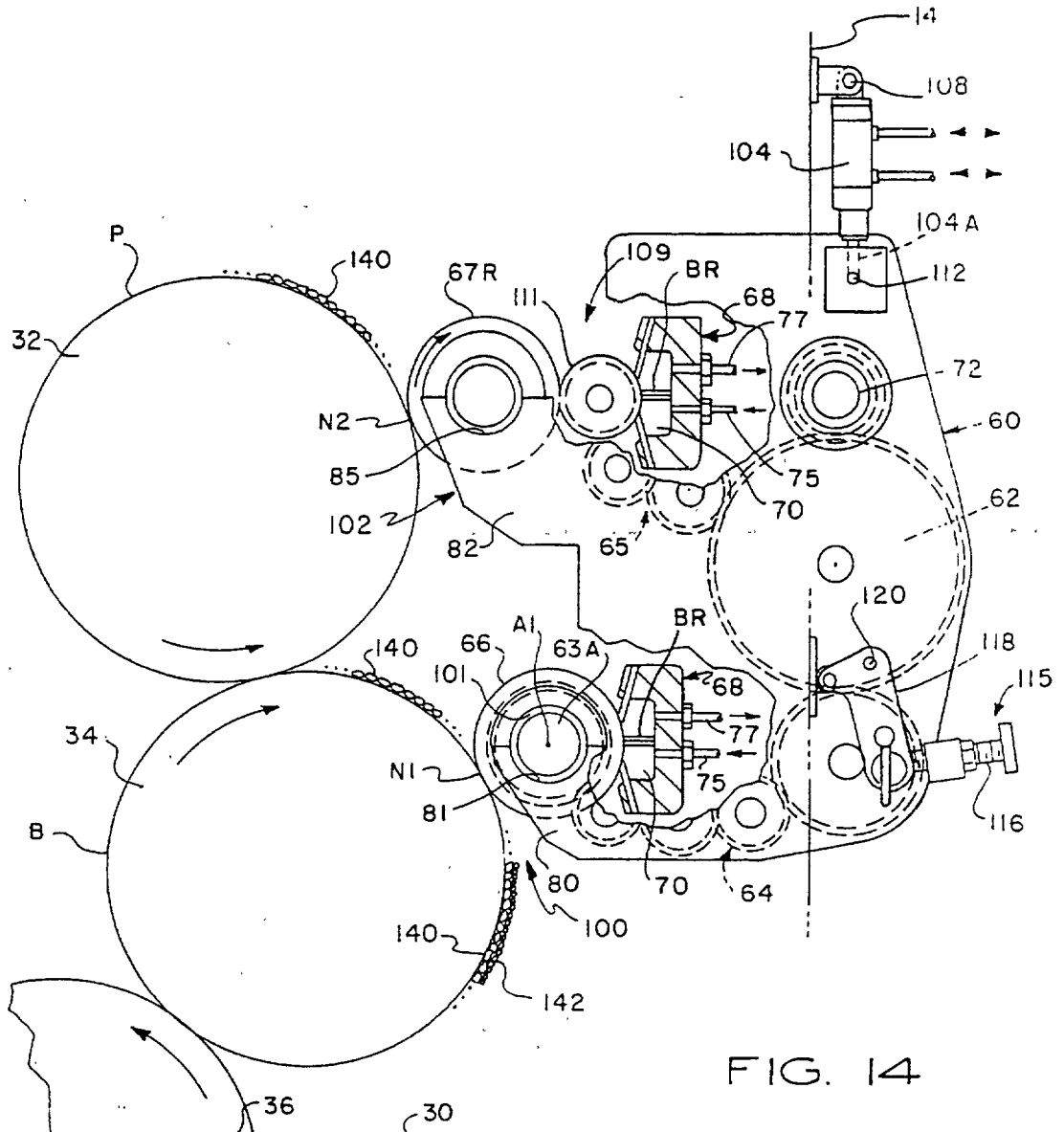


FIG. 14



FIG. 15

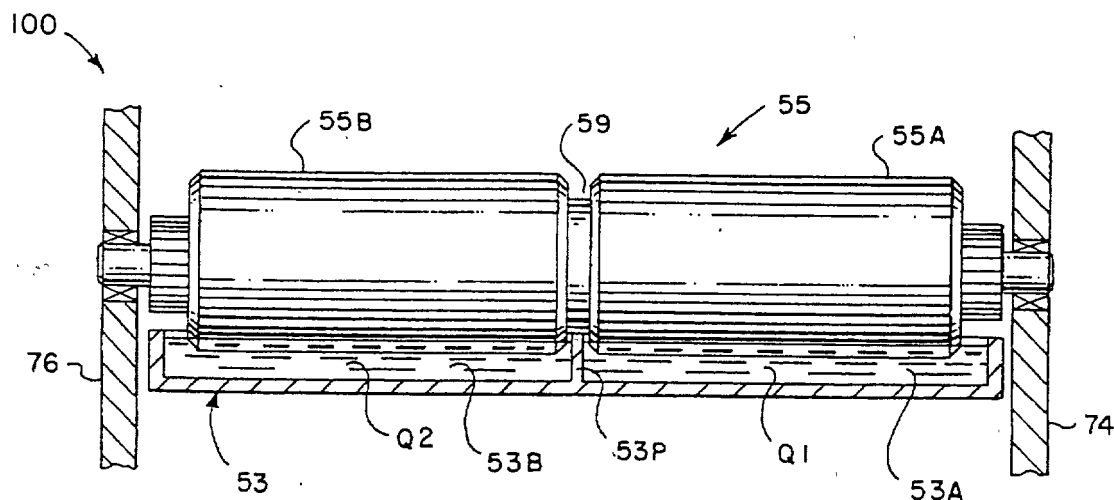


FIG. 16

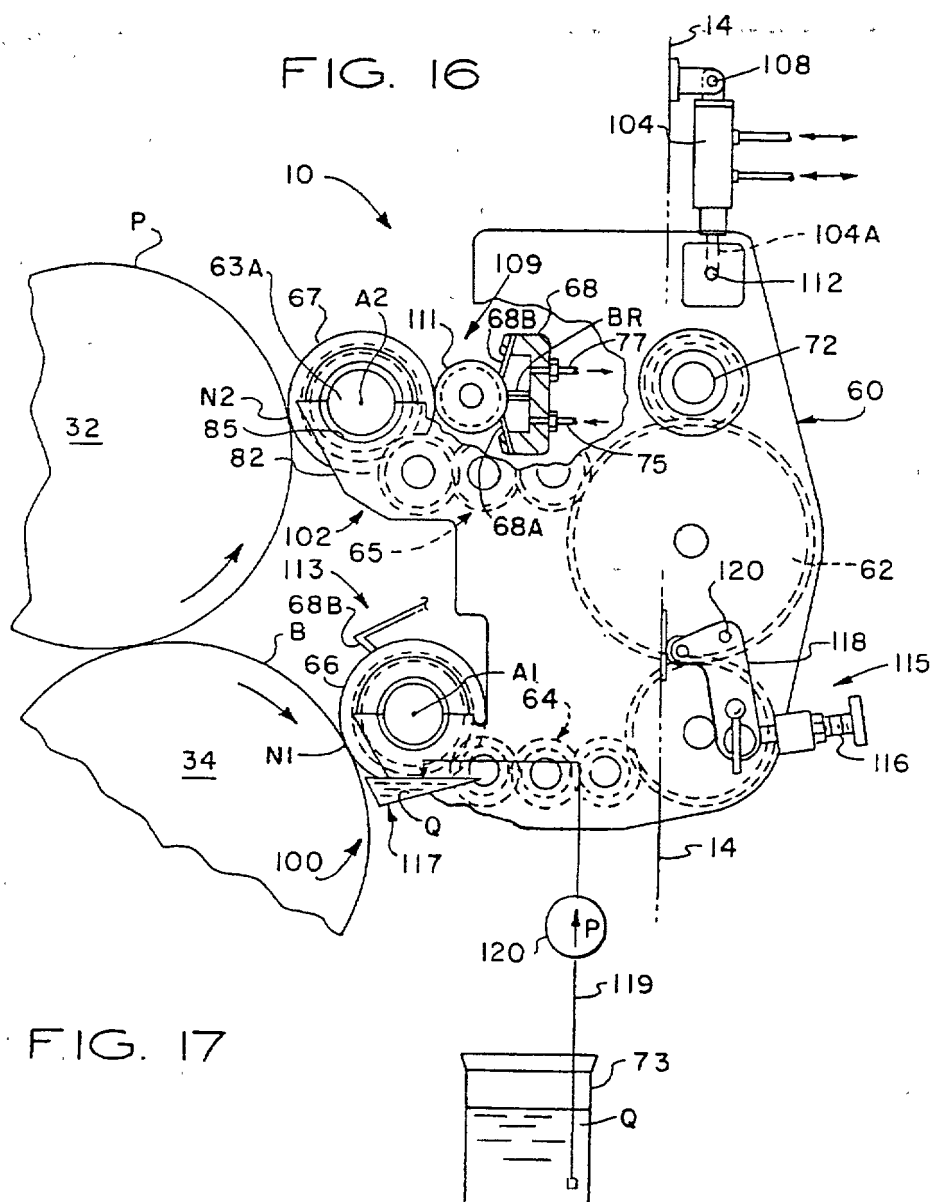


FIG. 17

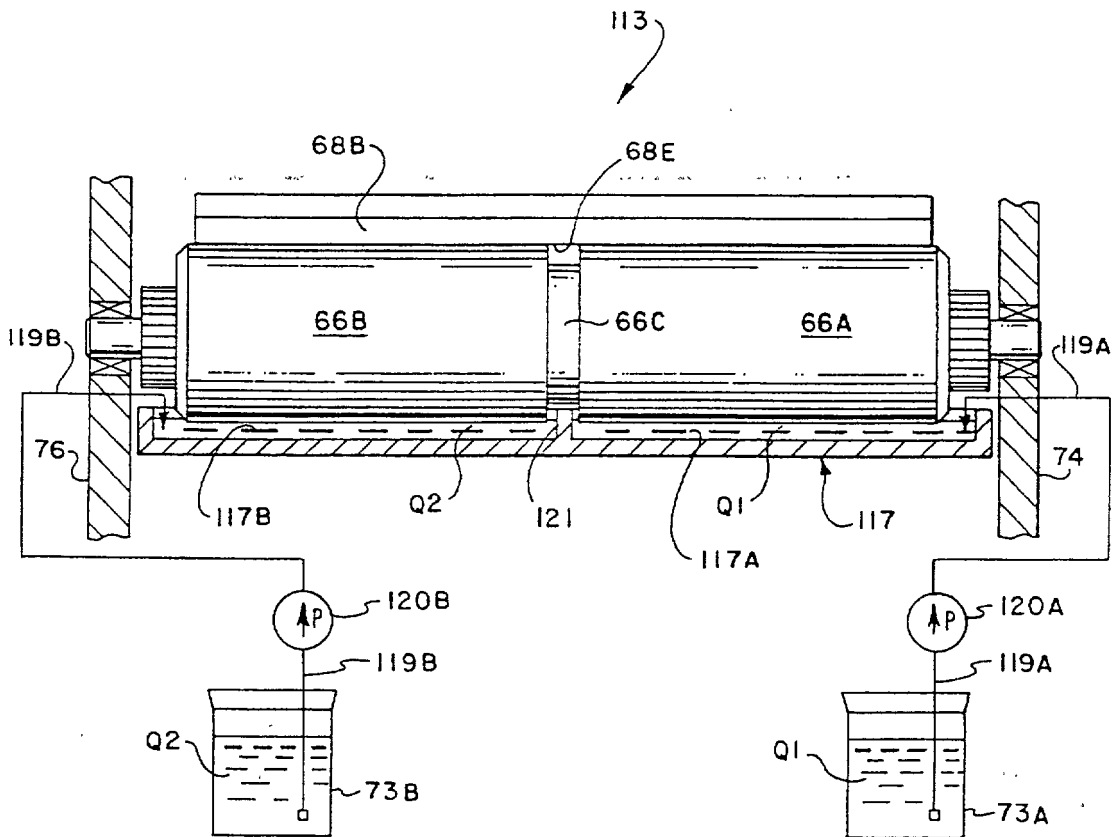


FIG. 18

RETRACTABLE PRINTING/COATING UNIT OPERABLE ON THE PLATE AND BLANKET CYLINDERS

FIELD OF THE INVENTION

This invention relates generally to sheet-fed or web-fed, rotary offset lithographic printing presses, and more particularly, to a new and improved inking/coating apparatus for the in-line application of aqueous or flexographic printing inks, primer or protective/decorative coatings applied simultaneously to the plate and blanket of the first or any consecutive printing unit of any lithographic printing press.

BACKGROUND OF THE INVENTION

Conventional sheet-fed, rotary offset printing presses typically include one or more printing units through which individual sheets are fed and printed. After the last printing unit, freshly printed sheets are transferred by a delivery conveyor to the delivery end of the press where the freshly printed and/or coated sheets are collected and stacked uniformly. In a typical sheet-fed, rotary offset printing press such as the Heidelberg Speedmaster line of presses, the delivery conveyor includes a pair of endless chains carrying gripper bars with gripper fingers which grip and pull freshly printed sheets from the last impression cylinder and convey the sheets to the sheet delivery stacker.

Since the inks used with sheet fed rotary offset printing presses are typically wet and tacky, special precautions must be taken to prevent marking and smearing of the freshly printed or coated sheets as the sheets are transferred from one printing unit to another. The printed ink on the surface of the sheet dries relatively slowly and is easily smeared during subsequent transfer between printing units. Marking, smearing and smudging can be prevented by a vacuum assisted sheet transfer apparatus as described in the following U.S. Pat. Nos.: 5,113,255; 5,127,329; 5,205,217; 5,228,391; 5,243,909; and 5,419,254, all to Howard W. DeMoore, co-inventor, and manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A. under its trademark BACVAC™.

In some printing jobs, offsetting is prevented by applying a protective and/or decorative coating material over all or a portion of the freshly printed sheets. Some coatings are formed of a UV-curable or water-dispersed resin applied as a liquid solution over the freshly printed sheets to protect the ink from offsetting or set-off and improve the appearance of the freshly printed sheets. Such coatings are particularly desirable when decorative or protective finishes are applied in the printing of posters, record jackets, brochures, magazines, folding cartons and the like.

DESCRIPTION OF THE PRIOR ART

Various arrangements have been made for applying the coating as an in-line printing operation by using the last printing unit of the press as the coating application unit. For example, U.S. Pat. Nos. 4,270,483; 4,685,414; and 4,779,557 disclose coating apparatus which can be moved into position to permit the blanket cylinder of the last printing unit of a printing press to be used to apply a coating material over the freshly printed sheets. In U.S. Pat. No. 4,841,903 (Bird) there are disclosed coating apparatus which can be selectively moved between the plate cylinder or the blanket cylinder of the last printing unit of the press so the last printing unit can only be used for coating purposes. However, when coating apparatus of these types are being used,

the last printing unit cannot be used to print ink to the sheets, but rather can only be used for the coating operation. Thus, while coating with this type of in-line coating apparatus, the printing press loses the capability of printing on the last printing unit as it is converted to a coating unit.

The coater of U.S. Pat. No. 5,107,790 (Sliker et al) is retractable along an inclined rail for extending and retracting a coater head into engagement with a blanket on the blanket cylinder. Because of its size, the rail-retractable coater can only be installed between the last printing unit of the press and the delivery sheet stacker, and cannot be used for interunit coating. The coater of U.S. Pat. No. 4,615,293 (Jahn) provides two separate, independent coaters located on the dampener side of a converted printing unit for applying lacquer to a plate and to a rubber blanket. Consequently, although a plate and blanket are provided, the coating unit of Jahn's press is restricted to a dedicated coating operation only.

Proposals have been made for overcoming the loss of a printing unit when in-line coating is used, for example as set forth in U.S. Pat. No. 5,176,077 to Howard W. DeMoore (co-inventor and assignee), which discloses a coating apparatus having an applicator roller positioned to apply the coating material to the freshly printed sheet while the sheet is still on the last impression cylinder of the press. This allows the last printing unit to print and coat simultaneously, so that no loss of printing unit capability results.

Some conventional coaters are rail-mounted and occupy a large amount of press space and reduce access to the press. Elaborate equipment is needed for retracting such coaters from the operative coating position to the inoperative position, which reduces access to the printing unit.

Accordingly, there is a need for an in-line inking/coating apparatus which does not result in the loss of a printing unit, does not extend the length of the press, and which can print and coat aqueous and flexographic inks and coating materials simultaneously onto the plate and blanket on any lithographic printing unit of any lithographic printing press, including the first printing unit.

OBJECTS OF THE INVENTION

Accordingly, a general object of the present invention is to provide improved inking/coating apparatus which is capable of selectively applying ink or coating material to a plate on a plate cylinder or ink or coating material to a plate or blanket on a blanket cylinder.

A specific object of the present invention is to provide improved inking/coating apparatus of the character described which is extendable into inking/coating engagement with either a plate on a plate cylinder or to a plate or blanket on a blanket cylinder.

A related object of the present invention is to provide improved inking/coating apparatus of the character described which is capable of being mounted on any lithographic printing unit of the press and does not interfere with operator access to the plate cylinder, blanket cylinder, or adjacent printing units.

Another object of the present invention is to provide improved inking/coating apparatus of the character described, which can be moved from an operative inking/coating engagement position adjacent to a plate cylinder or a blanket cylinder to a non-operative, retracted position.

Still another object of the present invention is to provide improved inking/coating apparatus of the character described, which can be used for applying aqueous, flexo-

graphic and ultra-violet curable inks and/or coatings in combination with lithographic, flexographic and waterless printing processes on any rotary offset printing press.

A related object of the present invention is to provide improved inking/coating apparatus of the character described, which is capable of applying aqueous or flexographic ink or coating material on one printing unit, for example the first printing unit, and drying the ink or coating material before it is printed or coated on the next printing unit so that it can be overprinted or overcoated immediately on the next printing unit with waterless, aqueous, flexographic or lithographic inks or coating materials.

Yet another object of the present invention is to provide improved inking/coating apparatus for use on a multiple color rotary offset printing press that can apply ink or coating material separately and/or simultaneously to the plate and/or blanket of a printing unit of the press from a single operative position, and from a single inking/coating apparatus.

A related object of the present invention is to provide improved inking/coating apparatus of the character described, in which virtually no printing unit adjustment or alteration is required when the inking/coating apparatus is converted from plate to blanket printing or coating and vice versa.

Another object of the present invention is to provide improved inking/coating apparatus that can be operably mounted in the dampener space of any lithographic printing unit for inking/coating engagement with either a plate on a plate cylinder or a plate or blanket on a blanket cylinder, and which does not interfere with operator movement or activities in the interunit space between printing units.

SUMMARY OF THE INVENTION

The foregoing objects are achieved by a retractable, in-line inking/coating apparatus which is mounted on the dampener side of any printing unit of a rotary offset press for movement between an operative (on-impression) inking/coating position and a retracted, disengaged (Off-impression) position. The inking/coating apparatus includes an applicator roller which is movable into and out of engagement with a plate on a plate cylinder or a blanket on a blanket cylinder. The inking/coating applicator head is pivotally coupled to a printing unit by pivot pins which are mounted on the press side frames in the traditional dampener space of the printing unit in parallel alignment with the plate cylinder and the blanket cylinder. This dampener space mounting arrangement allows the inking/coating unit to be installed between any adjacent printing units on the press.

In the preferred embodiment, the applicator head includes vertically spaced pairs of cradle members with one cradle pair being adapted for supporting an inking/coating applicator roller in alignment with a plate cylinder, and the other cradle pair supporting an inking/coating applicator roller in alignment with the blanket cylinder, respectively, when the applicator head is in the operative position. Because of the pivotal support provided by the pivot pins, the applicator head can be extended and retracted within the limited space available in the traditional dampener space, without restricting operator access to the printing unit cylinders and without causing a printing unit to lose its printing capability.

When the inking/coating apparatus is used in combination with a flexographic printing plate and aqueous or flexographic ink or coating material, the water component of the aqueous or flexographic ink or coating material on the

freshly printed or coated sheet is evaporated and dried by a high velocity, hot air interunit dryer and a high volume heat and moisture extractor assembly so that the freshly printed ink or coating material is dry before the sheet is printed or coated on the next printing unit. This quick drying process permits a base layer or film of ink, for example opaque white or metallic (gold, silver or other metallics) ink to be printed on the first printing unit, and then overprinted on the next printing unit without back-trapping or dot gain.

The construction and operation of the present invention will be understood from the following detailed description taken in conjunction with the accompanying drawings which disclose, by way of example, the principles and advantages of the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of a sheet fed, rotary offset printing press having inking/coating apparatus embodying the present invention;

FIG. 2 is a simplified perspective view of the single head, dual cradle inking/coating apparatus of the present invention;

FIG. 3 is a schematic side elevational view of the printing press of FIG. 1 having single head, dual cradle inking/coating apparatus installed in the traditional dampener position of the first, second and last printing units;

FIG. 4 is a simplified side elevational view showing the single head, dual cradle inking/coating apparatus in the operative inking/coating position for simultaneously printing on the printing plate and blanket on the fourth printing unit;

FIG. 5 is a simplified side elevational view showing the single head, dual cradle inking/coating apparatus in the operative position for spot or overall inking or coating on the blanket of the first printing unit, and showing the dual cradle inking/coating apparatus in the operative position for spot or overall inking or coating on the printing plate of the second printing unit;

FIG. 6 is a simplified side elevational view of the single head, dual cradle inking/coating apparatus of FIG. 4 and FIG. 5, partially broken away, showing the single head, dual cradle inking/coating apparatus in the operative coating position and having a sealed doctor blade reservoir assembly for spot or overall coating on the blanket;

FIG. 7 is a schematic view showing a heat exchanger and pump assembly connected to the single head, dual cradle inking/coating apparatus for circulating temperature controlled ink or coating material to the inking/coating apparatus;

FIG. 8 is a side elevational view, partially broken away, and similar to FIG. 6 which illustrates an alternative coating head arrangement;

FIG. 9 is a simplified elevational view of a printing unit which illustrates pivotal coupling of the inking/coating apparatus on the printing unit side frame members;

FIG. 10 is a view similar to FIG. 2 in which a pair of split applicator rollers are mounted in the upper cradle and lower cradle, respectively;

FIG. 11 is a side elevational view of a split applicator roller;

FIG. 12 is a perspective view of a doctor blade reservoir which is centrally partitioned by a seal element;

FIG. 13 is a sectional view showing sealing engagement of the split applicator roller against the partition seal element of FIG. 12;

FIG. 14 is a view similar to FIG. 8 which illustrates an alternative inking/coating embodiment;

FIG. 15 is a simplified side elevational view of a substrate which has a bronzed-like finish which is applied by simultaneous operation of the dual applicator roller embodiment of FIG. 14;

FIG. 16 is a side elevational view, partly in section, of a pan roller having separate transfer surfaces mounted on a split fountain pan;

FIG. 17 is a simplified side elevational view of the dual cradle inking/coating apparatus, partially broken away, which illustrates an alternative inking/coating head apparatus featuring a single doctor blade assembly, anilox applicator roller mounted on the lower cradle; and

FIG. 18 is a side elevational view, partly in section, of a single doctor blade anilox applicator roller assembly having separate transfer surfaces, and a split fountain pan having separate fountain compartments, with the separate fountain compartments being supplied with different inks or coating materials from separate off-press sources.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

As used herein, the term "processed" refers to printing and coating methods which can be applied to either side of a substrate, including the application of lithographic, waterless, UV-curable, aqueous and flexographic inks and/or coatings. The term "substrate" refers to sheet and web material. Also, as used herein, the term "waterless printing plate" refers to a printing plate having image areas and non-image areas which are oleophilic and oleophobic, respectively. "Waterless printing ink" refers to an oil-based ink which does not contain a significant aqueous component. "Flexographic plate" refers to a flexible printing plate having a relief surface which is wettable by flexographic ink or coating material. "Flexographic printing ink or coating material" refers to an ink or coating material having a base constituent of either water, solvent or UV-curable liquid. "UV-curable lithographic printing ink and coating material" refers to oil-based printing inks and coating materials that can be cured (dried) photomechanically by exposure to ultraviolet radiation, and that have a semi-paste or gel-like consistency. "Aqueous printing ink or coating material" refers to an ink or coating material that predominantly contains water as a solvent, diluent or vehicle. A "relief plate" refers to a printing plate having image areas which are raised relative to non-image areas which are recessed.

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line inking/coating apparatus, herein generally designated 10, for applying aqueous, flexographic or UV-curable inks or protective and/or decorative coatings to sheets or webs printed in a sheet-fed or web-fed, rotary offset printing press, herein generally designated 12. In this instance, as shown in FIG. 1, the inking/coating apparatus 10 is installed in a four unit rotary offset printing press 12, such as that manufactured by Heidelberg Druckmaschinen AG of Germany under its designation Heidelberg Speedmaster SM102 (40", 102 cm).

The press 12 includes a press frame 14 coupled at one end, herein the right end, to a sheet feeder 16 from which sheets, herein designated S, are individually and sequentially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the freshly printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical

sheet printing units 22, 24, 26 and 28 which can print four different colors onto the sheets as they are transferred through the press 12. The printing units are housed within printing towers T1, T2, T3 and T4 formed by side frame members 14, 15. Each printing tower has a delivery side 25 and a dampener side 27. A dampener space 29 is partially enclosed by the side frames on the dampener side of the printing unit.

As illustrated, the printing units 22, 24, 26 and 28 are substantially identical and of conventional design. The first printing unit 22 includes an in-feed transfer cylinder 30, a plate cylinder 32, a blanket cylinder 34 and an impression cylinder 36, all supported for rotation in parallel alignment between the press side frames 14, 15 which define printing unit towers T1, T2, T3 and T4. Each of the first three printing units 22, 24 and 26 have a transfer cylinder 38 disposed to transfer the freshly printed sheets from the adjacent impression cylinder and transfer the freshly printed sheets to the next printing unit via an intermediate transfer drum 40.

The last printing unit 28 includes a delivery cylinder 42 mounted on a delivery shaft 43. The delivery cylinder 42 supports the freshly printed sheet 18 as it is transferred from the last impression cylinder 36 to a delivery conveyor system, generally designated 44, which transfers the freshly printed sheet to the sheet delivery stacker 20. To prevent smearing during transfer, a flexible covering is mounted on the delivery cylinder 42, as described and claimed in U.S. Pat. No. 4,402,267 to Howard W. DeMoore, which is incorporated herein by reference. The flexible covering is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE®. Optionally, a vacuum-assisted sheet transfer assembly manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark BACVAC® can be substituted for the delivery transfer cylinder 42 and flexible covering.

The delivery conveyor system 44 as shown in FIG. 3 is of conventional design and includes a pair of endless delivery gripper chains 46, only one of which is shown carrying at regular spaced locations along the chains, laterally disposed gripper bars having gripper fingers used to grip the leading edge of a freshly printed or coated sheet 18 after it leaves the nip between the impression cylinder 36 and delivery cylinder 42 of the last printing unit 28. As the leading edge is gripped by the gripper fingers, the delivery chains 46 pull the sheet away from the last impression cylinder 36 and convey the freshly printed or coated sheet to the sheet delivery stacker 20.

Prior to reaching the delivery sheet stacker, the freshly printed and/or coated sheets S pass under a delivery dryer 48 which includes a combination of infra-red thermal radiation, high velocity hot air flow and a high performance heat and moisture extractor for drying the ink and/or the protective/decorative coating. Preferably, the delivery dryer 48, including the high performance heat and moisture extractor is constructed as described in U.S. application Ser. No. 08/116,711, filed Sep. 3, 1993, entitled "Infra-Red Forced Air Dryer and Extractor" by Howard C. Secor, Ronald M. Rendleman and Paul D. Copenhagen, commonly assigned to the assignee of the present invention, Howard W. DeMoore, and licensed to Printing Research, Inc. of Dallas, Tex., U.S.A., which manufactures and markets the delivery dryer 48 under its trademark AIR BLANKET™.

In the exemplary embodiment shown in FIG. 3, the first printing unit 22 has a flexographic printing plate PF mounted on the plate cylinder, and therefore neither an inking roller train nor a dampening system is required. A

flexographic printing plate PF is also mounted on the plate cylinder of the second printing unit 24. The form rollers of the inking roller train 52 shown mounted on the second printing unit 24 are retracted and locked off to prevent plate contact. Flexographic ink is supplied to the flexographic printing plate PF of the second printing unit 24 by the inking/coating apparatus 10.

A suitable flexographic printing plate PF is offered by E. I. du Pont de Nemours of Wilmington, Del., U.S.A., under its trademark CYREL®. Another source is BASF Aktiengesellschaft of Ludwigshafen, Germany, which offers a suitable flexographic printing plate under its trademark NYLOFLEX®.

The third printing unit 26 as illustrated in FIG. 3 and FIG. 4 is equipped for lithographic printing and includes an inking apparatus 50 having an inking roller train 52 arranged to transfer ink Q from an ink fountain 54 to a lithographic plate P mounted on the plate cylinder 32. This is accomplished by a fountain roller 56 and a ductor roller 57. The fountain roller 56 projects into the ink fountain 54, whereupon its surface picks up ink. The lithographic printing ink Q is transferred from the fountain roller 56 to the inking roller train 52 by the ductor roller 57. The inking roller train 52 supplies ink Q to the image areas of the lithographic printing plate P.

The lithographic printing ink Q is transferred from the lithographic printing plate P to an ink receptive blanket B which is mounted on the blanket cylinder 34. The inked image carried on the blanket B is transferred to a substrate S as the substrate is transferred through the nip between the blanket cylinder 34 and the impression cylinder 36.

The inking roller arrangement 52 illustrated in FIG. 3 and FIG. 4 is exemplary for use in combination with lithographic ink printing plates P. It is understood that a dampening system 58 having a dampening fluid reservoir DF is coupled to the inking roller train 52 (FIG. 4), but is not required for waterless or flexographic printing.

The plate cylinder 32 of printing unit 28 is equipped with a waterless printing plate PW. Waterless printing plates are also referred to as dry planographic printing plates and are disclosed in the following U.S. Pat. Nos.: 3,910,187; Reissue 30,670; U.S. Pat. No. 4,086,093; and U.S. Pat. No. 4,853,313. Suitable waterless printing plates can be obtained from Toray Industries, Inc. of Tokyo, Japan. A dampening system is not used for waterless printing, and waterless (oil-based) printing ink is used. The waterless printing plate PW has image areas and non-image areas which are oleophilic/hydrophilic and oleophobic/hydrophobic, respectively. The waterless printing plate PW is engraved or etched, with the image areas being recessed with respect to the non-image areas. The image area of the waterless printing plate PW is rolled-up with the flexographic or aqueous printing ink which is transferred by the applicator roller 66. Both aqueous and oil-based inks and coatings are repelled from the non-image areas, and are retained in the image areas. The printing ink or coating is then transferred from the image areas to an ink or coating receptive blanket B and is printed or coated onto a substrate S.

For some printing jobs, a flexographic plate PF or a waterless printing plate PW is mounted over a resilient packing such as the blanket B on the blanket cylinder 34, for example as indicated by phantom lines in printing unit 22 of FIG. 5. An advantage of this alternative embodiment is that the waterless plate PW or the flexographic plate PF are resiliently supported over the blanket cylinder by the underlying blanket B or other resilient packing. The radial deflec-

tion and give of the resilient blanket B provides uniform, positive engagement between the applicator roller 66 and a flexographic plate or waterless plate.

In that arrangement, a plate is not mounted on the plate cylinder 32; instead, a waterless plate PW is mounted on the blanket cylinder, and the inked image on the waterless printing plate is not offset but is instead transferred directly from the waterless printing plate PW to the substrate S. The water component of flexographic ink on the freshly printed sheet is evaporated by high velocity, hot air dryers and high volume heat and moisture extractors so that the freshly printed aqueous or flexographic ink is dried before the substrate is printed on the next printing unit.

Referring now to FIG. 2, FIG. 3 and FIG. 9, the inking/coating apparatus 10 is pivotally mounted on the side frames 14, 15 for rotation about an axis X. The inking/coating apparatus 10 includes a frame 60, a hydraulic motor 62, a lower gear train 64, an upper gear train 65, an applicator roller 66, a sealed doctor blade assembly 68 (FIG. 6), and a drip pan DP, all mounted on the frame 60. The external peripheral surface of the applicator roller 66 is wetted by contact with liquid coating material or ink contained in a reservoir 70.

The hydraulic motor 62 drives the applicator roller 66 synchronously with the plate cylinder 32 and the blanket cylinder 34 in response to an RPM control signal from the press drive (not illustrated) and a feedback signal developed by a tachometer 72. While a hydraulic drive motor is preferred, other drive means such as an electric drive motor or an equivalent can be used.

When using waterless printing plate systems, the temperature of the waterless printing ink and of the waterless printing plate must be closely controlled for good image reproduction. For example, for waterless offset printing with TORAY waterless printing plates PW, it is absolutely necessary to control the waterless printing plate surface and waterless ink temperature to a very narrow range, for example 24° C. (75° F.) to 27° C. (80° F.).

Referring to FIG. 7, the reservoir 70 is supplied with ink or coating which is temperature controlled by a heat exchanger 71. The temperature controlled ink or coating material is circulated by a positive displacement pump, for example a peristaltic pump, through the reservoir 70 and heat exchanger 71 from a source 73 through a supply conduit 75 and a return conduit 77. The heat exchanger 71 cools or heats the ink or coating material and maintains the ink or coating and the printing plate within the desired narrow temperature range.

According to one aspect of the present invention, aqueous/flexographic ink or coating material is supplied to the applicator roller 66, which transfers the aqueous/flexographic ink or coating material to the printing plate (FIG. 7), which may be a waterless printing plate or a flexographic printing plate. When the inking/coating apparatus is used for applying aqueous/flexographic ink or coating material to a waterless printing plate PW, the inking roller train 52 is not required, and is retracted away from the printing plate. Because the viscosity of aqueous/flexographic printing ink or coating material varies with temperature, it is necessary to heat or cool the aqueous/flexographic printing ink or coating material to compensate for ambient temperature variations to maintain the ink viscosity in a preferred operating range.

For example, the temperature of the printing press can vary from around 60° F. (15° C.) in the morning, to around 85° F. (29° C.) or more in the afternoon. The viscosity of

aqueous/flexographic printing ink or coating material can be marginally high when the ambient temperature of the press is near 60° F. (15° C.), and the viscosity can be marginally low when the ambient temperature of the press exceeds 85° F. (29° C.). Consequently, it is desirable to control the temperature of the aqueous/flexographic printing ink or coating material so that it will maintain the surface temperature of waterless printing plates within the specified temperature range. Moreover, the ink/coating material temperature should be controlled to maintain the tack of the aqueous/flexographic printing ink or coating material within a desired range when the ink or coating material is being used in connection with flexographic printing processes.

The applicator roller 66 is preferably an anilox fluid metering roller which transfers measured amounts of printing ink or coating material to a plate or blanket. The surface of an anilox roller is engraved with an array of closely spaced, shallow depressions referred to as "cells". Ink or coating from the reservoir 70 flows into the cells as the anilox roller turns through the reservoir. The transfer surface of the anilox roller is "doctored" (wiped or scraped) by dual doctor blades 68A, 68B to remove excess ink or coating material. The ink or coating metered by the anilox roller is that contained within the cells. The dual doctor blades 68A, 68B also seal the supply reservoir 70.

The anilox applicator roller 66 is cylindrical and may be constructed in various diameters and lengths, containing cells of various sizes and shapes. The volumetric capacity of an anilox roller is determined by cell size, shape and number of cells per unit area. Depending upon the intended application, the cell pattern may be fine (many small cells per unit area) or coarse (fewer large cells per unit area).

By supplying the ink or coating material through the inking/coating apparatus 10, more ink or coating material can be applied to the sheet S as compared with the inking roller train of a lithographic printing unit. Moreover, color intensity is stronger and more brilliant because the aqueous or flexographic ink or coating material is applied at a much heavier film thickness or weight than can be applied by the lithographic process, and the aqueous or flexographic colors are not diluted by dampening solution.

Preferably, the sealed doctor blade assembly 68 is constructed as described in U.S. Pat. No. 5,176,077 to Howard W. DeMoore, co-inventor and assignee, which is incorporated herein by reference. An advantage of using a sealed reservoir is that fast drying ink or coating material can be used. Fast drying ink or coating material can be used in an open fountain 53 (see FIG. 8); however, open air exposure causes the water and solvents in the fast-drying ink or coating material to evaporate faster, thus causing the ink or coating material to dry prematurely and change viscosity. Moreover, an open fountain emits unwanted odors into the press room. When the sealed doctor blade assembly is utilized, the pump (FIG. 7) which circulates ink or coating material to the doctor blade head is preferably a peristaltic pump, which does not inject air into the feeder lines which supply the ink or coating reservoir 70 and helps to prevent the formation of air bubbles and foam within the ink or coating material.

An inking/coating apparatus 10 having an alternative applicator roller arrangement is illustrated in FIGS. 10-13. In this arrangement, the engraved metering surface of the anilox applicator rollers 66, 67 are partitioned by smooth seal surfaces 66C which separates a first engraved peripheral surface portion 66A from a second engraved peripheral surface portion 66B. Likewise, smooth seal surfaces 66D,

66E are formed on the opposite end portions of the applicator roller 66 for engaging end seals 134, 136 (FIG. 12) of the doctor blade reservoir. The upper applicator roller 67 has engraved anilox metering surfaces 67A and 67B which are separated by a smooth seal band 67C.

Referring now to FIG. 12 and FIG. 13, the reservoir 70 of the doctor blade head 68 is partitioned by a curved seal element 130 to form two separate chambers 70A, 70B. The seal element 130 is secured to the doctor blade head within an annular groove 132. The seal element 130 is preferably made of polyurethane foam or other durable, resilient foam material. The seal element 130 is engaged by the seal band 66, thus forming a rotary seal which blocks the leakage of ink or coating material from one reservoir chamber into the other reservoir chamber. Moreover, the seal band provides an unprinted or uncoated area which separates the printed or coated areas from each other, which is needed for work and turn printing jobs or other printing jobs which print two or more separate images onto the same substrate.

Another advantage of the split applicator roller embodiment is that it enables two or more flexographic inks or coating materials to be printed simultaneously within the same lithographic printing unit. That is, the reservoir chambers 70A, 70B of the upper doctor blade assembly can be supplied with gold ink and silver ink, for example, while the reservoir chambers 70A, 70B of the lower doctor blade assembly can be supplied with inks of two additional colors, for example opaque white ink and blue ink. This permits the opaque white ink to be overprinted with the gold ink, and the blue ink to be overprinted with the silver ink on the same printing unit on any lithographic press.

Moreover, a catalyst can be used in the upper doctor blade reservoir and a reactive ink or coating material can be used in the lower doctor blade reservoir. This can provide various effects, for example improved chemical resistance and higher gloss levels.

The split applicator roller sections 67A, 67B in the upper cradle position can be used for applying two separate inks or coating materials simultaneously, for example flexographic, aqueous and ultra-violet curable inks or coating materials, to separate surface areas of the plate, while the lower applicator roller sections 66A, 66B can apply an initiator layer and a micro-encapsulated layer simultaneously to separate blanket surface areas. Optionally, the metering surface portions 66A, 66B can be provided with different cell metering capacities for providing different printing effects which are being printed simultaneously. For example, the screen line count on one half-section of an anilox applicator roller is preferably in the range of 200-600 lines per inch (79-236 lines per cm) for half-tone images, and the screen line count of the other half-section is preferably in the range of 100-300 lines per inch (39-118 lines per cm) for overall coverage, high weight applications such as opaque white. This split arrangement in combination with dual applicator rollers is particularly advantageous when used in connection with "work and turn" printing jobs.

Referring again to FIG. 8, instead of using the sealed doctor blade reservoir assembly 68 as shown in FIG. 6, an open fountain assembly 69 is provided by the fountain pan 53 which contains a volume of liquid ink Q or coating material. The liquid ink or coating material is transferred to the applicator roller 66 by a pan roller 55 which turns in contact with ink Q or coating material in the fountain pan. If a split applicator roller is used, the pan roller 55 is also split, and the pan is divided into two pan sections 53A, 53B by a separator plate 53P, as shown in FIG. 16.

In the alternative embodiment of FIG. 16, the pan roller 55 is divided into two pan roller sections 55A, 55B by a centrally located, annular groove 59. The separator plate 53P is received within and centrally aligned with the groove 59, but does not touch the adjoining roller faces. By this arrangement, two or more inks or coating materials Q1, Q2 are contained within the open pan sections 55A, 55B for transfer by the split pan roller sections 53A, 53B, respectively. This permits two or more flexographic inks or coating materials to be transferred to two separate image areas on the plate or on the blanket of the same printing unit. This arrangement is particularly advantageous for work and turn printing jobs or other printing jobs which print two or more separate images onto the same substrate.

The frame 60 of the inking/coating apparatus 10 includes side support members 74, 76 which support the applicator roller 66, gear train 64, gear train 65, doctor blade assembly 68 and the drive motor 62. The applicator roller 66 is mounted on stub shafts 63A, 63B which are supported at opposite ends on a lower cradle assembly 100 formed by a pair of side support members 78, 80 which have sockets 79, 81 and retainer caps 101, 103. The stub shafts are received in roller bearings 105, 107 which permit free rotation of the applicator roller 66 about its longitudinal axis A1 (axis A2 in the upper cradle). The retainer caps 101, 103 hold the stub shafts 63A, 63B and bearings 105, 107 in the sockets 79, 81 and hold the applicator roller 66 in parallel alignment with the pivot axis X.

The side support members 74, 76 also have an upper cradle assembly 102 formed by a pair of side support members 82, 84 which are vertically spaced with respect to the lower side plates 78, 80. Each cradle 100, 102 has a pair of sockets 79, 81 and 83, 85, respectively, for holding an applicator roller 66, 67 for spot coating or inking engagement with the printing plate P on the plate cylinder 32 (FIG. 4) or with a printing plate P or a blanket B on the blanket cylinder 34.

Preferably, the applicator roller 67 (FIG. 8, FIG. 9) the upper cradle (plate) position is an anilox roller having a resilient transfer surface. In the dual cradle arrangement as shown in FIG. 2, the press operator can quickly change from blanket inking/coating to plate inking/coating within minutes, since it is only necessary to release, remove and reposition or replace the applicator roller 66.

The capability to simultaneously print in the flexographic mode, the aqueous mode, the waterless mode, or the lithographic mode on different printing units of the same lithographic press and to print or coat from either the plate position or the blanket position on any one of the printing units is referred to herein as the LITHOFLEX™ printing process or system. LITHOFLEX™ is a trademark of Printing Research, Inc. of Dallas, Tex., U.S.A., exclusive licensee of the present invention.

Referring now to FIG. 14, an inking/coating apparatus 10 having an inking/coating assembly 109 of an alternative design is installed in the upper cradle position for applying ink and/or coating material to a plate P on the plate cylinder 32. According to this alternative embodiment, an applicator roller 67R having a resilient transfer surface is coupled to an anilox fluid metering roller which transfers measured amounts of printing ink or coating material to the plate P. The anilox roller 111 has a transfer surface constructed of metal, ceramic or composite material which is engraved with cells. The resilient applicator roller 67R is interposed in transfer engagement with the plate P and the metering surface of the anilox roller 111. The resilient transfer surface

of the applicator roller 67R provides uniform, positive engagement with the plate.

Referring now to FIG. 17, an inking/coating apparatus 10 having an alternative inking/coating assembly 113 is installed in the lower cradle assembly 100 for applying flexographic or aqueous ink and/or coating material Q to a plate or blanket mounted on the blanket cylinder 34. Instead of using the sealed, dual doctor blade reservoir assembly 68 as shown in FIG. 6, an open, single doctor blade anilox roller assembly 113 is supplied with liquid ink Q or coating material contained in an open fountain pan 117. The liquid ink or coating material Q is transferred to the engraved transfer surface of the anilox roller 66 as it turns in the fountain pan 117. Excess ink or coating material Q is removed from the engraved transfer surface by a single doctor blade 68B. The liquid ink or coating material Q is pumped from an off-press source, for example the drum 73 shown in FIG. 17, through a supply conduit 119 into the fountain pan 117 by a pump 120.

For overall inking or coating jobs, the metering transfer surface of the anilox roller 66 extends over its entire peripheral surface. However, for certain printing jobs which print two or more separate images onto the same substrate, for example work and turn printing jobs, the metering transfer surface of the anilox applicator roller 66 is partitioned by a centrally located, annular undercut groove 66C which separates first and second metering transfer surfaces 66A, 66B as shown in FIG. 11 and FIG. 18.

The single doctor blade 68B has an edge 68E which wipes simultaneously against the split metering transfer surfaces 66A, 66B. In this single blade, split anilox roller embodiment 113, it is necessary to provide dual supply sources, for example drums 73A, 73B, dual supply lines 119A, 119B, and dual pumps 120A, 120B. Moreover, the fountain pan 117 is also split, and the pan 117 is divided into two pan sections 117A, 117B by a separator plate 121, as shown in FIG. 18. The separator plate 121 is centrally aligned with the undercut groove 66C, but does not touch the adjoining roller faces.

Although the single blade, split anilox applicator roller assembly 113 is shown mounted in the lower cradle position (FIG. 17), it should be understood that the single blade, split anilox applicator roller assembly 113 can be mounted and used in the upper cradle position, as well.

According to another aspect of the present invention, the inking/coating apparatus 10 is pivotally coupled on horizontal pivot pins 88P, 90P which allows the single head, dual cradle inking/coating apparatus 10 to be mounted on any lithographic printing unit. Referring to FIG. 9, the horizontal pivot pins 88P, 90P are mounted within the traditional dampener space 29 of the printing unit and are secured to the press side frames 14, 15, respectively. Preferably, the pivot support pins 88P, 90P are secured to the press side frames by a threaded fastener. The pivot support pins are received within circular openings 88, 90 which intersect the side support members 74, 76 of the inking/coating apparatus 10. The horizontal support pins 88P, 90P are disposed in parallel alignment with rotational axis X and with the plate cylinder and blanket cylinder, and are in longitudinal alignment with each other.

Preferably, the pivot pins 88P, 90P are located in the dampener space 29 so that the rotational axes A1, A2 of the applicator rollers 66, 67 are elevated with respect to the nip contact points N1, N2. By that arrangement, the transfer point between the applicator roller 66 and a blanket on the blanket cylinder 34 (as shown in FIG. 8) and the transfer

point between the applicator roller 66 and a plate on the plate cylinder 32 (as shown in FIG. 5) are above the radius lines R1, R2 of the plate cylinder and the blanket cylinder, respectively. This permits the inking/coating apparatus 10 to move clockwise to retract the applicator roller 66 to an off-impression position relative to the blanket cylinder in response to a single extension stroke of the power actuator arms 104A, 106A. Similarly, the applicator roller 66 is moved counterclockwise to the on-impression operative position as shown in FIGS. 4, 5, 6 and 8 by a single retraction stroke of the actuator arms 104A, 106A, respectively.

Preferably, the pivot pins are made of steel and the side support members are made of aluminum, with the steel pivot pins and the aluminum collar portion bordering the circular openings 88, 90 forming a low friction journal. By this arrangement, the inking/coating apparatus 10 is freely rotatable clockwise and counterclockwise with respect to the pivot pins 88P, 90P. Typically, the arc length of rotation is approximately 60 mils (about 1.5 mm). Consequently, the inking/coating apparatus 10 is almost totally enclosed within the dampener space 29 of the printing unit in the on-impression position and in the off-impression position.

The cradle assemblies 100 and 102 position the applicator roller 66 in inking/coating alignment with the plate cylinder or blanket cylinder, respectively, when the inking/coating apparatus 10 is extended to the operative (on-impression) position. Moreover, because the inking/coating apparatus 10 is installed within the dampener space 29, it is capable of freely rotating through a small arc while extending and retracting without being obstructed by the press side frames or other parts of the printing press. This makes it possible to install the inking/coating apparatus 10 on any lithographic printing unit. Moreover, because of its internal mounting position within the dampener space 29, the projection of the inking/coating apparatus 10 into the space between printing units is minimal. This assures unrestricted operator access to the printing unit when the applicator head is in the operative (on-impression) and retracted (off-impression) positions.

As shown in FIG. 4 and FIG. 5, movement of the inking/coating apparatus 10 is counterclockwise from the retracted (off-impression) position to the operative (on-impression) position.

Although the dampener side installation is preferred, the inking/coating apparatus 10 can be adapted for operation on the delivery side of the printing unit, with the inking/coating apparatus being movable from a retracted (off-impression) position to an on-impression position for engagement of the applicator roller with either a plate on the plate cylinder or a blanket on the blanket cylinder on the delivery side 25 of the printing unit.

Movement of the inking/coating apparatus 10 to the operative (on-impression) position is produced by power actuators, preferably double acting pneumatic cylinders 104, 106 which have extendable/retractable power transfer arms 104A, 106A, respectively. The first pneumatic cylinder 104 is pivotally coupled to the press frame 14 by a pivot pin 108, and the second pneumatic cylinder 106 is pivotally coupled to the press frame 15 by a pivot pin 110. In response to selective actuation of the pneumatic cylinders 104, 106, the power transfer arms 104A, 106A are extended or retracted. The power transfer arm 104A is pivotally coupled to the side support member 74 by a pivot pin 112. Likewise, the power transfer arm 106A is pivotally coupled to the side support member 76 by a pivot pin 114.

As the power arms extend, the inking/coating apparatus 10 is rotated clockwise on the pivot pins 88P, 90P, thus

moving the applicator roller 66 to the off-impression position. As the power arms retract, the inking/coater apparatus 60 is rotated counterclockwise on the pivot pins 88P, 90P, thus moving the applicator roller 66 to the on-impression position. The torque applied by the pneumatic actuators is transmitted to the inking/coating apparatus 10 through the pivot pin 112 and pivot pin 114.

Fine adjustment of the on-impression position of the applicator roller relative to the plate cylinder or the blanket cylinder, and of the pressure of roller engagement, is provided by an adjustable stop assembly 115. The adjustable stop assembly 115 has a threaded bolt 116 which is engagable with a bell crank 118. The bell crank 118 is pivotally coupled to the side support member 74 on a pin 120. One end of the bell crank 118 is engagable by the threaded bolt 116, and a cam roller 122 is mounted for rotation on its opposite end. The striking point of engagement is adjusted by rotation of the bolt 116 so that the applicator roller 66 is properly positioned for inking/coating engagement with the plate P or blanket B and provides the desired amount of inking/coating pressure when the inking/coating assembly 60 is moved to the operative position.

This arrangement permits the in-line inking/coating apparatus to operate effectively without encroaching in the interunit space between any adjacent printing units, and without blocking or obstructing access to the cylinders of the printing units when the inking/coating apparatus is in the extended (off-impression) position or retracted (on-impression) position. Moreover, when the in-line inking/coating apparatus is in the retracted position, the doctor blade reservoir and coating circulation lines can be drained and flushed automatically while the printing press is running as well as when the press has been stopped for change-over from one job to another or from one type of ink or coating to another.

Substrates which are printed or coated with aqueous flexographic printing inks require high velocity hot air for drying. When printing a flexographic ink such as opaque white or metallic gold, it is always necessary to dry the printed substrates between printing units before overprinting them. According to the present invention, the water component on the surface of the freshly printed or coated substrate S is evaporated and dried by high velocity, hot air interunit dryer and high volume heat and moisture extractor units 124, 126 and 128, as shown in FIG. 2, FIG. 4 and FIG. 5. The dryer/extractor units 124, 126 and 128 are oriented to direct high velocity heated air onto the freshly printed/coated substrates as they are transferred by the impression cylinder 36 and the intermediate transfer drum 40 of one printing unit and to another transfer cylinder 30 and to the impression cylinder 36 of the next printing unit. By that arrangement, the freshly printed flexographic ink or coating material is dried before the substrate S is overprinted by the next printing unit.

The high velocity, hot air dryer and high performance heat and moisture extractor units 124, 126 and 128 utilize high velocity air jets which scrub and break-up the moist air layer which clings to the surface of each freshly printed or coated sheet or web. Within each dryer, high velocity air is heated as it flows across a resistance heating element within an air delivery baffle tube. High velocity jets of hot air are discharged through multiple airflow apertures into an exposure zone Z (FIG. 4 and FIG. 5) and onto the freshly printed/coated sheet S as it is transferred by the impression cylinder 36 and transfer drum 40, respectively.

Each dryer assembly includes a pair of air delivery dryer heads 124D, 126D and 128D which are arranged in spaced,

side-by-side relationship. The high velocity, hot air dryer and high performance heat and moisture extractor units 124, 126 and 128 are preferably constructed as disclosed in co-pending U.S. patent application Ser. No. 08/132,584, filed Oct. 6, 1993, entitled "High Velocity Hot Air Dryer", to Howard W. DeMoore, co-inventor and assignee of the present invention, and which is incorporated herein by reference, and which is marketed by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE HV™.

The hot moisture-laden air displaced from the surface of each printed or coated sheet is extracted from the dryer exposure zone Z and exhausted from the printing unit by the high volume extractors 124, 126 and 128. Each extractor head includes an extractor manifold 124E, 126E and 128E coupled to the dryer heads 124D, 126D and 128D and draws the moisture, volatiles, odors and hot air through a longitudinal air gap G between the dryer heads. Best results are obtained when extraction is performed simultaneously with drying. Preferably, an extractor is closely coupled to the exposure zone Z at each dryer-location as shown in FIG. 4. Extractor heads 124E, 126E and 128E are mounted on the dryer heads 124D, 126D and 128D, respectively, with the longitudinal extractor air gap G facing directly into the exposure zone Z. According to this arrangement, each printed or coated sheet is dried before it is printed on the next printing unit.

The aqueous water-based inks used in flexographic printing evaporate at a relatively moderate temperature provided by the interunit high velocity hot air dryers/extractors 124, 126 and 128. Sharpness and print quality are substantially improved since the flexographic ink or coating material is dried before it is overprinted on the next printing unit. Since the freshly printed flexographic ink is dry, dot gain is substantially reduced and back-trapping on the blanket of the next printing unit is virtually eliminated. This interunit drying/extracting arrangement makes it possible to print flexographic inks such as metallic ink and opaque white ink on the first printing unit, and then dry-trap and overprint on the second and subsequent printing units.

Moreover, this arrangement permits the first printing unit 22 to be used as a coater in which a flexographic, aqueous or UV-curable coating material is applied to the lowest grade substrate such as recycled paper, cardboard, plastic and the like, to trap and seal-in lint, dust, spray powder and other debris and provide a smoother, more durable printing surface which can be overprinted on the next printing unit.

A first down (primer) aqueous coating layer seals-in the surface of a low grade, rough substrate, for example, recycled paper or plastic, and improves overprinted dot definition and provides better ink lay-down while preventing strike-through and show-through. A flexographic UV-curable coating material can then be applied downstream over the primer coating, thus producing higher coating gloss.

Preferably, the applicator roller 66 is constructed of composite carbon fiber material, metal or ceramic coated metal when it is used for applying ink or coating material to the blanket B or other resilient material on the blanket cylinder 34. When the applicator roller 66 is applied to the plate, it is preferably constructed as an anilox roller having a resilient, compressible transfer surface. Suitable resilient roller surface materials include Buna N synthetic rubber and EPDM (terpolymer elastomer).

It has been demonstrated in prototype testing that the inking/coating apparatus 10 can apply a wide range of ink and coating types, including fluorescent (Day Glo), pearl-

escent, metallics (gold, silver and other metals), glitter, scratch and sniff (micro-encapsulated fragrance), scratch and reveal, luminous, pressure-sensitive adhesives and the like, as well as UV-curable and aqueous coatings.

With the dampener assembly removed from the printing unit, the inking/coating apparatus 10 can easily be installed in the dampener space for selectively applying flexographic inks and/or coatings to a flexographic or waterless printing plate or to the blanket. Moreover, overprinting of the flexographic inks and coatings can be performed on the next printing unit since the flexographic inks and/or coatings are dried by the high velocity, hot air interunit dryer and high volume heat and moisture extractor assembly of the present invention.

The flexographic inks and coatings as used in the present invention contain colored pigments and/or soluble dyes, binders which fix the pigments onto the surface of the substrate, waxes, defoamers, thickeners and solvents. Aqueous printing inks predominantly contain water as a diluent and/or vehicle. The thickeners which are preferred include algonates, starch, cellulose and its derivatives; for example cellulose esters or cellulose ethers and the like. Coloring agents including organic as well as inorganic pigments may be derived from dyes which are insoluble in water and solvents. Suitable binders include acrylates and/or polyvinylchloride.

When metallic inks are printed, the cells of the anilox roller must be appropriately sized to prevent the metal particles from getting stuck within the cells. For example, for metallic gold ink, the anilox roller should have a screen line count in the range of 175-300 lines per inch (68-118 lines per cm). Preferably, in order to keep the anilox roller cells clear, the doctor blade assembly 68 is equipped with a bristle brush BR (FIG. 14) as set forth in U.S. Pat. No. 5,425,809 to Steven M. Person, assigned to Howard W. DeMoore, and licensed to Printing Research, Inc. of Dallas, Tex., U.S.A., which is incorporated herein by reference.

The inking/coating apparatus 10 can also apply UV-curable inks and coatings. If UV-curable inks and coatings are utilized, ultra-violet dryers/extractors are installed adjacent to the high velocity hot air dryer/extractor units 124, 126 and 128, respectively.

It will be appreciated that the LITHOFLEX™ printing process described herein makes it possible to selectively operate a printing unit of a press in the lithographic printing mode while simultaneously operating another printing unit of the same press in either the flexographic printing mode or in the waterless printing mode, while also providing the capability to print or coat, separately or simultaneously, from either the plate position or the blanket position. The dual cradle support arrangement of the present invention makes it possible to quickly change over from inking/coating on the blanket cylinder position to inking/coating on the plate cylinder position with minimum press down-time, since it is only necessary to remove and reposition or replace the applicator roller 66 while the inking/coating apparatus 10 is in the retracted position. It is only necessary to remove four cap screws, lift the applicator roller 66 from the cradle, and reposition it in the other cradle. All of this can be accomplished in a few minutes, without removing the inking/coating apparatus 10 from the press.

It is possible to spot coat or overall coat from the plate position or from the blanket position with flexographic inks or coatings on one printing unit and then spot coat or overall coat with UV-curable inks or coatings from the plate position or from the blanket position on another printing unit

during the same press run. Moreover, the press operator can spot or overall coat from the plate for one job, and then spot and/or overall coat from the blanket on the next job.

The positioning of the applicator roller relative to the plate or blanket is repeatable to a predetermined preset operative position. Consequently, only minor printing unit modifications or alterations may be required for the LITHOFLEX™ process. Although automatic extension and retraction have been described in connection with the exemplary embodiment, extension to the operative (on-impression) position and retraction to a non-operative (off-impression) position can be carried out manually, if desired. In the manual embodiment, it is necessary to latch the inking/coating apparatus 10 to the press side frames 14, 15 in the operative (on-impression) position, and to mechanically prop the inking/coating apparatus in the off-impression (retracted) position.

Referring again to FIG. 8, an applicator roller 66 is mounted on the lower cradle assembly 100 by side support members 78, 80, and a second applicator roller 66 is mounted on the upper cradle assembly 102 by side support members 82, 84. According to this arrangement, the inking/coating apparatus 10 can apply printing ink and/or coating material to a plate on the plate cylinder, while simultaneously applying printing ink and/or coating material to a plate or a blanket on the blanket cylinder of the same printing unit. When the same color ink is used by the upper and lower applicator rollers from the plate position and from the blanket position simultaneously on the same printing unit, a "double bump" or double inking films or coating layers are applied to the substrate S during a single pass of the substrate through the printing unit. The tack of the two inks or coating materials must be compatible for good transfer during the double bump. Moreover, the inking/coating apparatus 10 can be used for supplying ink or coating material to the blanket cylinder of a rotary offset web press, or to the blanket of a dedicated coating unit.

According to conventional bronzing techniques, a metallic (bronze) powder is applied off-line to previously printed substrate which produces a grainy, textured finish or appearance. The on-line application of bronze material by conventional flexographic or lithographic printing will only produce a smooth, continuous appearance. However, a grainy, textured finish is preferred for highest quality printing which, prior to the present invention, could only be produced by off-line methods.

Referring now to FIG. 14 and FIG. 15, metallic ink or coating material is applied on-line to the substrate S by simultaneous operation of the upper and lower applicator rollers 67R, 66 to produce an uneven surface finish having a bronze-like textured or grainy appearance. According to the simulated bronzing method of the present invention, the flexographic bronze ink is applied simultaneously to the plate and to the blanket by the dual cradle inking/coating apparatus 10 as shown in FIG. 14. A resilient applicator roller 67R is mounted in the upper cradle 102, and an anilox applicator roller 66 is mounted on the lower cradle 100. The rollers are supplied from separate doctor blade reservoirs 70. The doctor blade reservoir 70 in the upper cradle position supplies bronze ink or coating material having relatively coarse, metallic particles 140 dispersed in aqueous or flexographic ink. The coarse particle ink or coating material is applied to the plate P by the resilient applicator roller 67R in the upper cradle position 102. At the same time, flexographic and/or bronze ink or coating material having relatively fine, metallic particles 142 is transferred to the blanket B by the anilox roller 66 which is mounted on the lower cradle 100.

The metering surfaces of the upper and lower applicator rollers have different cell sizes and volumetric capacities which accommodate the coarse and fine metallic particles. For example, the anilox roller 111 mounted in the upper cradle position 102 which transfers the coarse metallic particles 140 preferably has a screen line count in the range of 100-300 lines per inch (39-118 lines per cm), and the metering surface of the anilox roller 66 mounted on the lower cradle 100 which transfers the relatively fine metallic particles 142 preferably has a screen line count in the range of 200-600 lines per inch (79-236 lines per cm).

After transfer from the plate to the blanket, the fine metallic particles 142 form a layer over the coarse metallic particles 140. As both bronze layers are offset onto the substrate S, the layer of fine metallic particles 142 is printed onto the substrate S with the top layer of coarse metallic particles 140 providing a textured, grainy appearance. The fine metallic particles 142 cover the substrate which would otherwise be visible in the gaps between the coarse metallic particles 140. The combination of the coarse particle layer over the fine particle layer thus provides a textured, bronzed-like finish and appearance.

Particulate materials other than metal can be used for producing a textured finish. For example, coarse and fine particles of metallized plastic (glitter), mica particles (pearlescent) and the like, can be substituted for the metallic particles for producing unlimited surface variations, appearances and effects. All of the particulate material, including the metallic particles, are preferably in solid, flat platelet form, and have a size dimension suitable for application by an anilox applicator roller. Other particulate or granular material, for example stone grit having irregular form and size, can be used to good advantage.

Solid metal particles in platelet form, which are good reflectors of light, are preferred for producing the bronzed-like appearance and effect. However, various textured finishes, which could have light-reflective properties, can be produced by using granular materials such as stone grit. Most commonly used metals include copper, zinc and aluminum. Other ductile metals can be used, if desired. Moreover, the coarse and fine particles need not be made of the same particulate material. Various effects and textured appearances can be produced by utilizing diverse particulate materials for the coarse particles and the fine particles, respectively. Further, either fine or coarse particle ink or coating material can be printed from the upper cradle position, and either fine or coarse particle ink or coating material can be printed from the lower cradle position, depending on the special or surface finish that is desired.

It will be appreciated that the last printing unit 28 can be configured for additional inking/coating capabilities which include lithographic, waterless, aqueous and flexographic processes. Various substrate surface effects (for example double bump or triple bump inking/coating or bronzing) can be performed on the last printing unit. For triple bump inking/coating, the last printing unit 28 is equipped with an auxiliary in-line inking or coating apparatus 97 as shown in FIG. 3 and FIG. 4. The in-line inking or coating apparatus 97 allows the application of yet another film of ink or a protective or decorative layer of coating material over any freshly printed or coated surface effects or special treatments, thereby producing a triple bump. The triple bump is achieved by applying a third film of ink or layer of coating material over the freshly printed or coated double bump simultaneously while the substrate is on the impression cylinder of the last printing unit.

When the in-line inking/coating apparatus 97 is installed, it is necessary to remove the SUPER BLUE® flexible

covering from the delivery cylinder 42, and it is also necessary to modify or convert the delivery cylinder 42 for inking/coating service by mounting a plate or blanket B on the delivery cylinder 42, as shown in FIG. 3 and FIG. 4. Packing material is placed under the plate or blanket B, thereby packing the plate or blanket B at the correct packed-to-print radial clearance so that ink or coating material will be printed or coated onto the freshly printed substrate S as it transfers through the nip between the plate or blanket B on the converted delivery cylinder 42 and the last impression cylinder 36. According to this arrangement, a freshly printed or coated substrate is overprinted or overcoated with a third film or layer of ink or coating material simultaneously while a second film or layer of ink or coating material is being over-printed or over-coated on the last impression cylinder 36.

The auxiliary inking/coating apparatus 97 and the converted or modified delivery cylinder 42 are mounted on the delivery drive shaft 43. The inking/coating apparatus 97 includes an applicator roller, preferably an anilox applicator roller 97A, for supplying ink or coating material to a plate or blanket B on the modified or converted delivery cylinder 42. The in-line inking/coating apparatus 97 and the modified or converted delivery cylinder 42 are preferably constructed as described in U.S. Pat. No. 5,176,077 to Howard W. DeMoore (co-inventor and assignee), which is hereby incorporated by reference. The in-line inking/coating apparatus 97 is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE EZ COATER™.

After the delivery cylinder 42 has been modified or converted for inking/coating service, and because of the reduced nip clearance imposed by the plate or blanket B, the modified delivery cylinder 42 can no longer perform its original function of guiding and transferring the freshly printed or coated substrate. Instead, the modified or converted delivery cylinder 42 functions as a part of the inking/coating apparatus 97 by printing or coating a third down film of ink or layer of coating material onto the freshly printed or coated substrate as it is simultaneously printed or coated on the last impression cylinder 36. Moreover, the mutual tack between the second down ink film or coating layer and the third down ink film or coating layer causes the overprinted or overcoated substrate to cling to the plate or blanket, thus opposing or resisting separation of the substrate from the plate or blanket.

To remedy this problem, a vacuum-assisted transfer apparatus 99 is mounted adjacent the modified or converted delivery cylinder 42 as shown in FIG. 3 and FIG. 4. Another purpose of the vacuum-assisted transfer apparatus 99 is to separate the freshly overprinted or overcoated triple bump substrate from the plate or blanket B as the substrate transfers through the nip. The vacuum-assisted transfer apparatus 99 produces a pressure differential across the freshly overprinted or overcoated substrate as it transfers through the nip, thus producing a separation force onto the substrate and providing a clean separation from the plate or blanket B.

The vacuum-assisted transfer apparatus 99 is preferably constructed as described in U.S. Pat. Nos. 5,113,255; 5,127,329; 5,205,217; 5,228,391; 5,243,909; and 5,419,254, all to Howard W. DeMoore, co-inventor, which are incorporated herein by reference. The vacuum-assisted transfer apparatus 99 is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A. under its trademark BACVAC™.

Although the present invention and its advantages have been described in detail, it should be understood that various

changes, substitutions and alterations can be made herein without departing from the spirit and scope of the present invention as defined by the appended claims.

What is claimed is:

1. A rotary offset printing press of the type including first and second printing units, the first printing unit comprising:

a plate cylinder having a flexographic printing plate mounted thereon;

a blanket cylinder having a blanket disposed in ink or coating transfer engagement with the flexographic printing plate for receiving aqueous or flexographic printing ink or coating material from the flexographic printing plate;

an impression cylinder disposed adjacent the blanket cylinder thereby forming a nip between the blanket and the impression cylinder whereby the aqueous or flexographic printing ink or coating material can be transferred from the blanket to a substrate as the substrate is transferred through the nip;

inking/coating apparatus movably coupled to the first printing unit for movement to an on-impression operative position and to an off-impression retracted position;

the inking/coating apparatus including container means for containing a volume of aqueous or flexographic ink or coating material, and at least one applicator roller coupled to the container means for applying aqueous or flexographic ink or coating material to the flexographic printing plate or to the blanket when the inking/coating apparatus is in the on-impression operative position;

the container means having a partition dividing the container means thereby defining a first container region and a second container region;

the at least one applicator roller having first and second transfer surfaces and means separating the first and second transfer surfaces; and,

the first and second transfer surfaces of the at least one applicator roller being disposed within the first and second container regions for rolling contact with aqueous or flexographic printing ink or coating material contained within the first and second container regions, respectively.

2. A rotary offset printing press as defined in claim 1, wherein:

said separating means is an annular seal element disposed on the applicator roller; and,

the partition is disposed in sealing engagement against the annular seal element of the applicator roller.

3. A rotary offset printing press as defined in claim 1, wherein:

said container means is an open fountain pan;

said separating means is an annular groove intersecting the applicator roller thereby separating the first and second transfer surfaces; and,

the partition is a separator plate mounted on the fountain pan between the first and second container regions and disposed in the annular groove.

4. A rotary offset printing press as defined in claim 1, including sheet feeding means coupled to the first printing unit for consecutively feeding substrates in sheet form into the first printing unit.

5. A rotary offset printing press as defined in claim 1, including web feeding means coupled to the first printing unit for continuously feeding a substrate in continuous web form into the first printing unit.

6. A rotary offset printing press as defined in claim 1, wherein:

said container means is a fountain pan having first and second pan sections for containing first and second aqueous or flexographic inks or coating materials, respectively; and,

said at least one applicator roller is a pan roller mounted for rotation in the first and second pan sections, respectively, for separately transferring aqueous or flexographic ink or coating material from the first and second pan sections to the first and second transfer surfaces of the applicator roller.

7. A rotary offset printing press as set forth in claim 1, wherein:

said container means is a sealed doctor blade head, said partition being mounted on the doctor blade head and separating the first and second container regions;

the at least one applicator roller comprising an anilox transfer roller;

the separating means being a seal band formed on the applicator roller between the first and second transfer surfaces; and,

the partition being disposed in sealing engagement with the seal band in the coupled position.

8. A rotary offset printing press as defined in claim 1, wherein the inking/coating apparatus comprises:

first cradle means for supporting the at least one applicator roller for engagement with a plate or blanket when the inking/coating apparatus is in the operative position;

second cradle means for supporting a second applicator roller for engagement with a plate or blanket when the inking/coating apparatus is in the operative position;

the at least one applicator roller being mounted for rotation on the first cradle means, the at least one applicator roller having a first seal band separating first and second transfer surfaces;

the second applicator roller being mounted for rotation on the second cradle means, the second applicator roller having a second seal band separating the third and fourth transfer surfaces;

the container means including:

first reservoir means for containing a volume of ink or coating material, the first reservoir means having first and second reservoir chambers and a first partition separating the first and second reservoir chambers;

second reservoir means for containing a volume of ink or coating material, the second reservoir means having third and fourth reservoir chambers and a second partition element separating the third and fourth reservoir chambers;

the first and second reservoir means being coupled to the at least one and second applicator rollers, respectively, the first and second transfer surfaces of the at least one applicator roller being disposed for rolling contact with ink or coating material in the first and second reservoir chambers, respectively, of the first reservoir means and the first partition being disposed in sealing engagement with the separating means of the first applicator roller; and,

the third and fourth transfer surfaces of the second applicator roller being disposed for rolling contact with ink or coating material in the third and fourth reservoir chambers, respectively, of the second res-

ervoir means and the second partition being disposed in sealing engagement with the separating means of the second applicator roller.

9. A rotary offset printing press as defined in claim 1, wherein:

the at least one applicator roller is an anilox roller; and, the volumetric capacity of the first transfer surface being different from the volumetric capacity of the second transfer surface.

10. A rotary offset printing press as defined in claim 1, wherein the inking/coating apparatus comprises:

cradle means;

the at least one applicator roller being mounted for rotation on the cradle means; and,

the volumetric capacity of the first transfer surface being different from the volumetric capacity of the second transfer surface.

11. A rotary offset printing press as defined in claim 1, further including:

a transfer drum coupled in substrate transfer relation with the impression cylinder of the first printing unit and in substrate transfer relation with the second printing unit;

a first dryer mounted adjacent the impression cylinder of the first printing unit for discharging heated air onto a freshly printed or coated substrate while the substrate is in contact with the impression cylinder of the first printing unit;

a second dryer mounted adjacent the transfer drum for discharging heated air onto a freshly printed or coated substrate after it has been transferred from the impression cylinder of the first printing unit and while it is in contact with the transfer cylinder; and,

a third dryer disposed adjacent the second printing unit for discharging heated air onto a freshly printed or coated substrate after it has been transferred from the transfer drum and before it is printed or otherwise processed on the second printing unit.

12. A rotary offset printing press as defined in claim 1, wherein the inking/coating apparatus comprises:

first cradle means;

a first reservoir or fountain means mounted on the first cradle means for containing ink or coating material;

a first applicator roller mounted for rotation on the first cradle means and disposed for rolling contact with ink or coating material in the first reservoir or fountain means, the first applicator roller being engagable with a printing plate on the plate cylinder;

second cradle means;

a second reservoir or fountain means mounted on the second cradle means for receiving ink or coating material; and,

a second applicator roller mounted for rotation on the second cradle means and disposed for rolling contact with ink or coating material in the second reservoir or fountain means, the second applicator roller being engagable with a printing plate or blanket mounted on the blanket cylinder in the operative position.

13. A rotary offset printing press as defined in claim 1, wherein the inking/coating apparatus has an axis of rotation and is pivotally mounted on the first printing unit in a position in which the nip contact point between said at least one applicator roller and a blanket or plate is offset with respect to a radius line projecting through the center of the plate cylinder or blanket cylinder to the axis of rotation of the inking/coating apparatus.

THE END OF THE WORLD

United States Patent [19]
DeMoore et al.

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[45] Date of Patent: Jul. 29, 1997

[54] **RETRACTABLE PRINTING/COATING UNIT
OPERABLE ON THE PLATE AND BLANKET
CYLINDERS SIMULTANEOUSLY FROM THE
DAMPENER SIDE OF THE FIRST PRINTING
UNIT OR ANY CONSECUTIVE PRINTING
UNIT OF ANY ROTARY OFFSET PRINTING
PRESS**

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[58] **Field of Search** 101/424.1, 450.1,
101/135, 141, 142, 211, 216, 232, 348-349;
118/46

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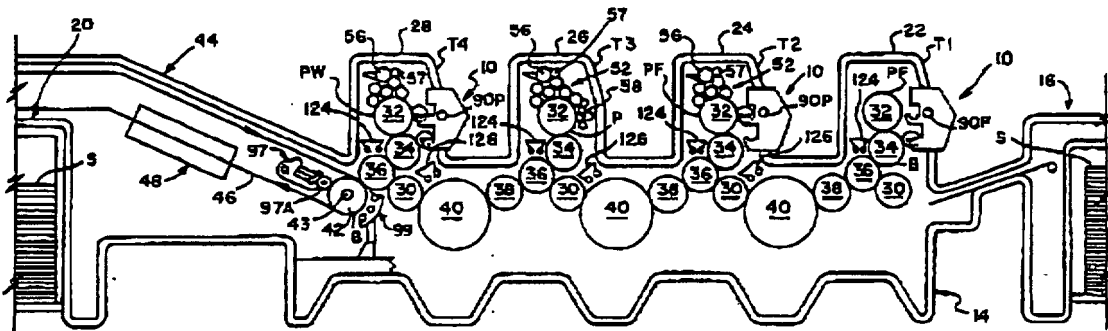
4,685,414	8/1987	DiRico	118/46
4,706,601	11/1987	Jahn	118/46
4,779,557	10/1988	Frazzitta	118/46
4,796,528	1/1989	Samzen	101/211
4,796,556	1/1989	Bird	118/46
4,815,413	3/1989	Kota	118/46
4,825,804	5/1989	Kirino et al.	118/46
4,841,903	6/1989	Bird	118/46
4,852,515	8/1989	Terasaka et al.	118/663
4,934,305	6/1990	Koehler et al.	118/46
5,107,790	4/1992	Sliter et al.	118/674
5,176,077	1/1993	DeMoore et al.	101/232
5,178,678	1/1993	Koehler et al.	118/46
5,189,960	3/1993	Valentini	101/349
5,209,179	5/1993	Herbert et al.	118/46
5,476,041	12/1995	Czotcher	101/232

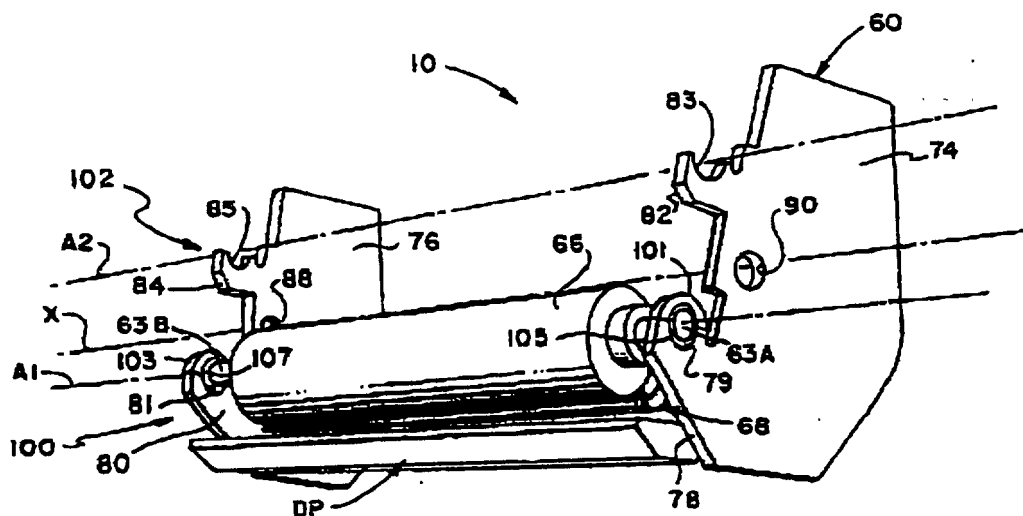
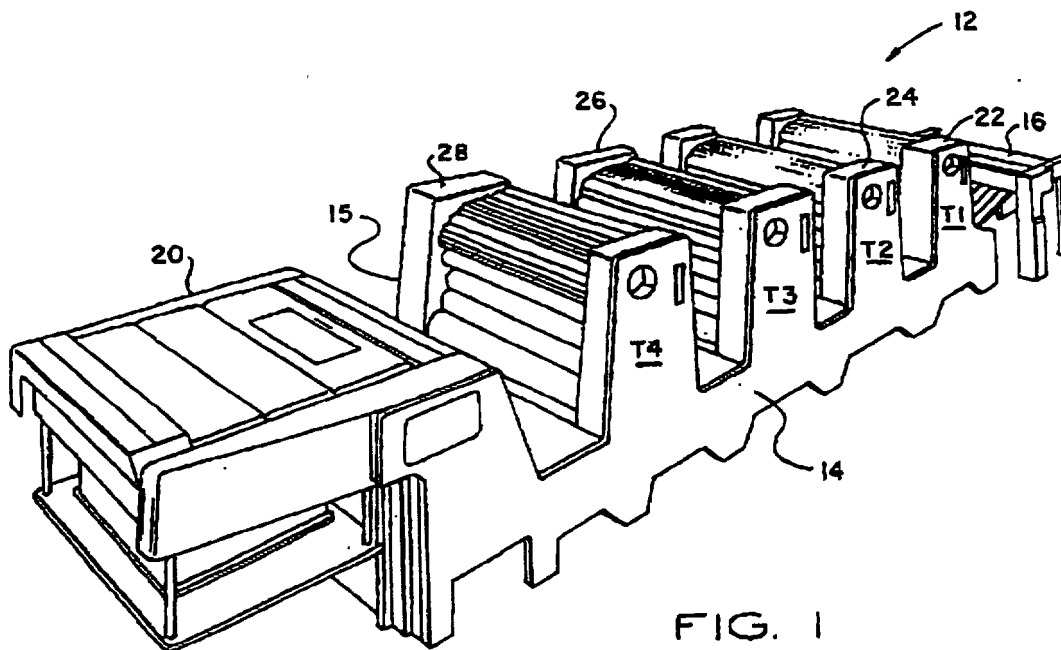
Primary Examiner—Eugene H. Eickholt
Attorney, Agent, or Firm—Sidley & Austin

[57] **ABSTRACT**

A retractable in-line inking/coating apparatus can apply either spot or overall inking/coating material to a plate and/or a blanket on the first printing unit or on any consecutive printing unit of any rotary offset printing press. The inking/coating apparatus is pivotally mounted within the conventional dampener space of any lithographic printing unit. The aqueous component of the flexographic printing ink or aqueous coating material is evaporated and dried by high velocity, hot air dryers and high performance heat and moisture extractors so that the aqueous or flexographic ink or coating material on a freshly printed or coated sheet is dry and can be dry-trapped on the next printing unit. The inking/coating apparatus includes dual cradles that support first and second applicator rollers so that the inking/coating apparatus can apply a double bump of aqueous/flexographic or UV-curable printing ink or coating material to a plate on the plate cylinder, while simultaneously applying aqueous, flexographic or UV-curable printing ink or coating material to a plate or a blanket on the blanket cylinder, and thereafter onto a sheet as the sheet is transferred through the nip between the blanket cylinder and the impression cylinder. A triple bump is printed or coated on the last printing unit with the aid of an impression cylinder inking/coating unit.

16 Claims, 10 Drawing Sheets





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TOP VIEW OF FIG. 3

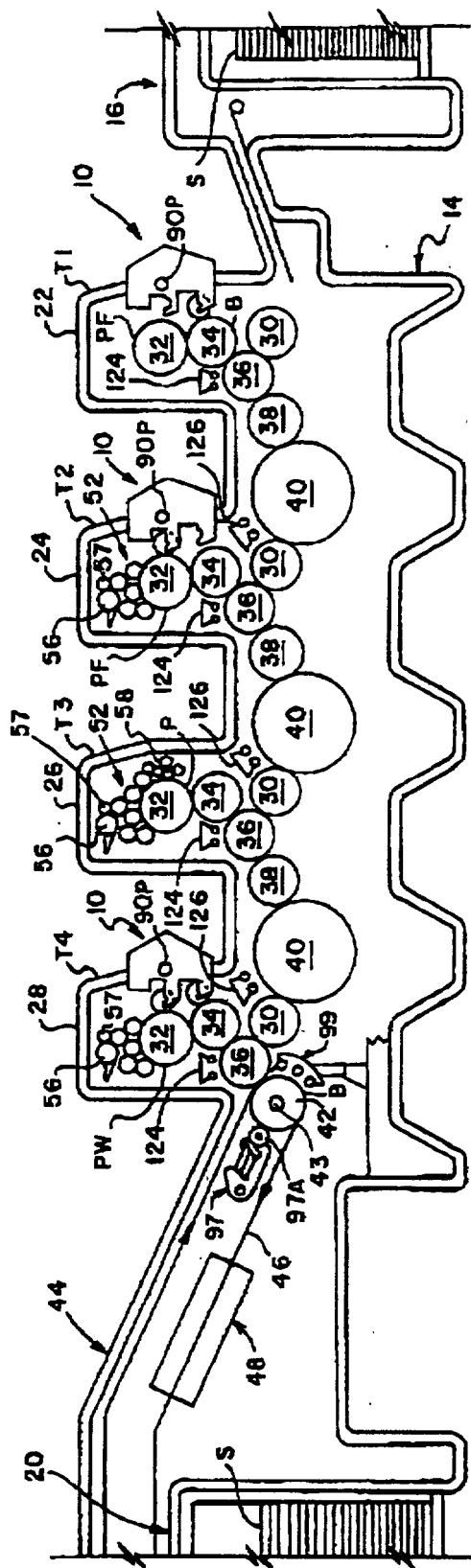


FIG. 3

FIG. 4

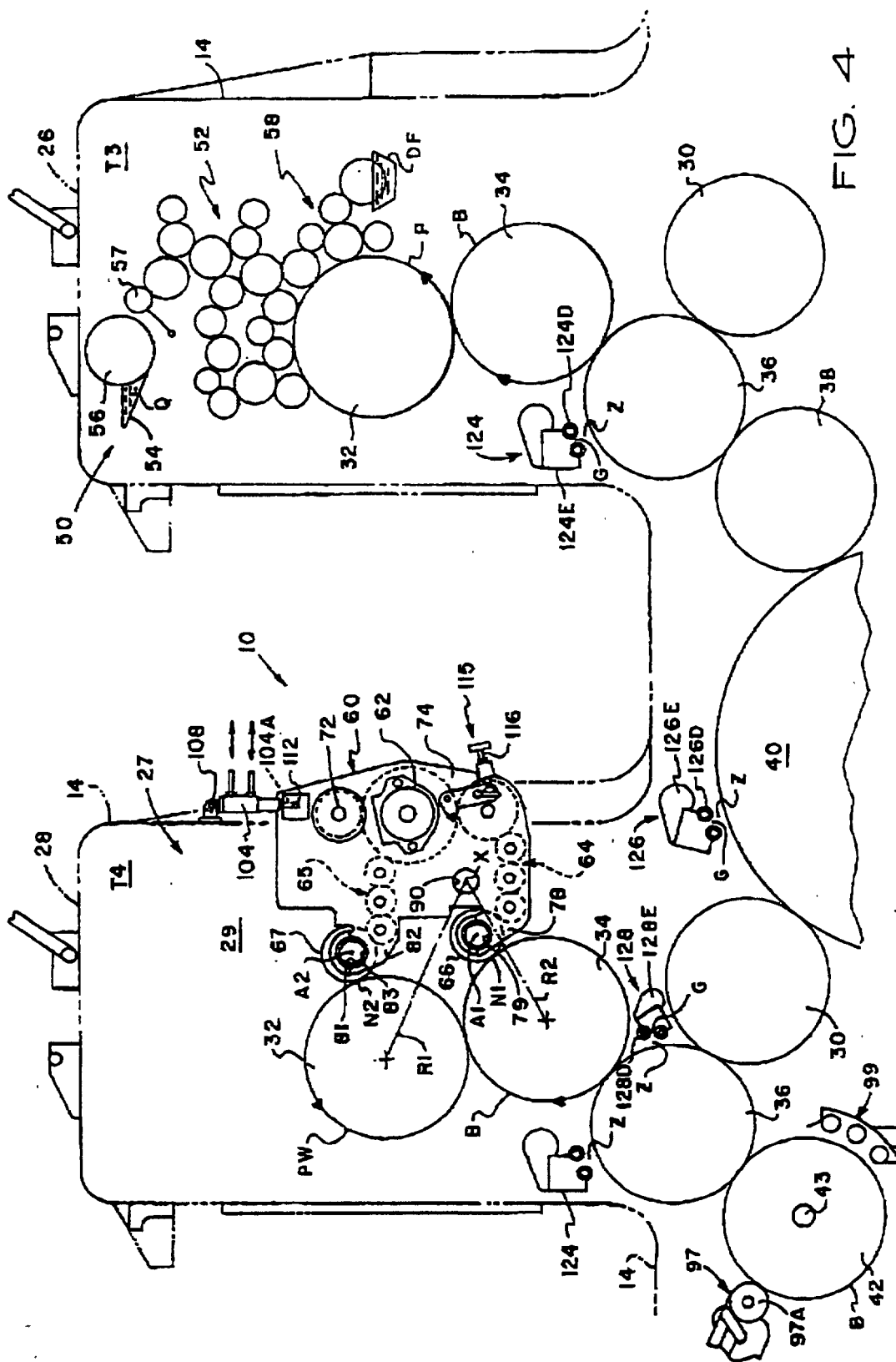


FIG. 5

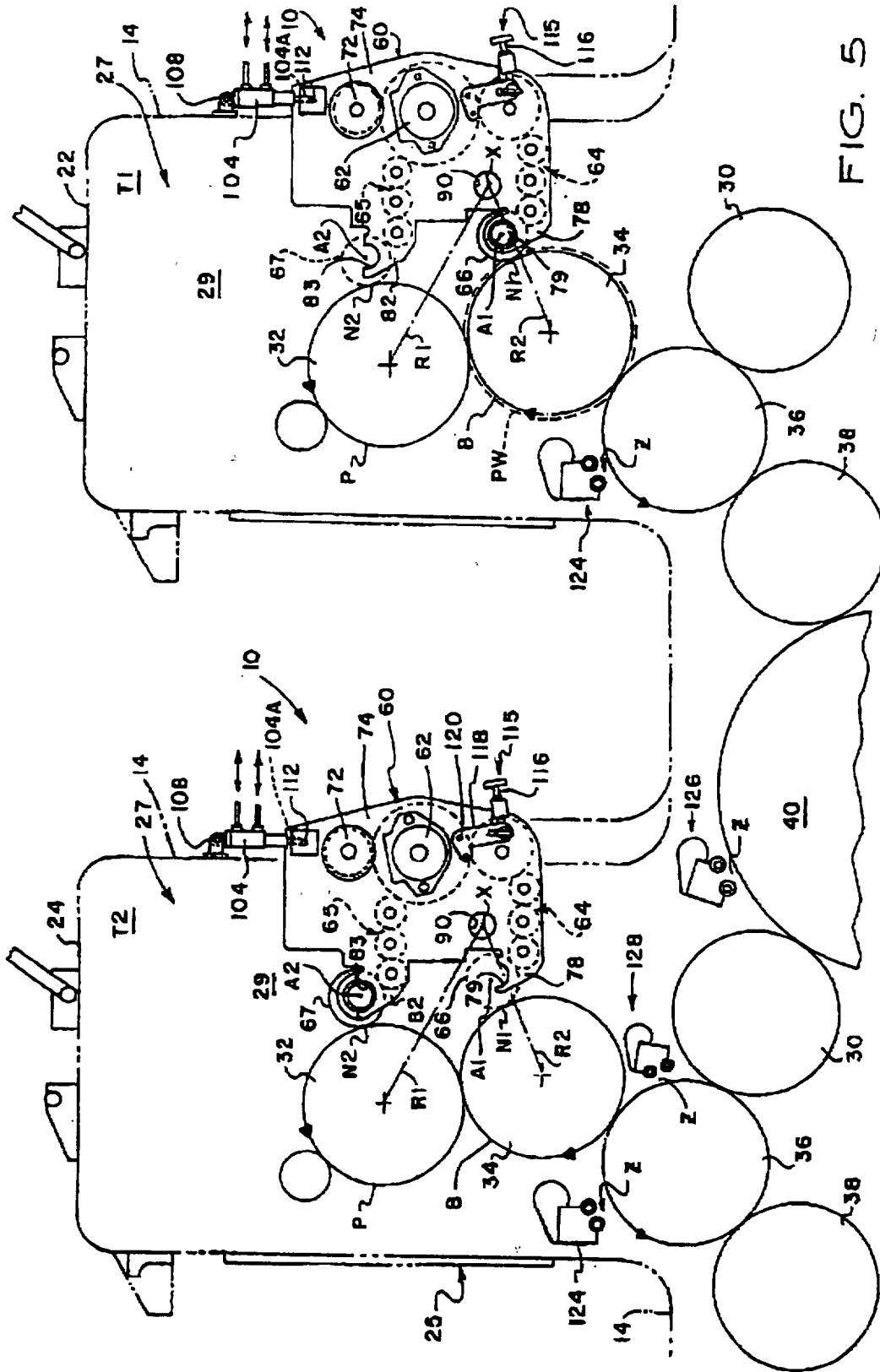


FIG. 5

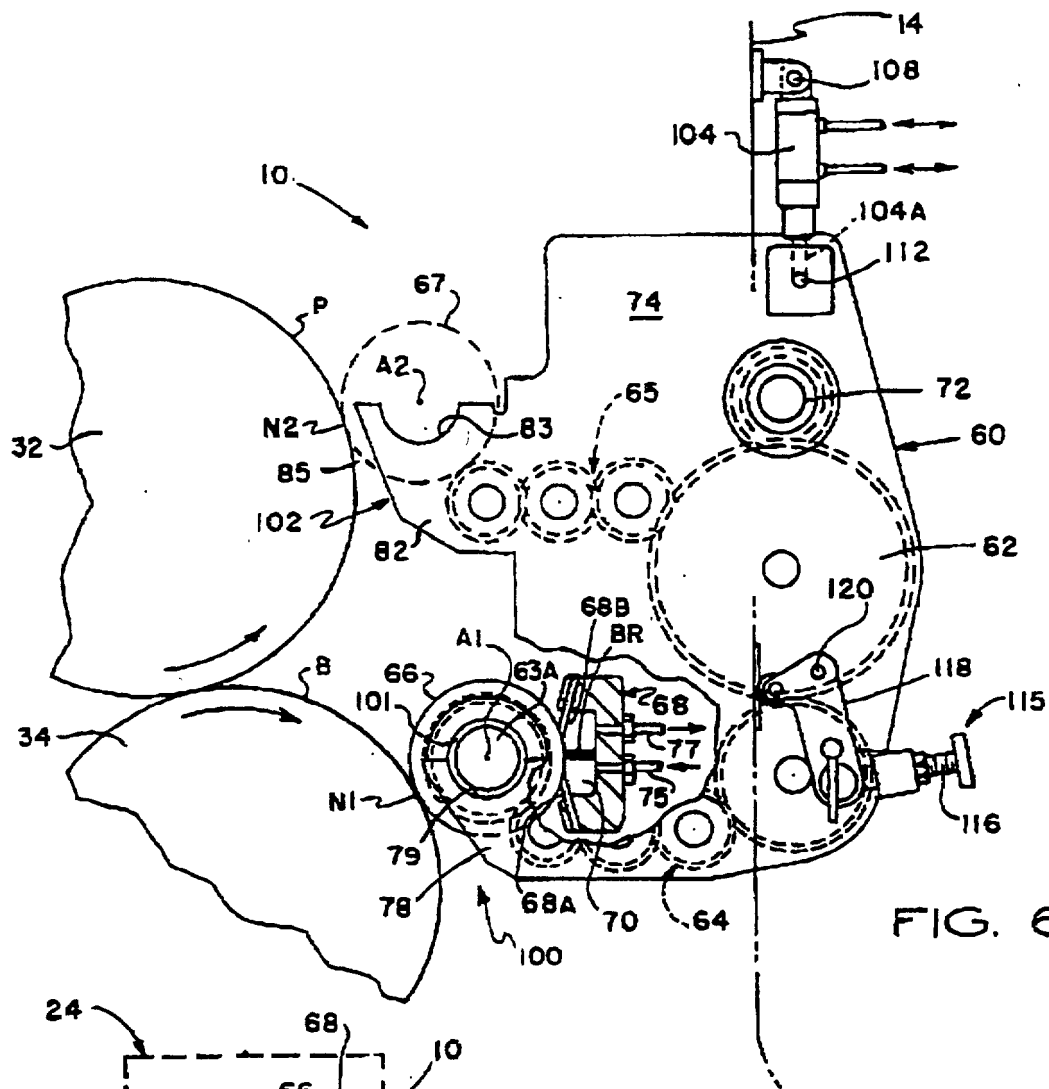


FIG. 6

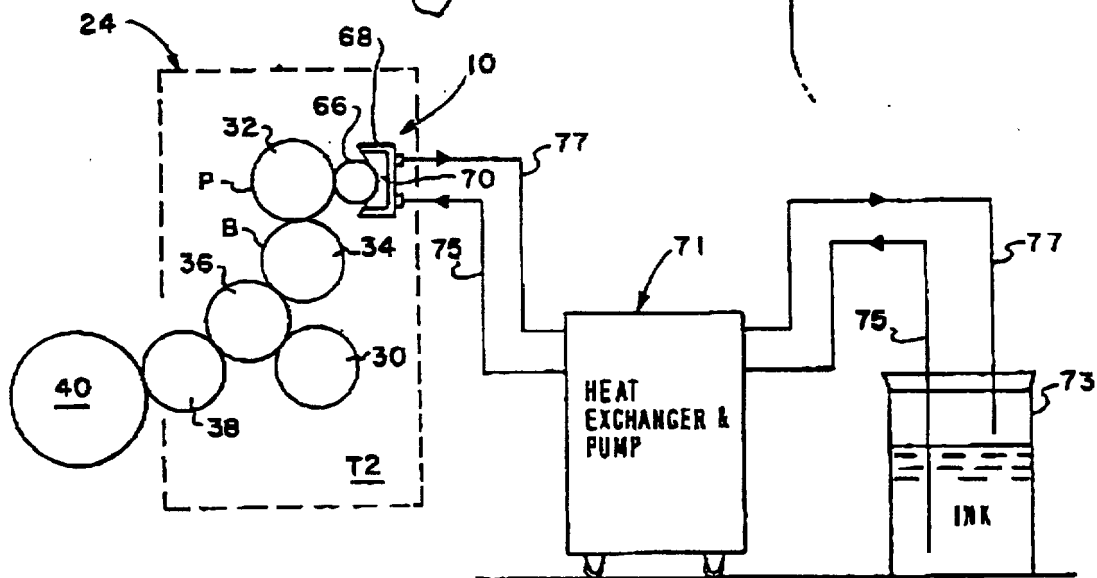


FIG. 7

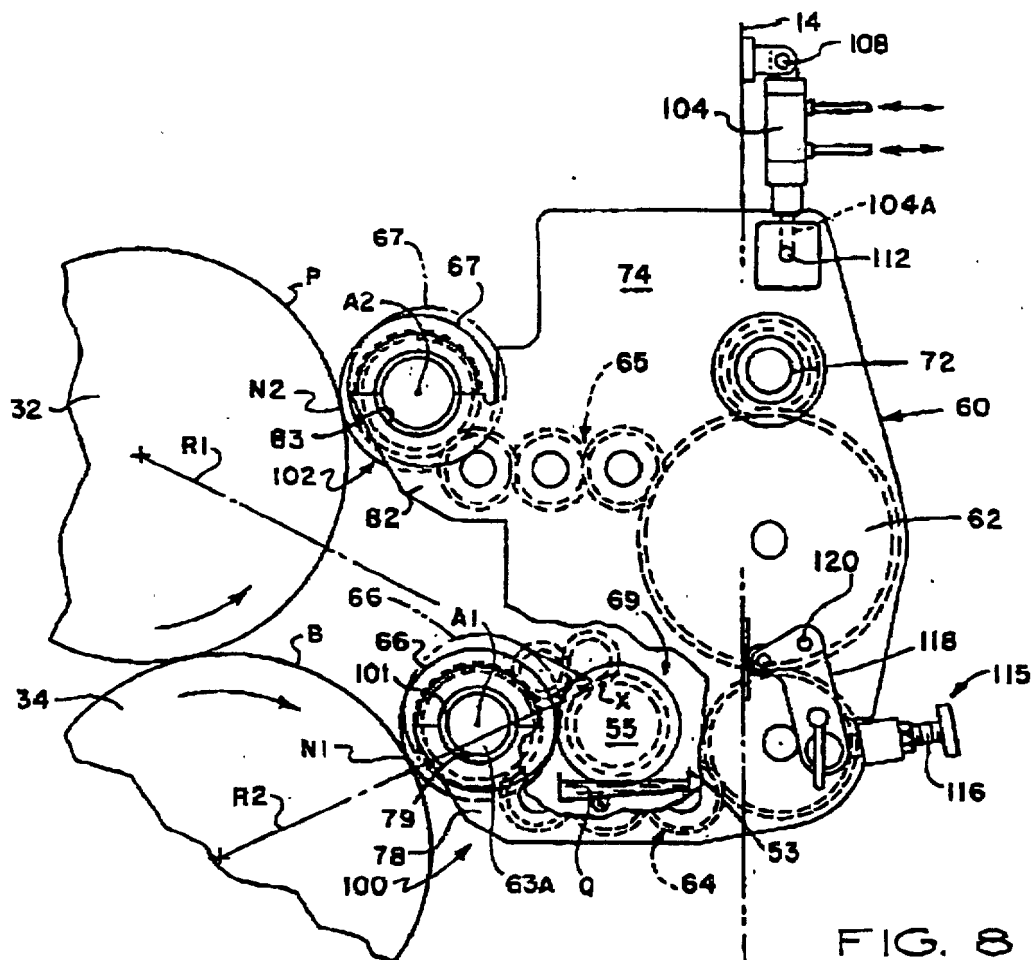


FIG. 8

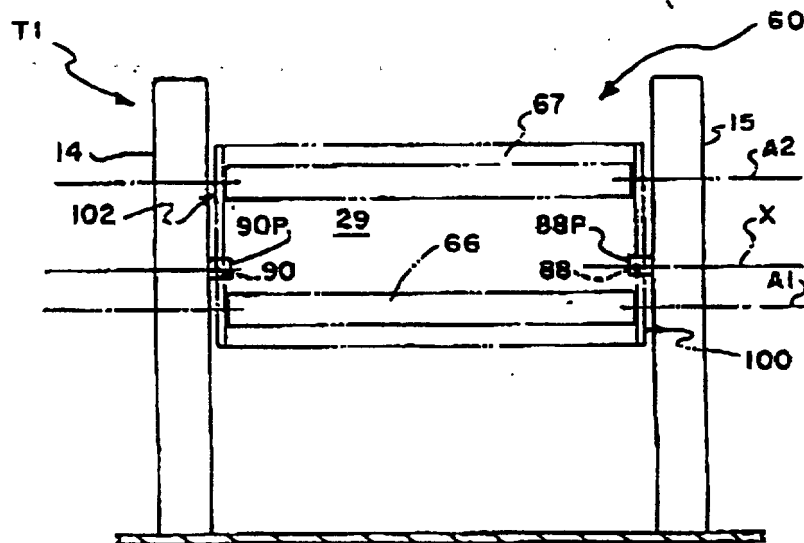


FIG. 9

FOOTNOTES

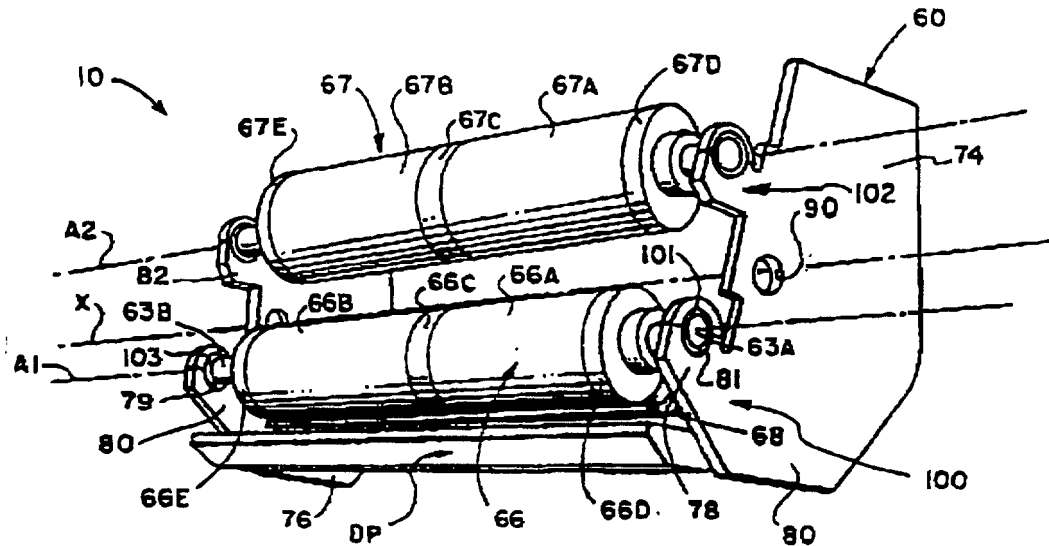


FIG. 10

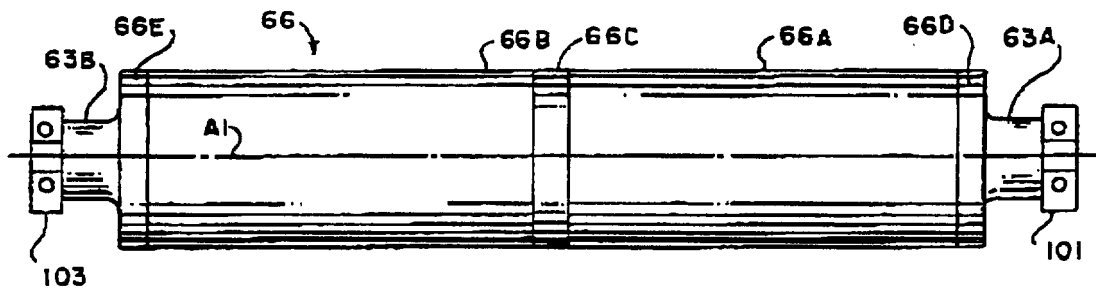


FIG. 11

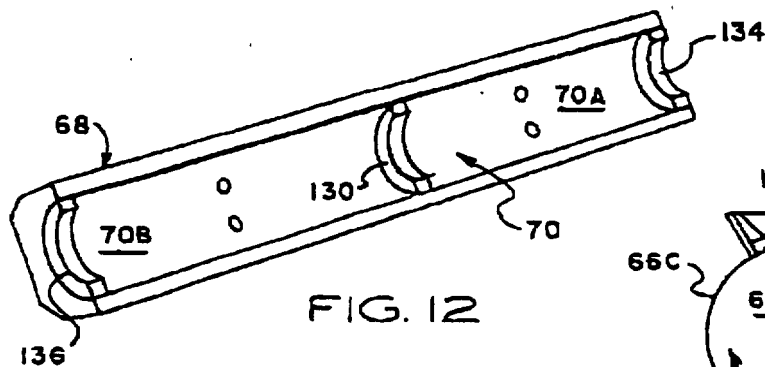


FIG. 12

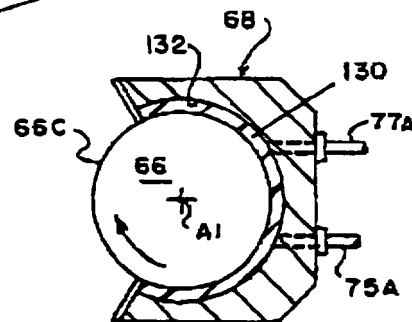


FIG. 13

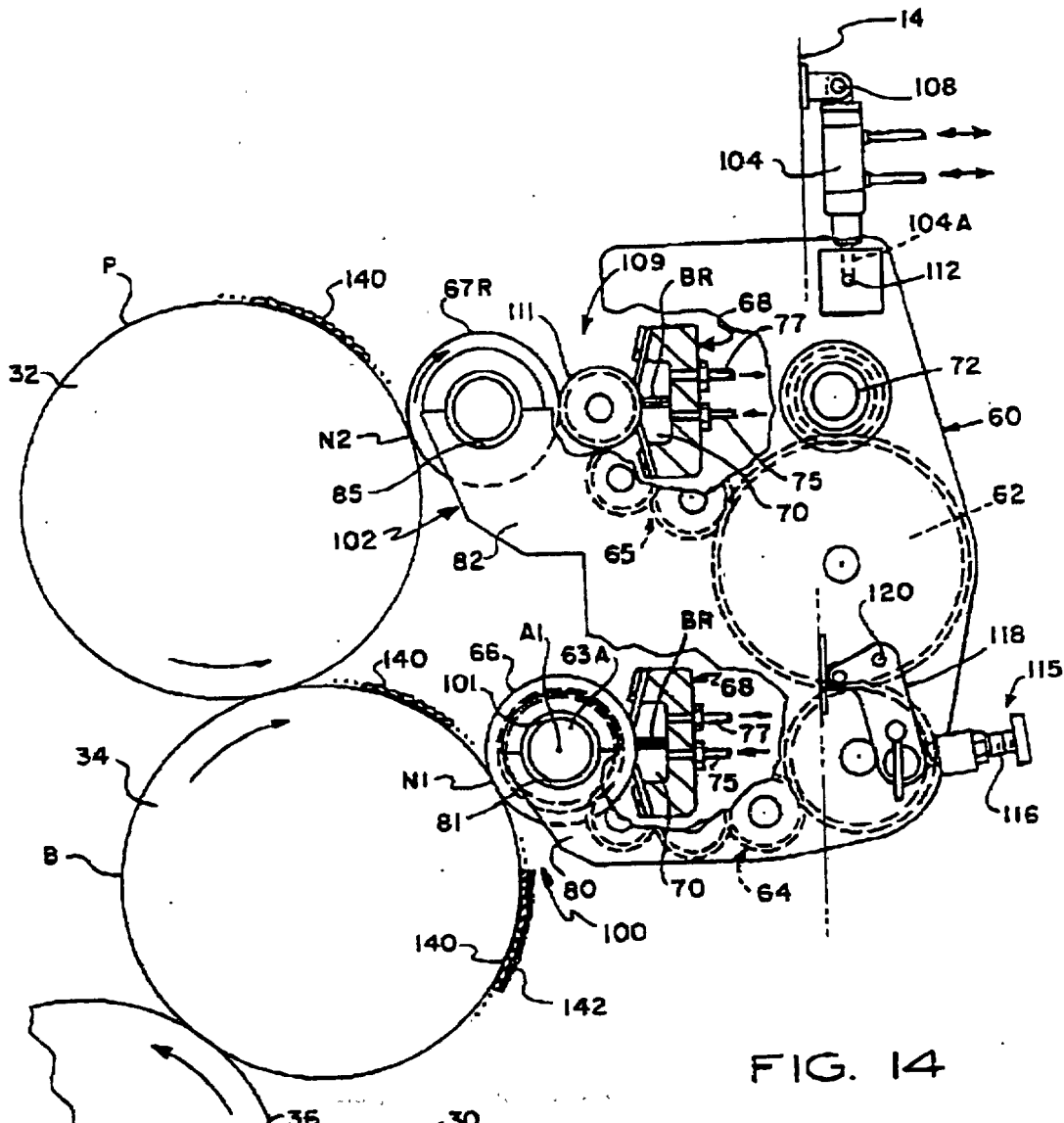


FIG. 14

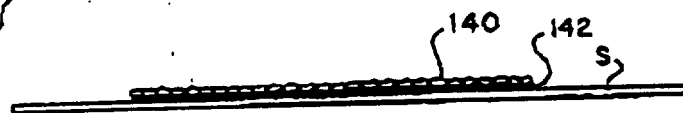
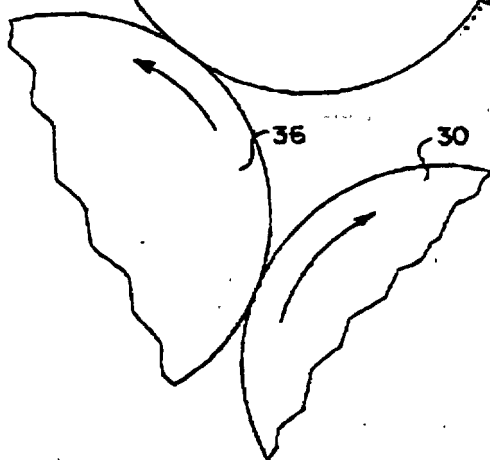


FIG. 15

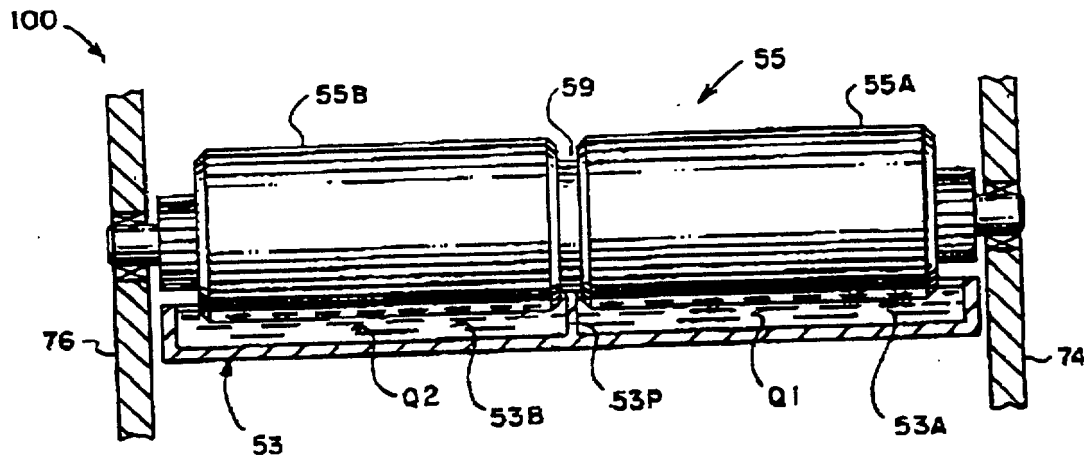


FIG. 16

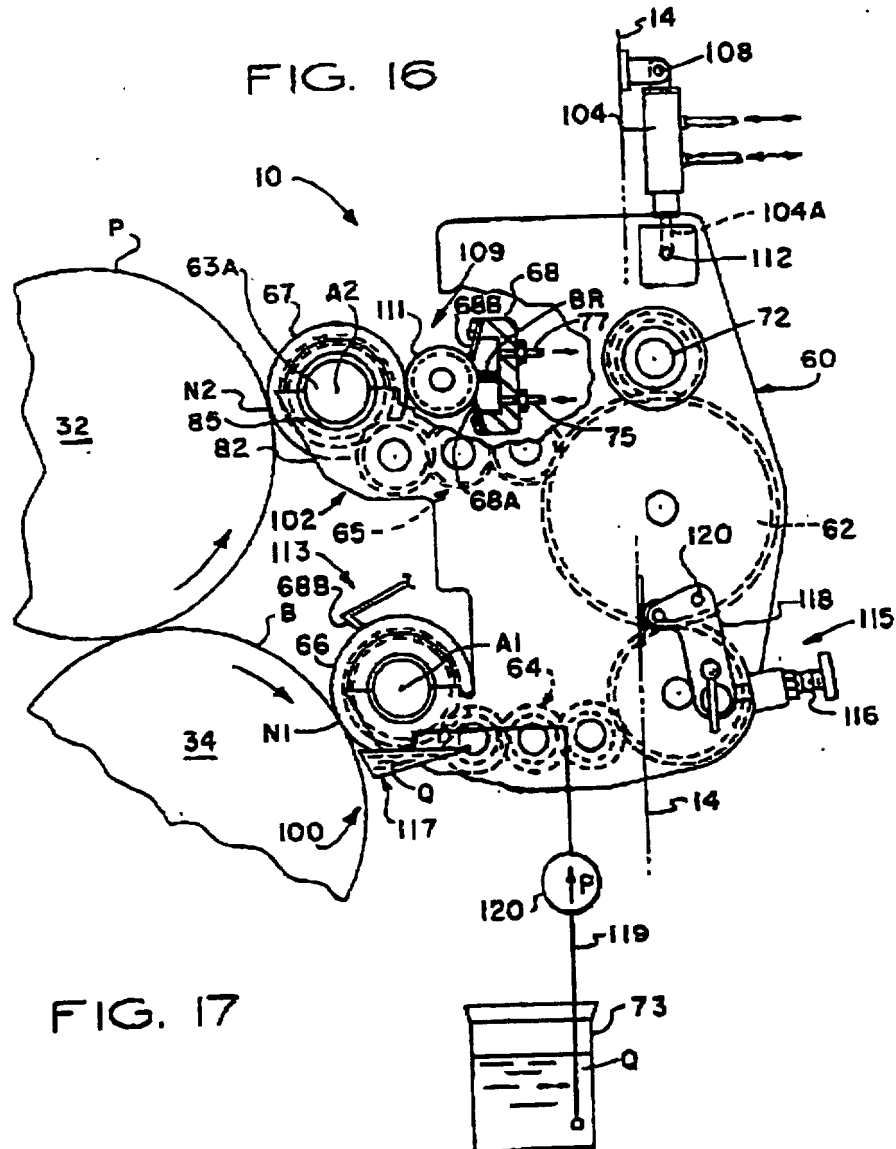


FIG. 17

FIG. 17

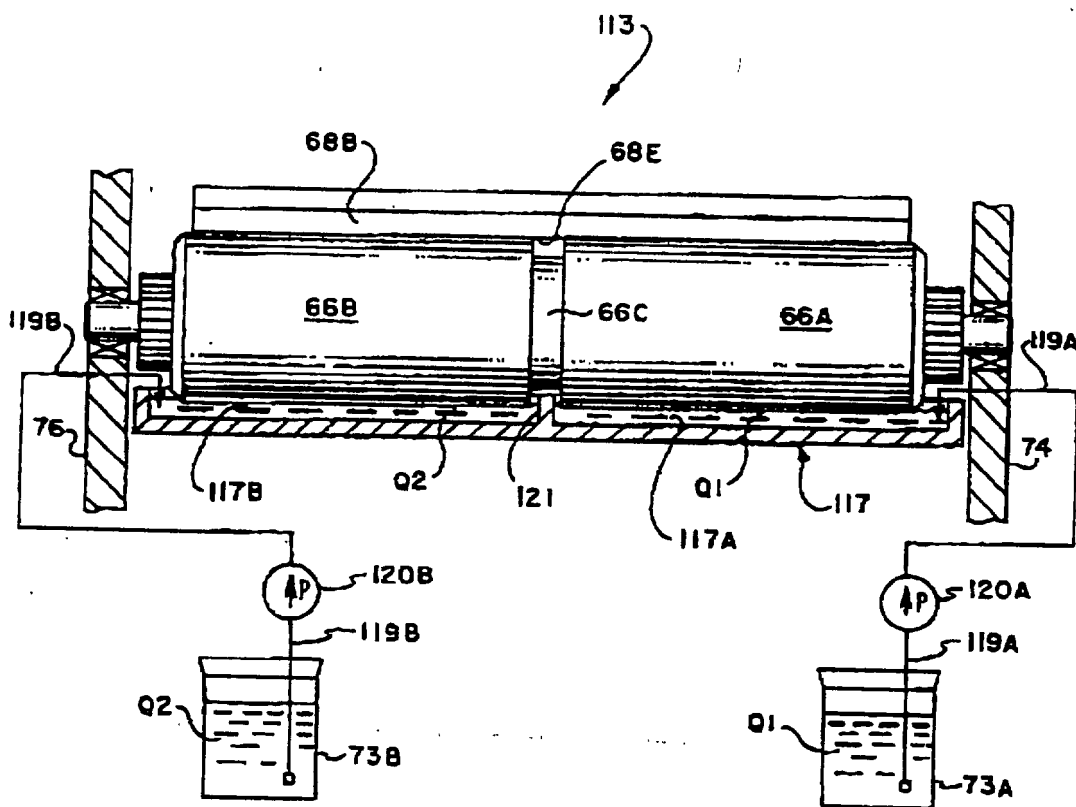


FIG. 18

RETRACTABLE PRINTING/COATING UNIT OPERABLE ON THE PLATE AND BLANKET CYLINDERS SIMULTANEOUSLY FROM THE DAMPENER SIDE OF THE FIRST PRINTING UNIT OR ANY CONSECUTIVE PRINTING UNIT OF ANY ROTARY OFFSET PRINTING PRESS

FIELD OF THE INVENTION

This invention relates generally to sheet-fed or web-fed, rotary offset lithographic printing presses, and more particularly, to a new and improved inking/coating apparatus for the in-line application of aqueous or flexographic printing inks, primer or protective/decorative coatings applied simultaneously to the plate and blanket of the first or any consecutive printing unit of any lithographic printing press.

BACKGROUND OF THE INVENTION

Conventional sheet-fed, rotary offset printing presses typically include one or more printing units through which individual sheets are fed and printed. After the last printing unit, freshly printed sheets are transferred by a delivery conveyor to the delivery end of the press where the freshly printed and/or coated sheets are collected and stacked uniformly. In a typical sheet-fed, rotary offset printing press such as the Heidelberg Speedmaster line of presses, the delivery conveyor includes a pair of endless chains carrying gripper bars with gripper fingers which grip and pull freshly printed sheets from the last impression cylinder and convey the sheets to the sheet delivery stacker.

Since the inks used with sheet fed rotary offset printing presses are typically wet and tacky, special precautions must be taken to prevent marking and smearing of the freshly printed or coated sheets as the sheets are transferred from one printing unit to another. The printed ink on the surface of the sheet dries relatively slowly and is easily smeared during subsequent transfer between printing units. Marking, smearing and smudging can be prevented by a vacuum assisted sheet transfer apparatus as described in the following U.S. Pat. Nos. 5,113,255; 5,127,329; 5,205,217; 5,228,391; 5,243,909; and 5,419,254, all to Howard W. DeMoore, co-inventor, and manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A. under its trademark BACVACO.

In some printing jobs, offsetting is prevented by applying a protective and/or decorative coating material over all or a portion of the freshly printed sheets. Some coatings are formed of a UV-curable or water-dispersed resin applied as a liquid solution over the freshly printed sheets to protect the ink from offsetting or set-off and improve the appearance of the freshly printed sheets. Such coatings are particularly desirable when decorative or protective finishes are applied in the printing of posters, record jackets, brochures, magazines, folding cartons and the like.

DESCRIPTION OF THE PRIOR ART

Various arrangements have been made for applying the coating as an in-line printing operation by using the last printing unit of the press as the coating application unit. For example, U.S. Pat. Nos. 4,270,483; 4,685,414; and 4,779,557 disclose coating apparatus which can be moved into position to permit the blanket cylinder of the last printing unit of a printing press to be used to apply a coating material over the freshly printed sheets. In U.S. Pat. No. 4,841,903 (Bird) there are disclosed coating apparatus which can be

selectively moved between the plate cylinder or the blanket cylinder of the last printing unit of the press so the last printing unit can only be used for coating purposes. However, when coating apparatus of these types are being used, the last printing unit cannot be used to print ink to the sheets, but rather can only be used for the coating operation. Thus, while coating with this type of in-line coating apparatus, the printing press loses the capability of printing on the last printing unit as it is converted to a coating unit.

The coater of U.S. Pat. No. 5,107,790 (Sliker et al) is retractable along an inclined rail for extending and retracting a coater head into engagement with a blanket on the blanket cylinder. Because of its size, the rail-retractable coater can only be installed between the last printing unit of the press and the delivery sheet stacker, and cannot be used for interunit coating. The coater of U.S. Pat. No. 4,615,293 (Jahn) provides two separate, independent coaters located on the dampener side of a converted printing unit for applying lacquer to a plate and to a rubber blanket. Consequently, although a plate and blanket are provided, the coating unit of Jahn's press is restricted to a dedicated coating operation only.

Proposals have been made for overcoming the loss of a printing unit when in-line coating is used, for example as set forth in U.S. Pat. No. 5,176,077 to Howard W. DeMoore (co-inventor and assignee), which discloses a coating apparatus having an applicator roller positioned to apply the coating material to the freshly printed sheet while the sheet is still on the last impression cylinder of the press. This allows the last printing unit to print and coat simultaneously, so that no loss of printing unit capability results.

Some conventional coaters are rail-mounted and occupy a large amount of press space and reduce access to the press. Elaborate equipment is needed for retracting such coaters from the operative coating position to the inoperative position, which reduces access to the printing unit.

Accordingly, there is a need for an in-line inking/coating apparatus which does not result in the loss of a printing unit, does not extend the length of the press, and which can print and coat aqueous and flexographic inks and coating materials simultaneously onto the plate and blanket on any lithographic printing unit of any lithographic printing press, including the first printing unit.

OBJECTS OF THE INVENTION

Accordingly, a general object of the present invention is to provide improved inking/coating apparatus which is capable of selectively applying ink or coating material to a plate on a plate cylinder or ink or coating material to a plate or blanket on a blanket cylinder.

A specific object of the present invention is to provide improved inking/coating apparatus of the character described which is extendable into inking/coating engagement with either a plate on a plate cylinder or to a plate or blanket on a blanket cylinder.

A related object of the present invention is to provide improved inking/coating apparatus of the character described which is capable of being mounted on any lithographic printing unit of the press and does not interfere with operator access to the plate cylinder, blanket cylinder, or adjacent printing units.

Another object of the present invention is to provide improved inking/coating apparatus of the character described, which can be moved from an operative inking/coating engagement position adjacent to a plate cylinder or a blanket cylinder to a non-operative, retracted position.

Still another object of the present invention is to provide improved inking/coating apparatus of the character described, which can be used for applying aqueous, flexographic and ultra-violet curable inks and/or coatings in combination with lithographic, flexographic and waterless printing processes on any rotary offset printing press.

A related object of the present invention is to provide improved inking/coating apparatus of the character described, which is capable of applying aqueous or flexographic ink or coating material on one printing unit, for example the first printing unit, and drying the ink or coating material before it is printed or coated on the next printing unit so that it can be overprinted or overcoated immediately on the next printing unit with waterless, aqueous, flexographic or lithographic inks or coating materials.

Yet another object of the present invention is to provide improved inking/coating apparatus for use on a multiple color rotary offset printing press that can apply ink or coating material separately and/or simultaneously to the plate and/or blanket of a printing unit of the press from a single operative position, and from a single inking/coating apparatus.

A related object of the present invention is to provide improved inking/coating apparatus of the character described, in which virtually no printing unit adjustment or alteration is required when the inking/coating apparatus is converted from plate to blanket printing or coating and vice versa.

Another object of the present invention is to provide improved inking/coating apparatus that can be operably mounted in the dampener space of any lithographic printing unit for inking/coating engagement with either a plate on a plate cylinder or a plate or blanket on a blanket cylinder, and which does not interfere with operator movement or activities in the interunit space between printing units.

SUMMARY OF THE INVENTION

The foregoing objects are achieved by a retractable, in-line inking/coating apparatus which is mounted on the dampener side of any printing unit of a rotary offset press for movement between an operative (on-impression) inking/coating position and a retracted, disengaged (off-impression) position. The inking/coating apparatus includes an applicator roller which is movable into and out of engagement with a plate on a plate cylinder or a blanket on a blanket cylinder. The inking/coating applicator head is pivotally coupled to a printing unit by pivot pins which are mounted on the press side frames in the traditional dampener space of the printing unit in parallel alignment with the plate cylinder and the blanket cylinder. This dampener space mounting arrangement allows the inking/coating unit to be installed between any adjacent printing units on the press.

In the preferred embodiment, the applicator head includes vertically spaced pairs of cradle members with one cradle pair being adapted for supporting an inking/coating applicator roller in alignment with a plate cylinder, and the other cradle pair supporting an inking/coating applicator roller in alignment with the blanket cylinder, respectively, when the applicator head is in the operative position. Because of the pivotal support provided by the pivot pins, the applicator head can be extended and retracted within the limited space available in the traditional dampener space, without restricting operator access to the printing unit cylinders and without causing a printing unit to lose its printing capability.

When the inking/coating apparatus is used in combination with a flexographic printing plate and aqueous or flexo-

graphic ink or coating material, the water component of the aqueous or flexographic ink or coating material on the freshly printed or coated sheet is evaporated and dried by a high velocity, hot air interunit dryer and a high volume heat and moisture extractor assembly so that the freshly printed ink or coating material is dry before the sheet is printed or coated on the next printing unit. This quick drying process permits a base layer or film of ink, for example opaque white or metallic (gold, silver or other metallics) ink to be printed on the first printing unit, and then overprinted on the next printing unit without back-trapping or dot gain.

The construction and operation of the present invention will be understood from the following detailed description taken in conjunction with the accompanying drawings which disclose, by way of example, the principles and advantages of the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of a sheet fed, rotary offset printing press having inking/coating apparatus embodying the present invention;

FIG. 2 is a simplified perspective view of the single head, dual cradle inking/coating apparatus of the present invention;

FIG. 3 is a schematic side elevational view of the printing press of FIG. 1 having single head, dual cradle inking/coating apparatus installed in the traditional dampener position of the first, second and last printing units;

FIG. 4 is a simplified side elevational view showing the single head, dual cradle inking/coating apparatus in the operative inking/coating position for simultaneously printing on the printing plate and blanket on the fourth printing unit;

FIG. 5 is a simplified side elevational view showing the single head, dual cradle inking/coating apparatus in the operative position for spot or overall inking or coating on the blanket of the first printing unit, and showing the dual cradle inking/coating apparatus in the operative position for spot or overall inking or coating on the printing plate of the second printing unit;

FIG. 6 is a simplified side elevational view of the single head, dual cradle inking/coating apparatus of FIG. 4 and FIG. 5, partially broken away, showing the single head, dual cradle inking/coating apparatus in the operative coating position and having a sealed doctor blade reservoir assembly for spot or overall coating on the blanket;

FIG. 7 is a schematic view showing a heat exchanger and pump assembly connected to the single head, dual cradle inking/coating apparatus for circulating temperature controlled ink or coating material to the inking/coating apparatus;

FIG. 8 is a side elevational view, partially broken away, and similar to FIG. 6 which illustrates an alternative coating head arrangement;

FIG. 9 is a simplified elevational view of a printing unit which illustrates pivotal coupling of the inking/coating apparatus on the printing unit side frame members;

FIG. 10 is a view similar to FIG. 2 in which a pair of split applicator rollers are mounted in the upper cradle and lower cradle, respectively;

FIG. 11 is a side elevational view of a split applicator roller;

FIG. 12 is a perspective view of a doctor blade reservoir which is centrally partitioned by a seal element;

FIG. 13 is a sectional view showing sealing engagement of the split applicator roller against the partition seal element of FIG. 12;

FIG. 14 is a view similar to FIG. 8 which illustrates an alternative inking/coating embodiment;

FIG. 15 is a simplified side elevational view of a substrate which has a bronzed-like finish which is applied by simultaneous operation of the dual applicator roller embodiment of FIG. 14;

FIG. 16 is a side elevational view, partly in section, of a pan roller having separate transfer surfaces mounted on a split fountain pan;

FIG. 17 is a simplified side elevational view of the dual cradle inking/coating apparatus, partially broken away, which illustrates an alternative inking/coating head apparatus featuring a single doctor blade assembly, anilox applicator roller mounted on the lower cradle; and

FIG. 18 is a side elevational view, partly in section, of a single doctor blade anilox applicator roller assembly having separate transfer surfaces, and a split fountain pan having separate fountain compartments, with the separate fountain compartments being supplied with different inks or coating materials from separate off-press sources.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

As used herein, the term "processed" refers to printing and coating methods which can be applied to either side of a substrate, including the application of lithographic, waterless, UV-curable, aqueous and flexographic inks and/or coatings. The term "substrate" refers to sheet and web material. Also, as used herein, the term "waterless printing plate" refers to a printing plate having image areas and non-image areas which are oleophilic and oleophobic, respectively. "Waterless printing ink" refers to an oil-based ink which does not contain a significant aqueous component. "Flexographic plate" refers to a flexible printing plate having a relief surface which is wettable by flexographic ink or coating material. "Flexographic printing ink or coating material" refers to an ink or coating material having a base constituent of either water, solvent or UV-curable liquid. "UV-curable lithographic printing ink and coating material" refers to oil-based printing inks and coating materials that can be cured (dried) photomechanically by exposure to ultraviolet radiation, and that have a semi-paste or gel-like consistency. "Aqueous printing ink or coating material" refers to an ink or coating material that predominantly contains water as a solvent, diluent or vehicle. A "relief plate" refers to a printing plate having image areas which are raised relative to non-image areas which are recessed.

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line inking/coating apparatus, herein generally designated 10, for applying aqueous, flexographic or UV-curable inks or protective and/or decorative coatings to sheets or webs printed in a sheet-fed or web-fed, rotary offset printing press, herein generally designated 12. In this instance, as shown in FIG. 1, the inking/coating apparatus 10 is installed in a four unit rotary offset printing press 12, such as that manufactured by Heidelberg Druckmaschinen AG of Germany under its designation Heidelberg Speedmaster SM102 (40", 102 cm).

The press 12 includes a press frame 14 coupled at one end, herein the right end, to a sheet feeder 16 from which sheets, herein designated S, are individually and sequentially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the freshly printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical sheet printing units 22, 24, 26 and 28 which can print four

different colors onto the sheets as they are transferred through the press 12. The printing units are housed within printing towers T1, T2, T3 and T4 formed by side frame members 14, 15. Each printing tower has a delivery side 25 and a dampener side 27. A dampener space 29 is partially enclosed by the side frames on the dampener side of the printing unit.

As illustrated, the printing units 22, 24, 26 and 28 are substantially identical and of conventional design. The first printing unit 22 includes an in-feed transfer cylinder 30, a plate cylinder 32, a blanket cylinder 34 and an impression cylinder 36, all supported for rotation in parallel alignment between the press side frames 14, 15 which define printing unit towers T1, T2, T3 and T4. Each of the first three printing units 22, 24 and 26 have a transfer cylinder 38 disposed to transfer the freshly printed sheets from the adjacent impression cylinder and transfer the freshly printed sheets to the next printing unit via an intermediate transfer drum 40.

The last printing unit 28 includes a delivery cylinder 42 mounted on a delivery shaft 43. The delivery cylinder 42 supports the freshly printed sheet 18 as it is transferred from the last impression cylinder 36 to a delivery conveyor system, generally designated 44, which transfers the freshly printed sheet to the sheet delivery stacker 20. To prevent smearing during transfer, a flexible covering is mounted on the delivery cylinder 42, as described and claimed in U.S. Pat. No. 4,402,267 to Howard W. DeMoore, which is incorporated herein by reference. The flexible covering is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE®. Optionally, a vacuum-assisted sheet transfer assembly manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark BACVAC® can be substituted for the delivery transfer cylinder 42 and flexible covering.

The delivery conveyor system 44 as shown in FIG. 3 is of conventional design and includes a pair of endless delivery gripper chains 46, only one of which is shown carrying at regular spaced locations along the chains, laterally disposed gripper bars having gripper fingers used to grip the leading edge of a freshly printed or coated sheet 18 after it leaves the nip between the impression cylinder 36 and delivery cylinder 42 of the last printing unit 28. As the leading edge is gripped by the gripper fingers, the delivery chains 46 pull the sheet away from the last impression cylinder 36 and convey the freshly printed or coated sheet to the sheet delivery stacker 20.

Prior to reaching the delivery sheet stacker, the freshly printed and/or coated sheets S pass under a delivery dryer 48 which includes a combination of infra-red thermal radiation, high velocity hot air flow and a high performance heat and moisture extractor for drying the ink and/or the protective/decorative coating. Preferably, the delivery dryer 48, including the high performance heat and moisture extractor is constructed as described in U.S. application Ser. No. 08/116, 711, filed Sep. 3, 1993, entitled "Infra-Red Forced Air Dryer and Extractor" by Howard C. Secor, Ronald M. Rendleman and Paul D. Copenhaver, commonly assigned to the assignee of the present invention, Howard W. DeMoore, and licensed to Printing Research, Inc. of Dallas, Tex., U.S.A., which manufactures and markets the delivery dryer 48 under its trademark AIR BLANKET™.

In the exemplary embodiment shown in FIG. 3, the first printing unit 22 has a flexographic printing plate PF mounted on the plate cylinder, and therefore neither an inking roller train nor a dampening system is required. A

flexographic printing plate PF is also mounted on the plate cylinder of the second printing unit 24. The form rollers of the inking roller train 52 shown mounted on the second printing unit 24 are retracted and locked off to prevent plate contact. Flexographic ink is supplied to the flexographic plate PF of the second printing unit 24 by the inking/coating apparatus 10.

A suitable flexographic printing plate PF is offered by E.I. du Pont de Nemours of Wilmington, Del., U.S.A., under its trademark CYREL®. Another source is BASF Aktiengesellschaft of Ludwigshafen, Germany, which offers a suitable flexographic printing plate under its trademark NYLOFLEX®.

The third printing unit 26 as illustrated in FIG. 3 and FIG. 4 is equipped for lithographic printing and includes an inking apparatus 50 having an inking roller train 52 arranged to transfer ink Q from an ink fountain 54 to a lithographic printing plate P mounted on the plate cylinder 32. This is accomplished by a fountain roller 56 and a doctor roller 57. The fountain roller 56 projects into the ink fountain 54, whereupon its surface picks up ink. The lithographic printing ink Q is transferred from the fountain roller 56 to the inking roller train 52 by the doctor roller 57. The inking roller train 52 supplies ink Q to the image areas of the lithographic printing plate P.

The lithographic printing ink Q is transferred from the lithographic printing plate P to an ink receptive blanket B which is mounted on the blanket cylinder 34. The inked image carried on the blanket B is transferred to a substrate S as the substrate is transferred through the nip between the blanket cylinder 34 and the impression cylinder 36.

The inking roller arrangement 52 illustrated in FIG. 3 and FIG. 4 is exemplary for use in combination with lithographic ink printing plates P. It is understood that a dampening system 58 having a dampening fluid reservoir DF is coupled to the inking roller train 52 (FIG. 4), but is not required for waterless or flexographic printing.

The plate cylinder 32 of printing unit 28 is equipped with a waterless printing plate PW. Waterless printing plates are also referred to as dry planographic printing plates and are disclosed in the following U.S. Pat. Nos.: 3,910,187; Re. 30,670; 4,086,093; and 4,853,313. Suitable waterless printing plates can be obtained from Toray Industries, Inc. of Tokyo, Japan. A dampening system is not used for waterless printing, and waterless (oil-based) printing ink is used. The waterless printing plate PW has image areas and non-image areas which are oleophilic/hydrophilic and oleophobic/hydrophobic, respectively. The waterless printing plate PW is engraved or etched, with the image areas being recessed with respect to the non-image areas. The image area of the waterless printing plate PW is rolled-up with the flexographic or aqueous printing ink which is transferred by the applicator roller 66. Both aqueous and oil-based inks and coatings are repelled from the non-image areas, and are retained in the image areas. The printing ink or coating is then transferred from the image areas to an ink or coating receptive blanket B and is printed or coated onto a substrate S.

For some printing jobs, a flexographic plate PF or a waterless printing plate PW is mounted over a resilient packing such as the blanket B on the blanket cylinder 34, for example as indicated by phantom lines in printing unit 22 of FIG. 5. An advantage of this alternative embodiment is that the waterless plate PW or the flexographic plate PF are resiliently supported over the blanket cylinder by the underlying blanket B or other resilient packing. The radial deflec-

tion and give of the resilient blanket B provides uniform, positive engagement between the applicator roller 66 and a flexographic plate or waterless plate.

In that arrangement, a plate is not mounted on the plate cylinder 32; instead, a waterless plate PW is mounted on the blanket cylinder, and the inked image on the waterless printing plate is not offset but is instead transferred directly from the waterless printing plate PW to the substrate S. The water component of flexographic ink on the freshly printed sheet is evaporated by high velocity, hot air dryers and high volume heat and moisture extractors so that the freshly printed aqueous or flexographic ink is dried before the substrate is printed on the next printing unit.

Referring now to FIG. 2, FIG. 3 and FIG. 9, the inking/coating apparatus 10 is pivotally mounted on the side frames 14, 15 for rotation about an axis X. The inking/coating apparatus 10 includes a frame 60, a hydraulic motor 62, a lower gear train 64, an upper gear train 65, an applicator roller 66, a sealed doctor blade assembly 68 (FIG. 6), and a drip pan DP, all mounted on the frame 60. The external peripheral surface of the applicator roller 66 is wetted by contact with liquid coating material or ink contained in a reservoir 70.

The hydraulic motor 62 drives the applicator roller 66 synchronously with the plate cylinder 32 and the blanket cylinder 34 in response to an RPM control signal from the press drive (not illustrated) and a feedback signal developed by a tachometer 72. While a hydraulic drive motor is preferred, other drive means such as an electric drive motor or an equivalent can be used.

When using waterless printing plate systems, the temperature of the waterless printing ink and of the waterless printing plate must be closely controlled for good image reproduction. For example, for waterless offset printing with TORAY waterless printing plates PW, it is absolutely necessary to control the waterless printing plate surface and waterless ink temperature to a very narrow range, for example 24° C. (75° F.) to 27° C. (80° F.).

Referring to FIG. 7, the reservoir 70 is supplied with ink or coating which is temperature controlled by a heat exchanger 71. The temperature controlled ink or coating material is circulated by a positive displacement pump, for example a peristaltic pump, through the reservoir 70 and heat exchanger 71 from a source 73 through a supply conduit 75 and a return conduit 77. The heat exchanger 71 cools or heats the ink or coating material and maintains the ink or coating and the printing plate within the desired narrow temperature range.

According to one aspect of the present invention, aqueous/flexographic ink or coating material is supplied to the applicator roller 66, which transfers the aqueous/flexographic ink or coating material to the printing plate (FIG. 7), which may be a waterless printing plate or a flexographic printing plate. When the inking/coating apparatus is used for applying aqueous/flexographic ink or coating material to a waterless printing plate PW, the inking roller train 52 is not required, and is retracted away from the printing plate. Because the viscosity of aqueous/flexographic printing ink or coating material varies with temperature, it is necessary to heat or cool the aqueous/flexographic printing ink or coating material to compensate for ambient temperature variations to maintain the ink viscosity in a preferred operating range.

For example, the temperature of the printing press can vary from around 60° F. (15° C.) in the morning, to around 85° F. (29° C.) or more in the afternoon. The viscosity of

aqueous/flexographic printing ink or coating material can be marginally high when the ambient temperature of the press is near 60° F. 15° C.), and the viscosity can be marginally low when the ambient temperature of the press exceeds 85° F. (29° C.). Consequently, it is desirable to control the temperature of the aqueous/flexographic printing ink or coating material so that it will maintain the surface temperature of waterless printing plates within the specified temperature range. Moreover, the ink/coating material temperature should be controlled to maintain the tack of the aqueous/flexographic printing ink or coating material within a desired range when the ink or coating material is being used in connection with flexographic printing processes.

The applicator roller 66 is preferably an anilox fluid metering roller which transfers measured amounts of printing ink or coating material to a plate or blanket. The surface of an anilox roller is engraved with an array of closely spaced, shallow depressions referred to as "cells". Ink or coating from the reservoir 70 flows into the cells as the anilox roller turns through the reservoir. The transfer surface of the anilox roller is "doctored" (wiped or scraped) by dual doctor blades 68A, 68B to remove excess ink or coating material. The ink or coating metered by the anilox roller is that contained within the cells. The dual doctor blades 68A, 68B also seal the supply reservoir 70.

The anilox applicator roller 66 is cylindrical and may be constructed in various diameters and lengths, containing cells of various sizes and shapes. The volumetric capacity of an anilox roller is determined by cell size, shape and number of cells per unit area. Depending upon the intended application, the cell pattern may be fine (many small cells per unit area) or coarse (fewer large cells per unit area).

By supplying the ink or coating material through the inking/coating apparatus 10, more ink or coating material can be applied to the sheet S as compared with the inking roller train of a lithographic printing unit. Moreover, color intensity is stronger and more brilliant because the aqueous or flexographic ink or coating material is applied at a much heavier film thickness or weight than can be applied by the lithographic process, and the aqueous or flexographic colors are not diluted by dampening solution.

Preferably, the sealed doctor blade assembly 68 is constructed as described in U.S. Pat. No. 5,176,077 to Howard W. DeMoore, co-inventor and assignee, which is incorporated herein by reference. An advantage of using a sealed reservoir is that fast drying ink or coating material can be used. Fast drying ink or coating material can be used in an open fountain 53 (see FIG. 8); however, open air exposure causes the water and solvents in the fast-drying ink or coating material to evaporate faster, thus causing the ink or coating material to dry prematurely and change viscosity. Moreover, an open fountain emits unwanted odors into the press room. When the sealed doctor blade assembly is utilized, the pump (FIG. 7) which circulates ink or coating material to the doctor blade head is preferably a peristaltic pump, which does not inject air into the feeder lines which supply the ink or coating reservoir 70 and helps to prevent the formation of air bubbles and foam within the ink or coating material.

An inking/coating apparatus 10 having an alternative applicator roller arrangement is illustrated in FIGS. 10-13. In this arrangement, the engraved metering surface of the anilox applicator rollers 66, 67 are partitioned by smooth seal surfaces 66C which separates a first engraved peripheral surface portion 66A from a second engraved peripheral surface portion 66B. Likewise, smooth seal surfaces 66D,

66E are formed on the opposite end portions of the applicator roller 66 for engaging end seals 134, 136 (FIG. 12) of the doctor blade reservoir. The upper applicator roller 67 has engraved anilox metering surfaces 67A and 67B which are separated by a smooth seal band 67C.

Referring now to FIG. 12 and FIG. 13, the reservoir 70 of the doctor blade head 68 is partitioned by a curved seal element 130 to form two separate chambers 70A, 70B. The seal element 130 is secured to the doctor blade head within an annular groove 132. The seal element 130 is preferably made of polyurethane foam or other durable, resilient foam material. The seal element 130 is engaged by the seal band 66C, thus forming a rotary seal which blocks the leakage of ink or coating material from one reservoir chamber into the other reservoir chamber. Moreover, the seal band provides an unprinted or uncoated area which separates the printed or coated areas from each other, which is needed for work and turn printing jobs or other printing jobs which print two or more separate images onto the same substrate.

Another advantage of the split applicator roller embodiment is that it enables two or more flexographic inks or coating materials to be printed simultaneously within the same lithographic printing unit. That is, the reservoir chambers 70A, 70B of the upper doctor blade assembly can be supplied with gold ink and silver ink, for example, while the reservoir chambers 70A, 70B of the lower doctor blade assembly can be supplied with inks of two additional colors, for example opaque white ink and blue ink. This permits the opaque white ink to be overprinted with the gold ink, and the blue ink to be overprinted with the silver ink on the same printing unit on any lithographic press.

Moreover, a catalyst can be used in the upper doctor blade reservoir and a reactive ink or coating material can be used in the lower doctor blade reservoir. This can provide various effects, for example improved chemical resistance and higher gloss levels.

The split applicator roller sections 67A, 67B in the upper cradle position can be used for applying two separate inks or coating materials simultaneously, for example flexographic, aqueous and ultra-violet curable inks or coating materials, to separate surface areas of the plate, while the lower applicator roller sections 66A, 66B can apply an initiator layer and a micro-encapsulated layer simultaneously to separate blanket surface areas. Optionally, the metering surface portions 66A, 66B can be provided with different cell metering capacities for providing different printing effects which are being printed simultaneously. For example, the screen line count on one half-section of an anilox applicator roller is preferably in the range of 200-600 lines per inch (79-236 lines per cm) for half-tone images, and the screen line count of the other half-section is preferably in the range of 100-300 lines per inch (39-118 lines per cm) for overall coverage, high weight applications such as opaque white. This split arrangement in combination with dual applicator rollers is particularly advantageous when used in connection with "work and turn" printing jobs.

Referring again to FIG. 8, instead of using the sealed doctor blade reservoir assembly 68 as shown in FIG. 6, an open fountain assembly 69 is provided by the fountain pan 53 which contains a volume of liquid ink Q or coating material. The liquid ink or coating material is transferred to the applicator roller 66 by a pan roller 55 which turns in contact with ink Q or coating material in the fountain pan. If a split applicator roller is used, the pan roller 55 is also split, and the pan is divided into two pan sections 53A, 53B by a separator plate 53P, as shown in FIG. 16.

In the alternative embodiment of FIG. 16, the pan roller 55 is divided into two pan roller sections 55A, 55B by a centrally located, annular groove 59. The separator plate 53P is received within and centrally aligned with the groove 59, but does not touch the adjoining roller faces. By this arrangement, two or more inks or coating materials Q1, Q2 are contained within the open pan sections 55A, 55B for transfer by the split pan roller sections 53A, 53B, respectively. This permits two or more flexographic inks or coating materials to be transferred to two separate image areas on the plate or on the blanket of the same printing unit. This arrangement is particularly advantageous for work and turn printing jobs or other printing jobs which print two or more separate images onto the same substrate.

The frame 60 of the inking/coating apparatus 10 includes side support members 74, 76 which support the applicator roller 66, gear train 64, gear train 65, doctor blade assembly 68 and the drive motor 62. The applicator roller 66 is mounted on stub shafts 63A, 63B which are supported at opposite ends on a lower cradle assembly 100 formed by a pair of side support members 78, 80 which have sockets 79, 81 and retainer caps 101, 103. The stub shafts are received in roller bearings 105, 107 which permit free rotation of the applicator roller 66 about its longitudinal axis A1 (axis A2 in the upper cradle). The retainer caps 101, 103 hold the stub shafts 63A, 63B and bearings 105, 107 in the sockets 79, 81 and hold the applicator roller 66 in parallel alignment with the pivot axis X.

The side support members 74, 76 also have an upper cradle assembly 102 formed by a pair of side support members 82, 84 which are vertically spaced with respect to the lower side plates 78, 80. Each cradle 100, 102 has a pair of sockets 79, 81 and 83, 85, respectively, for holding an applicator roller 66, 67 for spot coating or inking engagement with the printing plate P the plate cylinder 32 (FIG. 4) or with a printing plate P or a blanket B on the blanket cylinder 34.

Preferably, the applicator roller 67 (FIG. 8, FIG. 9) the upper cradle (plate) position is an anilox roller having a resilient transfer surface. In the dual cradle arrangement as shown in FIG. 2, the press operator can quickly change from blanket inking/coating to plate inking/coating within minutes, since it is only necessary to release, remove and reposition or replace the applicator roller 66.

The capability to simultaneously print in the flexographic mode, the aqueous mode, the waterless mode, or the lithographic mode on different printing units of the same lithographic press and to print or coat from either the plate position or the blanket position on any one of the printing units is referred to herein as the LITHOFLEX™ printing process or system. LITHOFLEX™ is a trademark of Printing Research, Inc. of Dallas, Tex., U.S.A., exclusive licensee of the present invention.

Referring now to FIG. 14, an inking/coating apparatus 10 having an inking/coating assembly 109 of an alternative design is installed in the upper cradle position for applying ink and/or coating material to a plate P on the plate cylinder 32. According to this alternative embodiment, an applicator roller 67R having a resilient transfer surface is coupled to an anilox fluid metering roller which transfers measured amounts of printing ink or coating material to the plate P. The anilox roller 111 has a transfer surface constructed of metal, ceramic or composite material which is engraved with cells. The resilient applicator roller 67R is interposed in transfer engagement with the plate P and the metering surface of the anilox roller 111. The resilient transfer surface

of the applicator roller 67R provides uniform, positive engagement with the plate.

Referring now to FIG. 17, an inking/coating apparatus 10 having an alternative inking/coating assembly 113 is installed in the lower cradle assembly 100 for applying flexographic or aqueous ink and/or coating material Q to a plate or blanket mounted on the blanket cylinder 34. Instead of using the sealed, dual doctor blade reservoir assembly 68 as shown in FIG. 6, an open, single doctor blade anilox roller assembly 113 is supplied with liquid ink Q or coating material contained in an open fountain pan 117. The liquid ink or coating material Q is transferred to the engraved transfer surface of the anilox roller 66 as it turns in the fountain pan 117. Excess ink or coating material Q is removed from the engraved transfer surface by a single doctor blade 68B. The liquid ink or coating material Q is pumped from an off-press source, for example the drum 73 shown in FIG. 17, through a supply conduit 119 into the fountain pan 117 by a pump 120.

For overall inking or coating jobs, the metering transfer surface of the anilox roller 66 extends over its entire peripheral surface. However, for certain printing jobs which print two or more separate images onto the same substrate, for example work and turn printing jobs, the metering transfer surface of the anilox applicator roller 66 is partitioned by a centrally located, annular undercut groove 66C which separates first and second metering transfer surfaces 66A, 66B as shown in FIG. 11 and FIG. 18.

The single doctor blade 68B has an edge 68E which wipes simultaneously against the split metering transfer surfaces 66A, 66B. In this single blade, split anilox roller embodiment 113, it is necessary to provide dual supply sources, for example drums 73A, 73B, dual supply lines 119A, 119B, and dual pumps 120A, 120B. Moreover, the fountain pan 117 is also split, and the pan 117 is divided into two pan sections 117A, 117B by a separator plate 121, as shown in FIG. 18. The separator plate 121 is centrally aligned with the undercut groove 66C, but does not touch the adjoining roller faces.

Although the single blade, split anilox applicator roller assembly 113 is shown mounted in the lower cradle position (FIG. 17), it should be understood that the single blade, split anilox applicator roller assembly 113 can be mounted and used in the upper cradle position, as well.

According to another aspect of the present invention, the inking/coating apparatus 10 is pivotally coupled on horizontal pivot pins 88P, 90P which allows the single head, dual cradle inking/coating apparatus 10 to be mounted on any lithographic printing unit. Referring to FIG. 9, the horizontal pivot pins 88P, 90P are mounted within the traditional dampener space 29 of the printing unit and are secured to the press side frames 14, 15, respectively. Preferably, the pivot support pins 88P, 90P are secured to the press side frames by a threaded fastener. The pivot support pins are received within circular openings 88, 90 which intersect the side support members 74, 76 of the inking/coating apparatus 10. The horizontal support pins 88P, 90P are disposed in parallel alignment with rotational axis X and with the plate cylinder and blanket cylinder, and are in longitudinal alignment with each other.

Preferably, the pivot pins 88P, 90P are located in the dampener space 29 so that the rotational axes A1, A2 of the applicator rollers 66, 67 are elevated with respect to the nip contact points N1, N2. By that arrangement, the transfer point between the applicator roller 66 and a blanket on the blanket cylinder 34 (as shown in FIG. 8) and the transfer

point between the applicator roller 66 and a plate on the plate cylinder 32 (as shown in FIG. 5) are above the radius lines R1, R2 of the plate cylinder and the blanket cylinder, respectively. This permits the inking/coating apparatus 10 to move clockwise to retract the applicator roller 66 to an off-impression position relative to the blanket cylinder in response to a single extension stroke of the power actuator arms 104A, 106A. Similarly, the applicator roller 66 is moved counterclockwise to the on-impression operative position as shown in FIGS. 4, 5, 6 and 8 by a single retraction stroke of the actuator arms 104A, 106A, respectively.

Preferably, the pivot pins are made of steel and the side support members are made of aluminum, with the steel pivot pins and the aluminum collar portion bordering the circular openings 88, 90 forming a low friction journal. By this arrangement, the inking/coating apparatus 10 is freely rotatable clockwise and counterclockwise with respect to the pivot pins 88P, 90P. Typically, the arc length of rotation is approximately 60 mils (about 1.5 mm). Consequently, the inking/coating apparatus 10 is almost totally enclosed within the dampener space 29 of the printing unit in the on-impression position and in the off-impression position.

The cradle assemblies 100 and 102 position the applicator roller 66 in inking/coating alignment with the plate cylinder or blanket cylinder, respectively, when the inking/coating apparatus 10 is extended to the operative (on-impression) position. Moreover, because the inking/coating apparatus 10 is installed within the dampener space 29, it is capable of freely rotating through a small arc while extending and retracting without being obstructed by the press side frames or other parts of the printing press. This makes it possible to install the inking/coating apparatus 10 on any lithographic printing unit. Moreover, because of its internal mounting position within the dampener space 29, the projection of the inking/coating apparatus 10 into the space between printing units is minimal. This assures unrestricted operator access to the printing unit when the applicator head is in the operative (on-impression) and retracted (off-impression) positions.

As shown in FIG. 4 and FIG. 5, movement of the inking/coating apparatus 10 is counterclockwise from the retracted (off-impression) position to the operative (on-impression) position.

Although the dampener side installation is preferred, the inking/coating apparatus 10 can be adapted for operation on the delivery side of the printing unit, with the inking/coating apparatus being movable from a retracted (off-impression) position to an on-impression position for engagement of the applicator roller with either a plate on the plate cylinder or a blanket on the blanket cylinder on the delivery side 25 of the printing unit.

Movement of the inking/coating apparatus 10 to the operative (on-impression) position is produced by power actuators, preferably double acting pneumatic cylinders 104, 106 which have extendable/retractable power transfer arms 104A, 106A, respectively. The first pneumatic cylinder 104 is pivotally coupled to the press frame 14 by a pivot pin 108, and the second pneumatic cylinder 106 is pivotally coupled to the press frame 15 by a pivot pin 110. In response to selective actuation of the pneumatic cylinders 104, 106, the power transfer arms 104A, 106A are extended or retracted. The power transfer arm 104A is pivotally coupled to the side support member 74 by a pivot pin 112. Likewise, the power transfer arm 106A is pivotally coupled to the side support member 76 by a pivot pin 114.

As the power arms extend, the inking/coating apparatus 10 is rotated clockwise on the pivot pins 88P, 90P, thus

moving the applicator roller 66 to the off-impression position. As the power arms retract, the inking/coater apparatus 60 is rotated counterclockwise on the pivot pins 88P, 90P, thus moving the applicator roller 66 to the on-impression position. The torque applied by the pneumatic actuators is transmitted to the inking/coating apparatus 10 through the pivot pin 112 and pivot pin 114.

Fine adjustment of the on-impression position of the applicator roller relative to the plate cylinder or the blanket cylinder, and of the pressure of roller engagement, is provided by an adjustable stop assembly 115. The adjustable stop assembly 115 has a threaded bolt 116 which is engagable with a bell crank 118. The bell crank 118 is pivotally coupled to the side support member 74 on a pin 120. One end of the bell crank 118 is engagable by the threaded bolt 116, and a cam roller is mounted for rotation on its opposite end. The striking point of engagement is adjusted by rotation of the bolt 116 so that the applicator roller 66 is properly positioned for inking/coating engagement with the plate P or blanket B and provides the desired amount of inking/coating pressure when the inking/coating assembly 60 is moved to the operative position.

This arrangement permits the in-line inking/coating apparatus to operate effectively without encroaching in the interunit space between any adjacent printing units, and without blocking or obstructing access to the cylinders of the printing units when the inking/coating apparatus is in the extended (off-impression) position or retracted (on-impression) position. Moreover, when the in-line inking/coating apparatus is in the retracted position, the doctor blade reservoir and coating circulation lines can be drained and flushed automatically while the printing press is running as well as when the press has been stopped for change-over from one job to another or from one type of ink or coating to another.

Substrates which are printed or coated with aqueous flexographic printing inks require high velocity hot air for drying. When printing a flexographic ink such as opaque white or metallic gold, it is always necessary to dry the printed substrates between printing units before overprinting them. According to the present invention, the water component on the surface of the freshly printed or coated substrate S is evaporated and dried by high velocity, hot air interunit dryer and high volume heat and moisture extractor units 124, 126 and 128, as shown in FIG. 2, FIG. 4 and FIG. 5. The dryer/extractor units 124, 126 and 128 are oriented to direct high velocity heated air onto the freshly printed/coated substrates as they are transferred by the impression cylinder 36 and the intermediate transfer drum 40 of one printing unit and to another transfer cylinder 30 and to the impression cylinder 36 of the next printing unit. By that arrangement, the freshly printed flexographic ink or coating material is dried before the substrate S is overprinted by the next printing unit.

The high velocity, hot air dryer and high performance heat and moisture extractor units 124, 126 and 128 utilize high velocity air jets which scrub and break-up the moist air layer which clings to the surface of each freshly printed or coated sheet or web. Within each dryer, high velocity air is heated as it flows across a resistance heating element within an air delivery baffle tube. High velocity jets of hot air are discharged through multiple airflow apertures into an exposure zone Z (FIG. 4 and FIG. 5) and onto the freshly printed/coated sheet S as it is transferred by the impression cylinder 36 and transfer drum 40, respectively.

Each dryer assembly includes a pair of air delivery dryer heads 124D, 126D and 128D which are arranged in spaced,

side-by-side relationship. The high velocity, hot air dryer and high performance heat and moisture extractor units 124, 126 and 128 are preferably constructed as disclosed in co-pending U.S. patent application Ser. No. 08/132,584, filed Oct. 6, 1993, entitled "High Velocity Hot Air Dryer", to Howard W. DeMoore, co-inventor and assignee of the present invention, and which is incorporated herein by reference, and which is marketed by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE HVTM.

The hot moisture-laden air displaced from the surface of each printed or coated sheet is extracted from the dryer exposure zone Z and exhausted from the printing unit by the high volume extractors 124, 126 and 128. Each extractor head includes an extractor manifold 124E, 126E and 128E coupled to the dryer heads 124D, 126D and 128D and draws the moisture, volatiles, odors and hot air through a longitudinal air gap G between the dryer heads. Best results are obtained when extraction is performed simultaneously with drying. Preferably, an extractor is closely coupled to the exposure zone Z at each dryer location as shown in FIG. 4. Extractor heads 124E, 126E and 128E are mounted on the dryer heads 124D, 126D and 128D, respectively, with the longitudinal extractor air gap G facing directly into the exposure zone Z. According to this arrangement, each printed or coated sheet is dried before it is printed on the next printing unit.

The aqueous water-based inks used in flexographic printing evaporate at a relatively moderate temperature provided by the interunit high velocity hot air dryers/extractors 124, 126 and 128. Sharpness and print quality are substantially improved since the flexographic ink or coating material is dried before it is overprinted on the next printing unit. Since the freshly printed flexographic ink is dry, dot gain is substantially reduced and back-trapping on the blanket of the next printing unit is virtually eliminated. This interunit drying/extracting arrangement makes it possible to print flexographic inks such as metallic ink and opaque white ink on the first printing unit, and then dry-trap and overprint on the second and subsequent printing units.

Moreover, this arrangement permits the first printing unit 22 to be used as a coater in which a flexographic, aqueous or UV-curable coating material is applied to the lowest grade substrate such as recycled paper, cardboard, plastic and the like, to trap and seal-in lint, dust, spray powder and other debris and provide a smoother, more durable printing surface which can be overprinted on the next printing unit.

A first down (primer) aqueous coating layer seals—in the surface of a low grade, rough substrate, for example, re-cycled paper or plastic, and improves overprinted dot definition and provides better ink lay-down while preventing strike-through and show-through. A flexographic UV-curable coating material can then be applied downstream over the primer coating, thus producing higher coating gloss.

Preferably, the applicator roller 66 is constructed of composite carbon fiber material, metal or ceramic coated metal when it is used for applying ink or coating material to the blanket B or other resilient material on the blanket cylinder 34. When the applicator roller 66 is applied to the plate, it is preferably constructed as an anilox roller having a resilient, compressible transfer surface. Suitable resilient roller surface materials include Buna N synthetic rubber and EPDM (terpolymer elastomer).

It has been demonstrated in prototype testing that the inking/coating apparatus 10 can apply a wide range of ink

and coating types, including fluorescent (Day Glo), pearlescent, metallics (gold, silver and other metals), glitter, scratch and sniff (micro-encapsulated fragrance), scratch and reveal, luminous, pressure-sensitive adhesives and the like, as well as UV-curable and aqueous coatings.

With the dampener assembly removed from the printing unit, the inking/coating apparatus 10 can easily be installed in the dampener space for selectively applying flexographic inks and/or coatings to a flexographic or waterless printing plate or to the blanket. Moreover, overprinting of the flexographic inks and coatings can be performed on the next printing unit since the flexographic inks and/or coatings are dried by the high velocity, hot air interunit dryer and high volume heat and moisture extractor assembly of the present invention.

The flexographic inks and coatings as used in the present invention contain colored pigments and/or soluble dyes, binders which fix the pigments onto the surface of the substrate, waxes, defoamers, thickeners and solvents. Aqueous printing inks predominantly contain water as a diluent and/or vehicle. The thickeners which are preferred include alginates, starch, cellulose and its derivatives, for example cellulose esters or cellulose ethers and the like. Coloring agents including organic as well as inorganic pigments may be derived from dyes which are insoluble in water and solvents. Suitable binders include acrylates and/or polyvinylchloride.

When metallic inks are printed, the cells of the anilox roller must be appropriately sized to prevent the metal particles from getting stuck within the cells. For example, for metallic gold ink, the anilox roller should have a screen line count in the range of 175-300 lines per inch (68-118 lines per cm). Preferably, in order to keep the anilox roller cells clear, the doctor blade assembly 68 is equipped with a bristle brush BR (FIG. 14) as set forth in U.S. Pat. No. 5,425,809 to Steven M. Person, assigned to Howard W. DeMoore, and licensed to Printing Research, Inc. of Dallas, Tex., U.S.A., which is incorporated herein by reference.

The inking/coating apparatus 10 can also apply UV-curable inks and coatings. If UV-curable inks and coatings are utilized, ultra-violet dryers/extractors are installed adjacent to the high velocity hot air dryer/extractor units 124, 126 and 128, respectively.

It will be appreciated that the LITHOFLEX™ printing process described herein makes it possible to selectively operate a printing unit of a press in the lithographic printing mode while simultaneously operating another printing unit of the same press in either the flexographic printing mode or in the waterless printing mode, while also providing the capability to print or coat, separately or simultaneously, from either the plate position or the blanket position. The dual cradle support arrangement of the present invention makes it possible to quickly change over from inking/coating on the blanket cylinder position to inking/coating on the plate cylinder position with minimum press down-time, since it is only necessary to remove and reposition or replace the applicator roller 66 while the inking/coating apparatus 10 is in the retracted position. It is only necessary to remove four cap screws, lift the applicator roller 66 from the cradle, and reposition it in the other cradle. All of this can be accomplished in a few minutes, without removing the inking/coating apparatus 10 from the press.

It is possible to spot coat or overall coat from the plate position or from the blanket position with flexographic inks or coatings on one printing unit and then spot coat or overall coat with UV-curable inks or coatings from the plate posi-

tion or from the blanket position on another printing unit during the same press run. Moreover, the press operator can spot or overall coat from the plate for one job, and then spot and/or overall coat from the blanket on the next job.

The positioning of the applicator roller relative to the plate or blanket is repeatable to a predetermined preset operative position. Consequently, only minor printing unit modifications or alterations may be required for the LITHOFLEX™ process. Although automatic extension and retraction have been described in connection with the exemplary embodiment, extension to the operative (on-impression) position and retraction to a non-operative (off-impression) position can be carried out manually, if desired. In the manual embodiment, it is necessary to latch the inking/coating apparatus 10 to the press side frames 14, 15 in the operative (on-impression) position, and to mechanically prop the inking/coating apparatus in the off-impression (retracted) position.

Referring again to FIG. 8, an applicator roller 66 is mounted on the lower cradle assembly 100 by side support members 78, 80, and a second applicator roller 67 is mounted on the upper cradle assembly 102 by side support members 82, 84. According to this arrangement, the inking/coating apparatus 10 can apply printing ink and/or coating material to a plate on the plate cylinder, while simultaneously applying printing ink and/or coating material to a plate or a blanket on the blanket cylinder of the same printing unit. When the same color ink is used by the upper and lower applicator rollers from the plate position and from the blanket position simultaneously on the same printing unit, a "double bump" or double inking films or coating layers are applied to the substrate S during a single pass of the substrate through the printing unit. The tack of the two inks or coating materials must be compatible for good transfer during the double bump. Moreover, the inking/coating apparatus 10 can be used for supplying ink or coating material to the blanket cylinder of a rotary offset web press, or to the blanket of a dedicated coating unit.

According to conventional bronzing techniques, a metallic (bronze) powder is applied off-line to previously printed substrate which produces a grainy, textured finish or appearance. The on-line application of bronze material by conventional flexographic or lithographic printing will only produce a smooth, continuous appearance. However, a grainy, textured finish is preferred for highest quality printing which, prior to the present invention, could only be produced by off-line methods.

Referring now to FIG. 14 and FIG. 15, metallic ink or coating material is applied on-line to the substrate S by simultaneous operation of the upper and lower applicator rollers 67R, 66 to produce an uneven surface finish having a bronze-like textured or grainy appearance. According to the simulated bronzing method of the present invention, the flexographic bronze ink is applied simultaneously to the plate and to the blanket by the dual cradle inking/coating apparatus 10 as shown in FIG. 14. A resilient applicator roller 67R is mounted in the upper cradle 102, and an anilox applicator roller 66 is mounted on the lower cradle 100. The rollers are supplied from separate doctor blade reservoirs 70. The doctor blade reservoir 70 in the upper cradle position supplies bronze ink or coating material having relatively coarse, metallic particles 140 dispersed in aqueous or flexographic ink. The coarse particle ink or coating material is applied to the plate P by the resilient applicator roller 67R in the upper cradle position 102. At the same time, flexographic and/or bronze ink or coating material having relatively fine, metallic particles 142 is transferred to the blanket B by the anilox roller 66 which is mounted on the lower cradle 100.

The metering surfaces of the upper and lower applicator rollers have different cell sizes and volumetric capacities which accommodate the coarse and fine metallic particles. For example, the anilox roller 111 mounted in the upper cradle position 102 which transfers the coarse metallic particles 140 preferably has a screen line count in the range of 100-300 lines per inch (39-118 lines per cm), and the metering surface of the anilox roller 66 mounted on the lower cradle 100 which transfers the relatively fine metallic particles 142 preferably has a screen line count in the range of 200-600 lines per inch (79-236 lines per cm).

After transfer from the plate to the blanket, the fine metallic particles 142 form a layer over the coarse metallic particles 140. As both bronze layers are offset onto the substrate S, the layer of fine metallic particles 142 is printed onto the substrate S with the top layer of coarse metallic particles 140 providing a textured, grainy appearance. The fine metallic particles 142 cover the substrate which would otherwise be visible in the gaps between the coarse metallic particles 140. The combination of the coarse particle layer over the fine particle layer thus provides a textured, bronzed-like finish and appearance.

Particulate materials other than metal can be used for producing a textured finish. For example, coarse and fine particles of metallized plastic (glitter), mica particles (pearlescent) and the like, can be substituted for the metallic particles for producing unlimited surface variations, appearances and effects. All of the particulate material, including the metallic particles, are preferably in solid, flat platelet form, and have a size dimension suitable for application by an anilox applicator roller. Other particulate or granular material, for example stone grit having irregular form and size, can be used to good advantage.

Solid metal particles in platelet form, which are good reflectors of light, are preferred for producing the bronzed-like appearance and effect. However, various textured finishes, which could have light-reflective properties, can be produced by using granular materials such as stone grit. Most commonly used metals include copper, zinc and aluminum. Other ductile metals can be used, if desired. Moreover, the coarse and fine particles need not be made of the same particulate material. Various effects and textured appearances can be produced by utilizing diverse particulate materials for the coarse particles and the fine particles, respectively. Further, either fine or coarse particle ink or coating material can be printed from the upper cradle position, and either fine or coarse particle ink or coating material can be printed from the lower cradle position, depending on the special or surface finish that is desired.

It will be appreciated that the last printing unit 28 can be configured for additional inking/coating capabilities which include lithographic, waterless, aqueous and flexographic processes. Various substrate surface effects (for example double bump or triple bump inking/coating or bronzing) can be performed on the last printing unit. For triple bump inking/coating, the last printing unit 28 is equipped with an auxiliary in-line inking or coating apparatus 97 as shown in FIG. 3 and FIG. 4. The in-line inking or coating apparatus 97 allows the application of yet another film of ink or a protective or decorative layer of coating material over any freshly printed or coated surface effects or special treatments, thereby producing a triple bump. The triple bump is achieved by applying a third film of ink or layer of coating material over the freshly printed or coated double bump simultaneously while the substrate is on the impression cylinder of the last printing unit.

When the in-line inking/coating apparatus 97 is installed, it is necessary to remove the SUPER BLUE® flexible

covering from the delivery cylinder 42, and it is also necessary to modify or convert the delivery cylinder 42 for inking/coating service by mounting a plate or blanket B on the delivery cylinder 42, as shown in FIG. 3 and FIG. 4. Packing material is placed under the plate or blanket B, thereby packing the plate or blanket B at the correct packed-to-print radial clearance so that ink or coating material will be printed or coated onto the freshly printed substrate S as it transfers through the nip between the plate or blanket B on the converted delivery cylinder 42 and the last impression cylinder 36. According to this arrangement, a freshly printed or coated substrate is overprinted or overcoated with a third film or layer of ink or coating material simultaneously while a second film or layer of ink or coating material is being over-printed or over-coated on the last impression cylinder 36.

The auxiliary inking/coating apparatus 97 and the converted or modified delivery cylinder 42 are mounted on the delivery drive shaft 43. The inking/coating apparatus 97 includes an applicator roller, preferably an anilox applicator roller 97A, for supplying ink or coating material to a plate or blanket B on the modified or converted delivery cylinder 42. The in-line inking/coating apparatus 97 and the modified or converted delivery cylinder 42 are preferably constructed as described in U.S. Pat. No. 5,176,077 to Howard W. DeMoore (co-inventor and assignee), which is hereby incorporated by reference. The in-line inking/coating apparatus 97 is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE EZ COATER™.

After the delivery cylinder 42 has been modified or converted for inking/coating service, and because of the reduced nip clearance imposed by the plate or blanket B, the modified delivery cylinder 42 can no longer perform its original function of guiding and transferring the freshly printed or coated substrate. Instead, the modified or converted delivery cylinder 42 functions as a part of the inking/coating apparatus 97 by printing or coating a third down film of ink or layer of coating material onto the freshly printed or coated substrate as it is simultaneously printed or coated on the last impression cylinder 36. Moreover, the mutual tack between the second down ink film or coating layer and the third down ink film or coating layer causes the overprinted or overcoated substrate to cling to the plate or blanket, thus opposing or resisting separation of the substrate from the plate or blanket.

To remedy this problem, a vacuum-assisted transfer apparatus 99 is mounted adjacent the modified or converted delivery cylinder 42 as shown in FIG. 3 and FIG. 4. Another purpose of the vacuum-assisted transfer apparatus 99 is to separate the freshly overprinted or overcoated triple bump substrate from the plate or blanket B as the substrate transfers through the nip. The vacuum-assisted transfer apparatus 99 produces a pressure differential across the freshly overprinted or overcoated substrate as it transfers through the nip, thus producing a separation force onto the substrate and providing a clean separation from the plate or blanket B.

The vacuum-assisted transfer apparatus 99 is preferably constructed as described in U.S. Pat. Nos. 5,113,255; 5,127,329; 5,205,217; 5,228,391; 5,243,909; and 5,419,254, all to Howard W. DeMoore, co-inventor, which are incorporated herein by reference. The vacuum-assisted transfer apparatus 99 is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A. under its trademark BACVAC®.

Although the present invention and its advantages have been described in detail, it should be understood that various

changes, substitutions and alterations can be made herein without departing from the spirit and scope of the present invention as defined by the appended claims.

What is claimed is:

1. A method for printing in a rotary offset press of the type including first and second printing units, the first printing unit having a flexographic printing plate, a blanket, an impression cylinder and inking/coating applicator means for applying aqueous or flexographic printing ink or coating material to the flexographic printing plate and/or to the blanket, comprising the following steps performed in succession in the first printing unit:

applying a first spot or overall coating of aqueous or flexographic printing ink or coating material to the flexographic printing plate;

transferring the aqueous or flexographic printing ink or coating material from the flexographic printing plate to the blanket;

applying a second spot or overall film of aqueous or flexographic printing ink or layer of coating material to the blanket;

transferring ink or coating material from the blanket to a substrate as the substrate is transferred through the nip between the blanket and the impression cylinder; and, drying the aqueous or flexographic ink or coating material on the freshly printed or coated substrate before the substrate is printed, coated or otherwise processed on the second printing unit.

2. The printing method as defined in claim 1, including the steps:

applying a primer coating of an aqueous or flexographic ink or coating material to a substrate in the first printing unit;

trapping and sealing particulate material such as dust, lint, anti-offset spray powder and the like under the primer coating;

drying the primer coating on the substrate before the substrate is printed or coated on the second printing unit; and,

overprinting the freshly coated substrate in the second printing unit.

3. The printing method as defined in claim 1,

wherein the drying step is performed by directing heated air onto the freshly printed or coated substrate while the freshly printed or coated substrate is in contact with the impression cylinder of the first printing unit.

4. The printing method as defined in claim 1, including the steps:

transferring the freshly printed or coated substrate to an intermediate transfer cylinder disposed between the first and second printing units; and,

drying the freshly printed or coated substrate while said substrate is in contact with the intermediate transfer cylinder.

5. The printing method as defined in claim 1, wherein: the drying step is performed by directing heated air onto the freshly printed or coated substrate while the freshly printed or coated substrate is in contact with an impression cylinder in the second printing unit.

6. The printing method as defined in claim 1, wherein the drying step is performed by directing heated air from a dryer onto the freshly printed or coated substrate, and including the step:

extracting hot air, moisture and volatiles from an exposure zone between the freshly printed or coated substrate

and the dryer while the freshly printed or coated substrate is in contact with the impression cylinder of the first printing unit.

7. The printing method as defined in claim 1, including the steps:

transferring the freshly printed or coated substrate to an intermediate transfer cylinder disposed between the first and second printing units;

directing heated air from a dryer onto the freshly printed or coated substrate while said substrate is in contact with the intermediate transfer cylinder; and,

extracting hot air, moisture and volatiles from an exposure zone between the freshly printed or coated substrate and said dryer while said freshly printed or coated substrate is in contact with the intermediate transfer cylinder.

8. The printing method as defined in claim 1, including the steps:

transferring the freshly printed or coated substrate to an impression cylinder on the second printing unit;

directing heated air from a dryer onto the freshly printed or coated substrate while said substrate is in contact with the impression cylinder of the second printing unit; and,

extracting hot air, moisture and volatiles from an exposure zone between the freshly printed or coated substrate and said dryer while said substrate is in contact with the impression cylinder of the second printing unit.

9. A method for providing an uneven printed or coated layer on a substrate in a rotary offset printing press of the type including a printing unit having a plate cylinder, a flexographic printing plate mounted on the plate cylinder, a blanket cylinder, a plate or blanket mounted on the blanket cylinder, an impression cylinder and applicator means for applying aqueous or flexographic printing ink or coating material to the flexographic printing plate and/or to the plate or blanket on the blanket cylinder, comprising the following steps performed in succession in the printing unit:

applying a first down layer of aqueous or flexographic ink or coating material containing relatively coarse particles to the flexographic plate;

transferring the relatively coarse particle printing ink or coating material from the flexographic printing plate to the plate or blanket on the blanket cylinder;

applying a second down layer of aqueous or flexographic printing ink or coating material containing relatively fine particles onto the relatively coarse particle printing ink or coating material;

transferring the coarse and fine particle ink or coating material from the blanket or plate on the blanket cylinder onto a substrate as the substrate is transferred through the nip between the blanket cylinder and the impression cylinder; and,

drying the freshly printed or coated substrate before the freshly printed or coated substrate is subsequently printed, coated or otherwise processed.

10. The method as set forth in claim 9, wherein the coarse and fine particles comprise a metal selected from the group including copper, zinc and aluminum.

11. The method as set forth in claim 9, wherein the coarse and fine particles comprise a non-metallic material selected from the group consisting of mica, silicon, stone grit and plastic.

12. The method as set forth in claim 9, wherein the coarse and fine particles comprise diverse particulate materials, respectively.

13. A method for printing or coating a substrate on the last printing unit of a rotary offset printing press of the type including a plate cylinder, a printing plate mounted on the plate cylinder, a blanket cylinder, a plate or blanket mounted on the blanket cylinder, an impression cylinder, inking/coating apparatus for applying printing ink or coating material simultaneously or separately to the flexographic printing plate and/or to the plate or blanket on the blanket cylinder, and including an inking/coating cylinder mounted adjacent the last printing unit for printing a film of ink or layer of coating material over a freshly printed substrate, comprising the steps:

applying a first down film of printing ink or layer of coating material to the printing plate;

transferring printing ink or coating material from the printing plate to a plate or blanket on the blanket cylinder;

applying a second down film of printing ink or layer of coating material over the first down film or layer on the plate or blanket on the blanket cylinder;

transferring ink or coating material from the blanket or plate on the blanket cylinder onto a substrate as the substrate is transferred through the nip between the blanket cylinder and the impression cylinder; and

simultaneously printing a third down film of printing ink or layer of coating material over the second down film of ink or layer of coating material while the second down film or layer is being printed or coated on the last impression cylinder.

14. A method for printing or coating a substrate in a rotary offset printing press of the type including a printing unit having a plate cylinder, a flexographic printing plate mounted on the plate cylinder, a blanket cylinder, a plate or blanket mounted on the blanket cylinder, an impression cylinder, and inking/coating apparatus for applying flexographic or aqueous printing ink or coating material to the flexographic printing plate and/or to the plate or blanket on the blanket cylinder, comprising the following steps:

applying a first down film or layer of flexographic or aqueous printing ink or coating material to the flexographic printing plate;

transferring printing ink or coating material from the flexographic printing plate to the plate or blanket on the blanket cylinder;

applying a second down film or layer of aqueous or flexographic printing ink or coating material over the first down film or layer on the plate or blanket on the blanket cylinder;

transferring ink or coating material from the blanket or plate on the blanket cylinder onto a substrate as the substrate is transferred through the nip between the blanket cylinder and the impression cylinder; and,

drying the freshly printed or coated substrate before the substrate is subsequently printed, coated or otherwise processed.

15. A method of printing or coating a substrate in a rotary offset printing press as set forth in claim 14, wherein the printing unit is the last printing unit of the rotary offset printing press and a delivery cylinder is mounted on the last printing unit for transferring the freshly printed substrate along a substrate travel path, including the steps:

modifying the delivery cylinder by mounting a plate or blanket on the delivery cylinder;

transferring ink or coating material to the plate or blanket on the modified delivery cylinder; and

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transferring a third down film or layer of aqueous or flexographic printing ink or coating material from the plate or blanket over the second down film or layer simultaneously while the freshly printed or coated substrate is on the last impression cylinder of the last printing unit.

16. A method for rotary offset printing as defined in any one of claims 1, 9, 13 or 14, including the steps:

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circulating liquid ink or coating material from a supply container to said inking/coating applicator means and from said inking/coating applicator means to the supply container; and,

heating or cooling the liquid ink or coating material as it is circulated.

* * * * *

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US005960713A

United States Patent [19]

DeMoore et al.

[11] Patent Number: 5,960,713

[45] Date of Patent: Oct. 5, 1999

[54] RETRACTABLE PRINTING-COATING UNIT OPERABLE ON THE PLATE AND BLANKET CYLINDERS SIMULTANEOUSLY FROM THE DAMPENER SIDE OF THE FIRST PRINTING UNIT OR ANY CONSECUTIVE PRINTING UNIT OR ANY ROTARY OFFSET PRINTING PRESS

[75] Inventors: Howard W. DeMoore, 10954 Shady Trail, Dallas, Tex. 75220; Ronald M. Rendlemaun, Dallas, Tex.; John W. Bird, Carrollton, Tex.

[73] Assignee: Howard W. DeMoore, Dallas, Tex.

[21] Appl. No.: 09/136,901

[22] Filed: Aug. 19, 1998

Related U.S. Application Data

[63] Continuation-in-part of application No. 08/538,422, Oct. 2, 1995, abandoned, which is a continuation-in-part of application No. 08/435,798, May 4, 1995.

[51] Int. Cl.⁶ B41F 7/06; B41F 5/02; B41F 5/22

[52] U.S. Cl. 101/137; 101/177

[58] Field of Search 101/136, 137, 101/142, 143, 144, 145, 177, 183, 207-210, 216, 217, 218, 349.1, 350.1, 350.2, 351.3, 352.01, 352.02, 352.04, 352.05, 363

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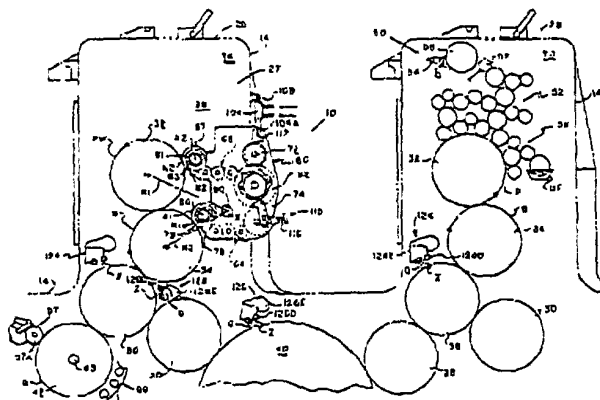
Primary Examiner—J. Reed Fisher

Attorney, Agent, or Firm—Locke Liddell & Sapp LLP

[57] ABSTRACT

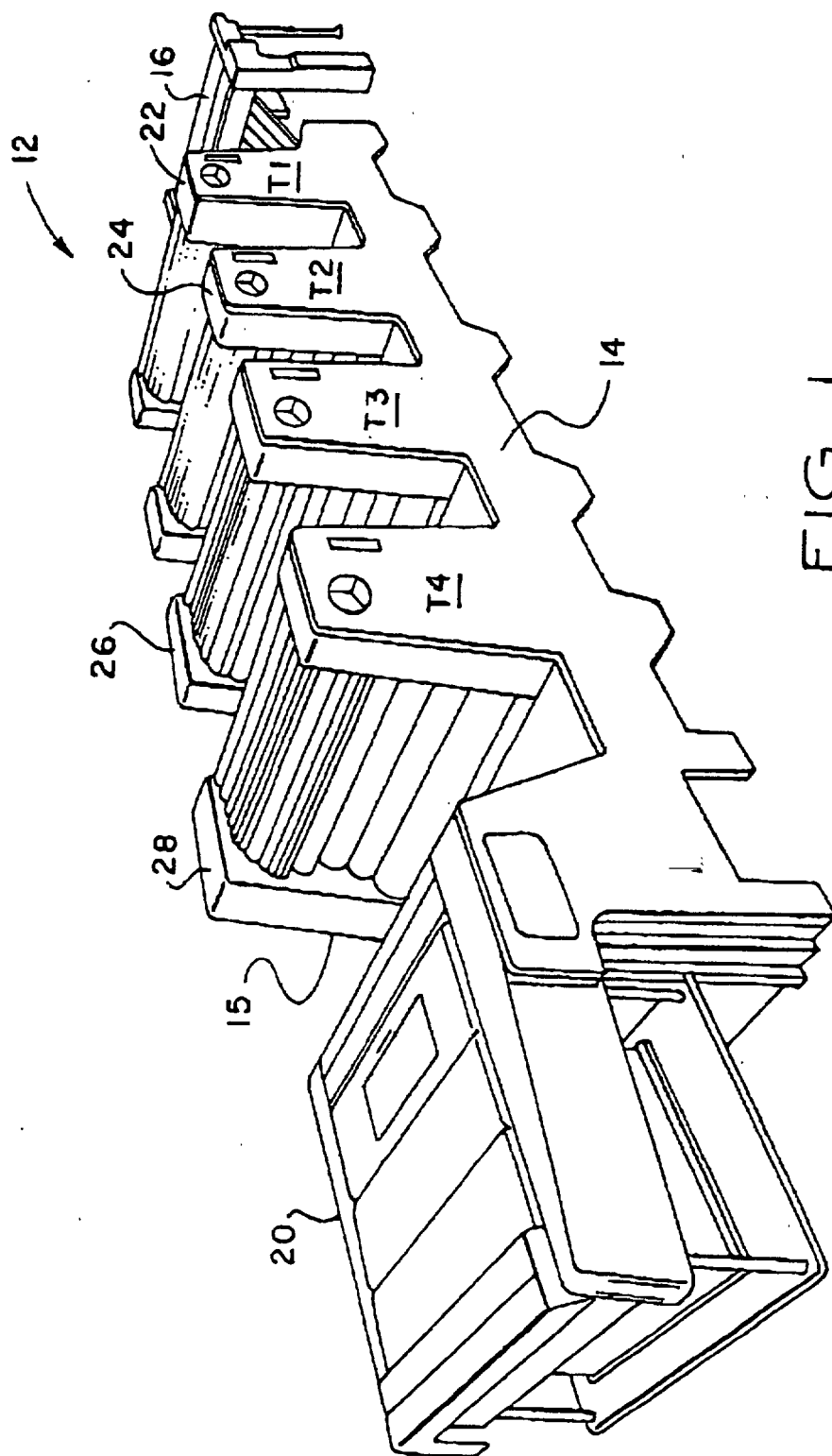
A retractable in-line inking/coating apparatus can apply either spot or overall inking/coating material to a plate and/or a blanket on the first printing unit or on any consecutive printing unit of any rotary offset printing press. The inking/coating apparatus is pivotally mounted within the conventional dampener space of any lithographic printing unit. The aqueous component of the flexographic printing ink or aqueous coating material is evaporated and dried by high velocity, hot air dryers and high performance heat and moisture extractors so that the aqueous or flexographic ink or coating material on a freshly printed or coated sheet is dry and can be dry-trapped on the next printing unit. The inking/coating apparatus includes dual cradles that support first and second applicator rollers so that the inking/coating apparatus can apply a double bump of aqueous/flexographic or UV-curable printing ink or coating material to a plate on the plate cylinder, while simultaneously applying aqueous, flexographic or UV-curable printing ink or coating material to a plate or a blanket on the blanket cylinder, and thereafter onto a sheet as the sheet is transferred through the nip between the blanket cylinder and the impression cylinder. A triple bump is printed or coated on the last printing unit with the aid of an impression cylinder inking/coating unit.

26 Claims, 15 Drawing Sheets



1990		1991		1992		1993		1994		1995		1996		1997		1998		1999		2000		2001		2002		2003		2004		2005		2006		2007		2008		2009		2010		2011		2012		2013		2014		2015		2016		2017		2018		2019		2020		2021		2022		2023		2024		2025		2026		2027		2028		2029		2030		2031		2032		2033		2034		2035		2036		2037		2038		2039		2040		2041		2042		2043		2044		2045		2046		2047		2048		2049		2050		2051		2052		2053		2054		2055		2056		2057		2058		2059		2060		2061		2062		2063		2064		2065		2066		2067		2068		2069		2070		2071		2072		2073		2074		2075		2076		2077		2078		2079		2080		2081		2082		2083		2084		2085		2086		2087		2088		2089		2090		2091		2092		2093		2094		2095		2096		2097		2098		2099		2100	
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100																																																																																																																										

FIG. 1



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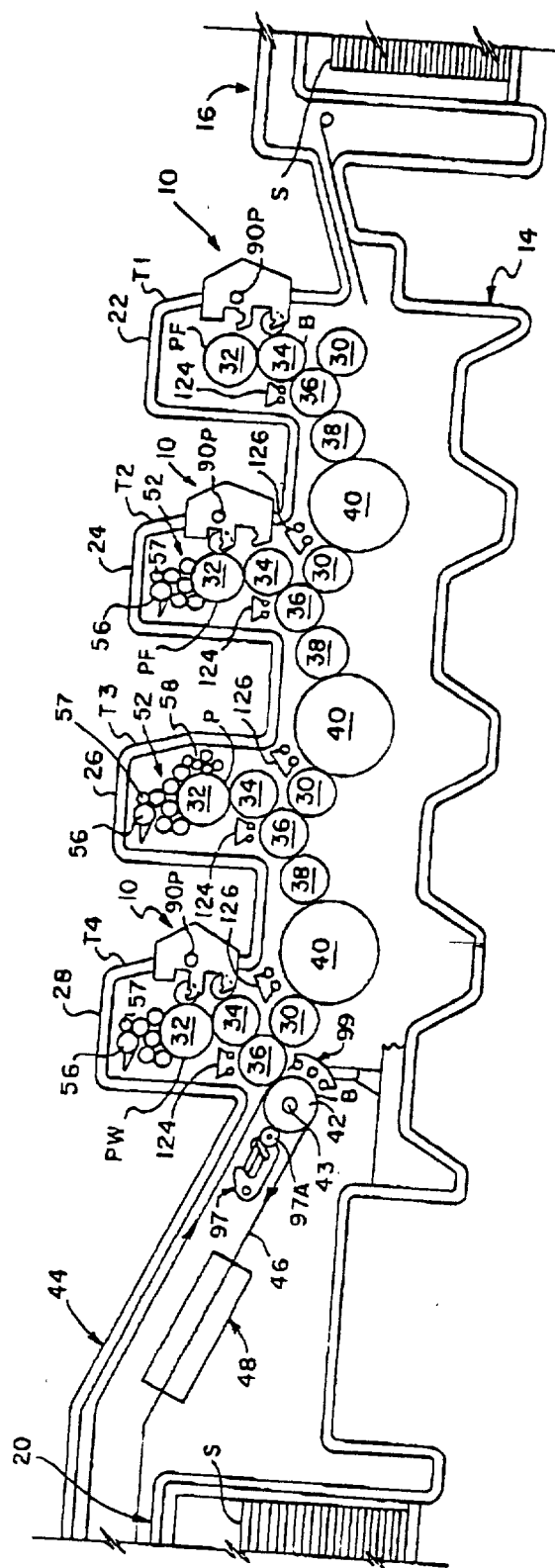


FIG. 3

FIG. 4

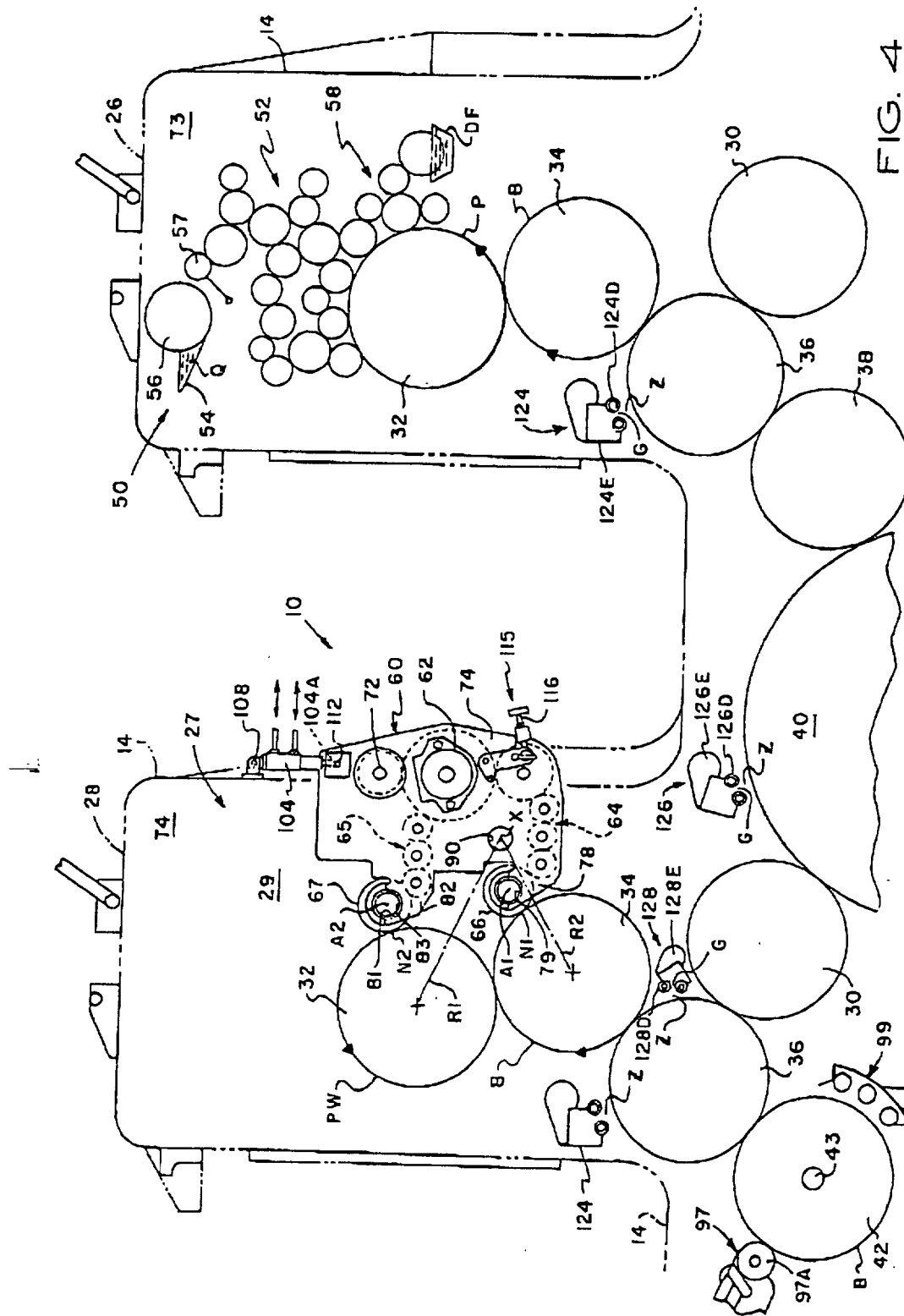


FIG. 5

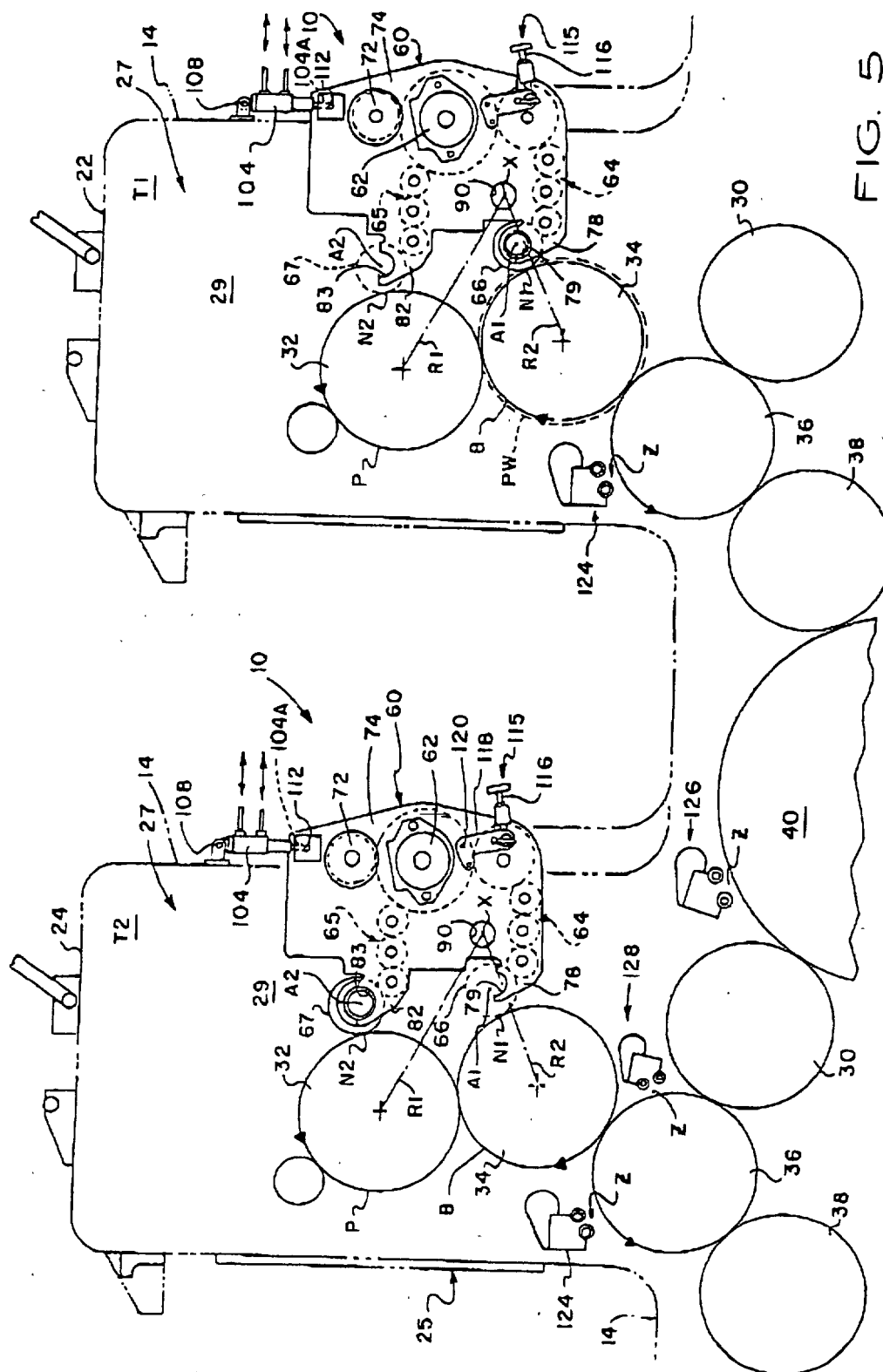


FIG. 5

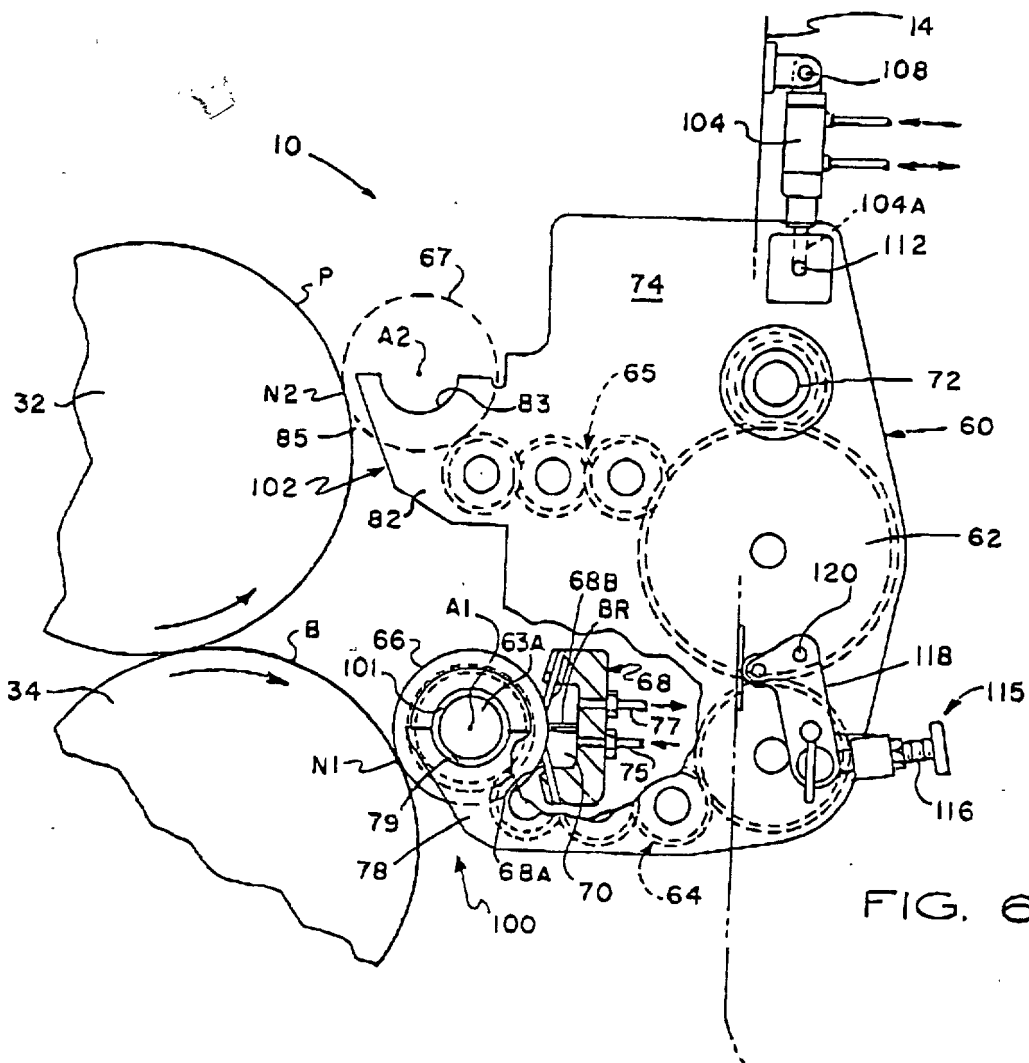


FIG. 6

FIG. 7

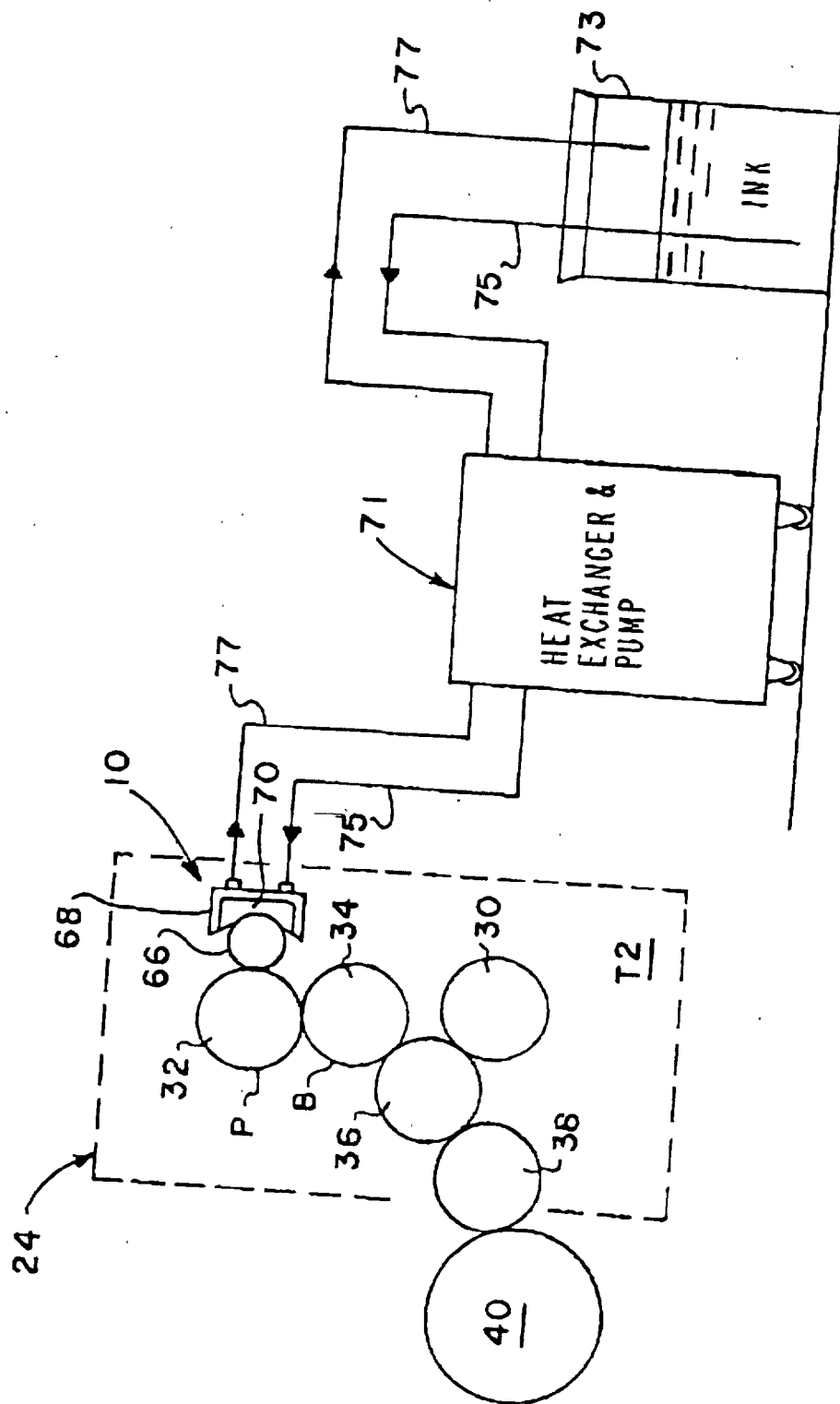


FIG. 7

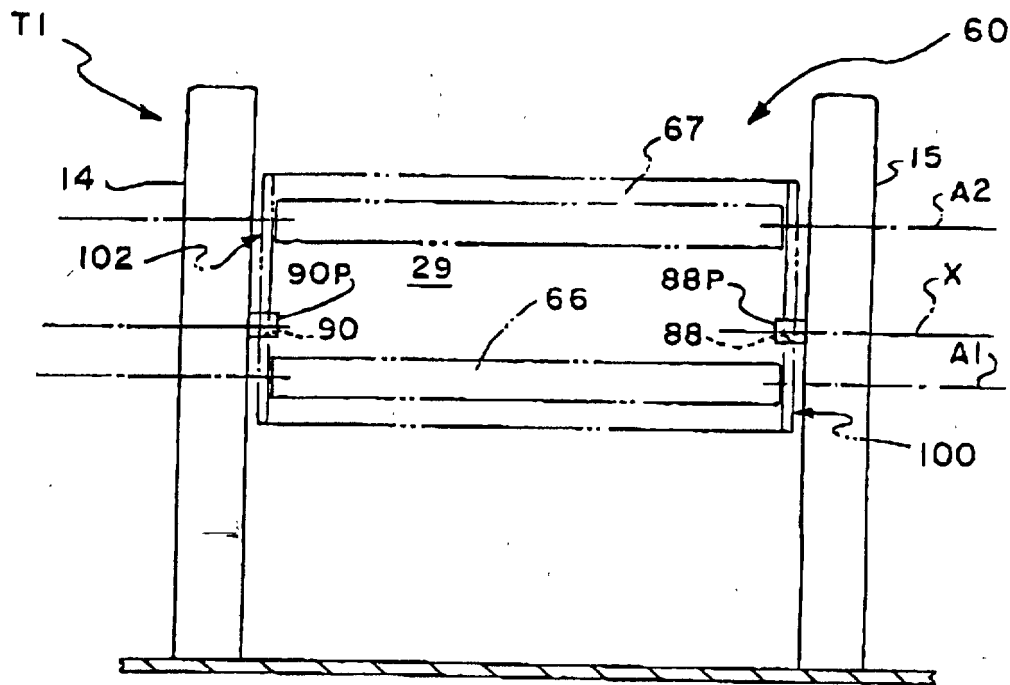
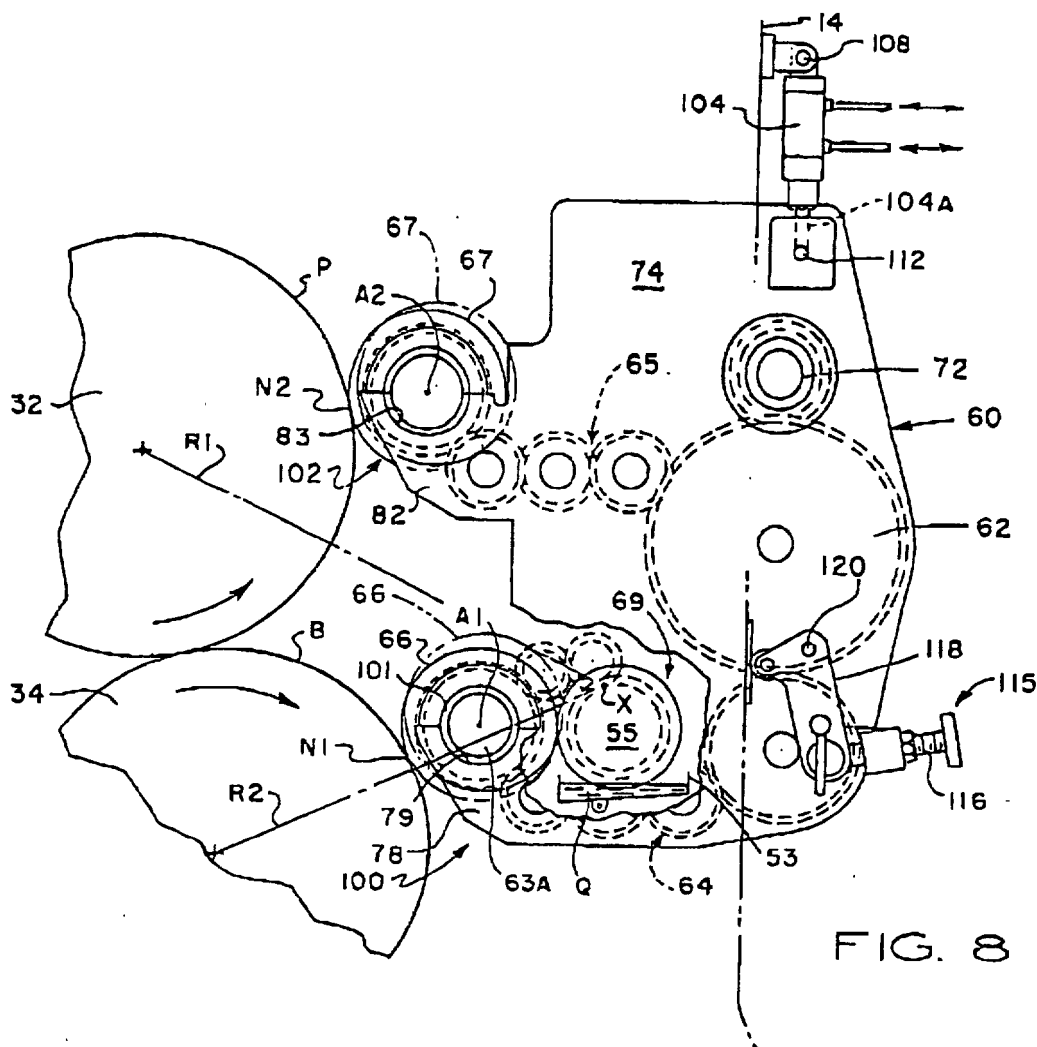


FIG. 9



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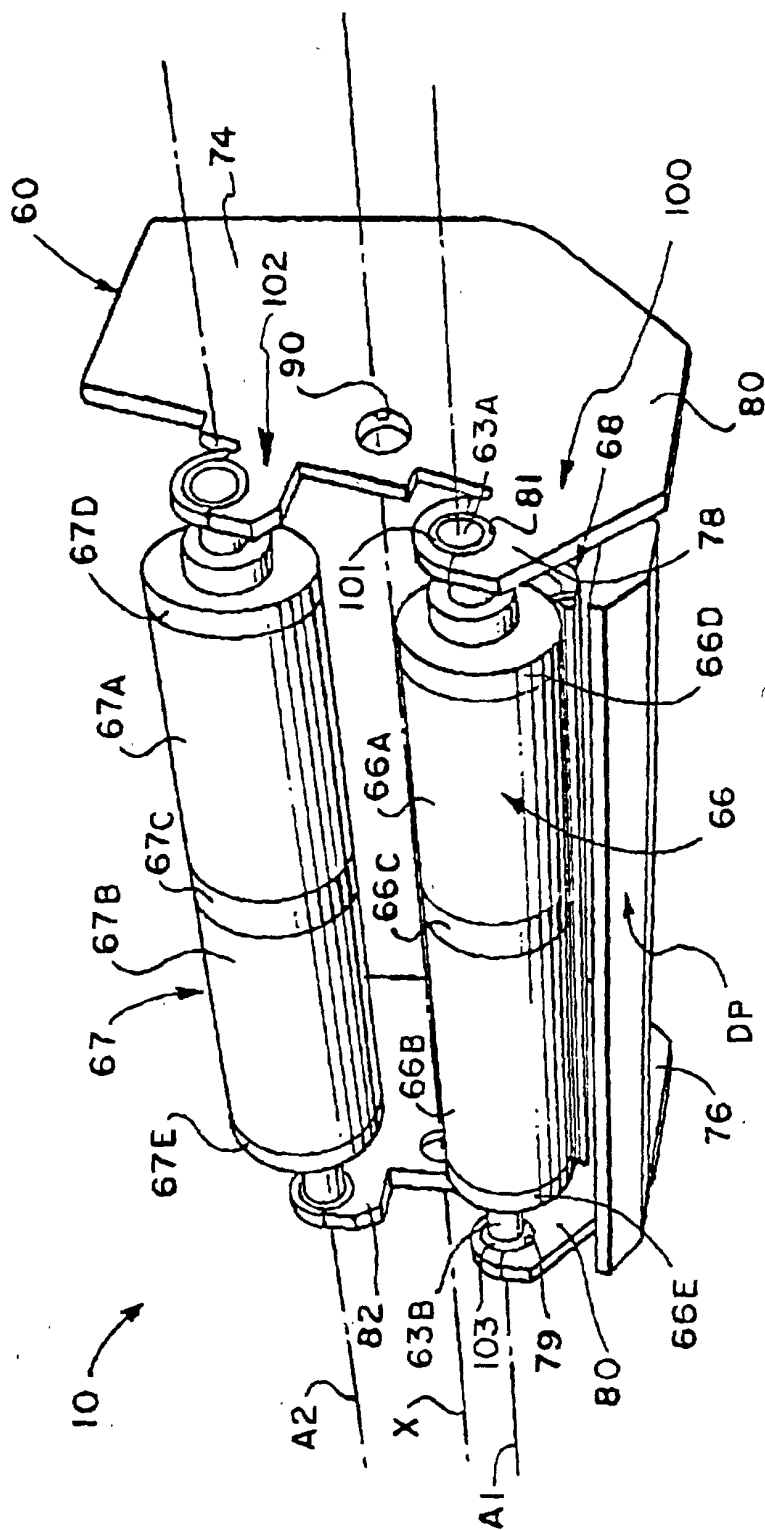


FIG. 10

FIG. 11

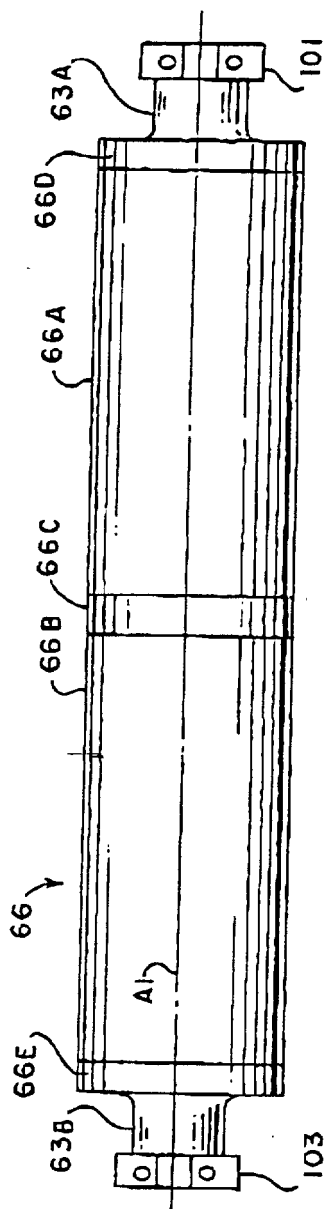


FIG. 11

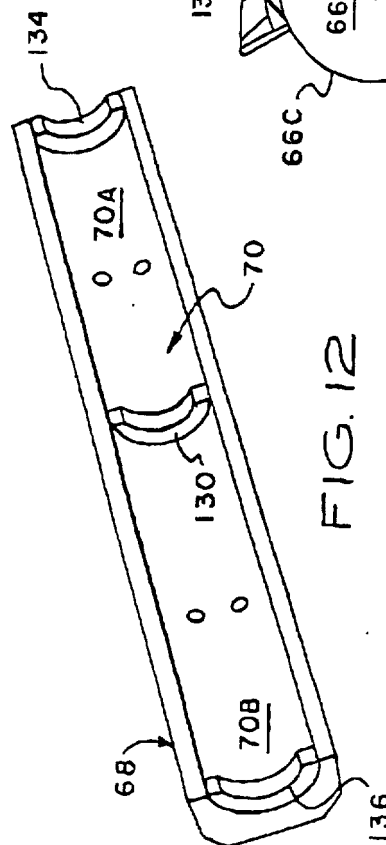


FIG. 12

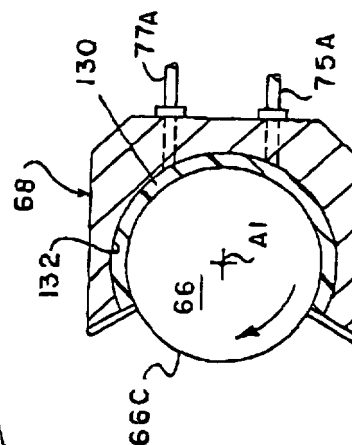


FIG. 13

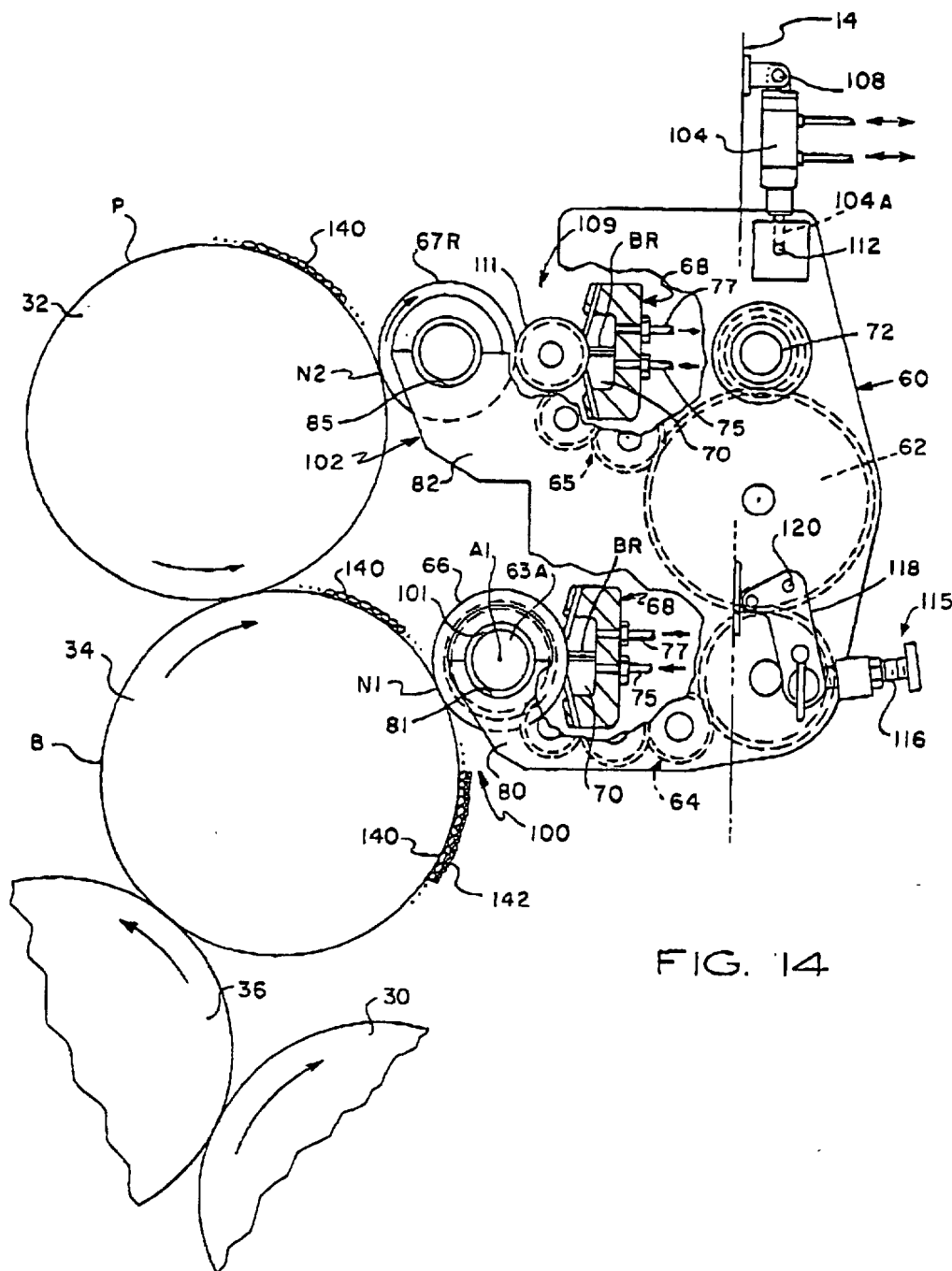


FIG. 14

[illegible]

FIG. 15

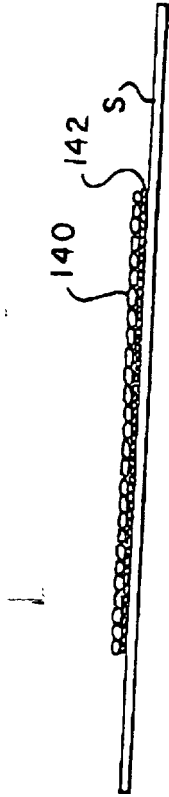


FIG. 15

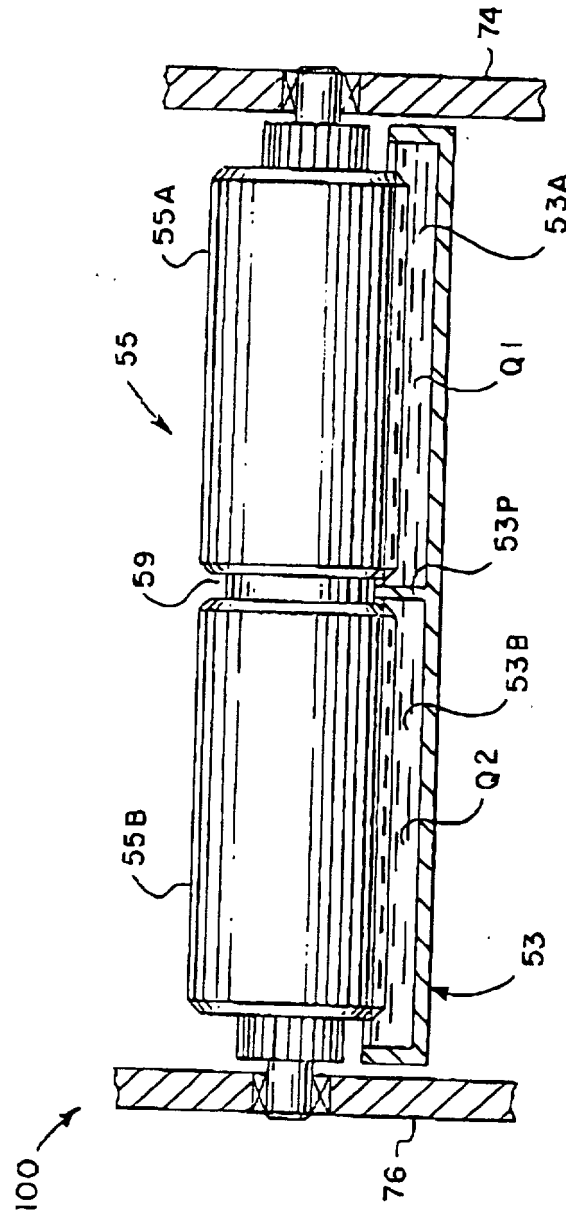
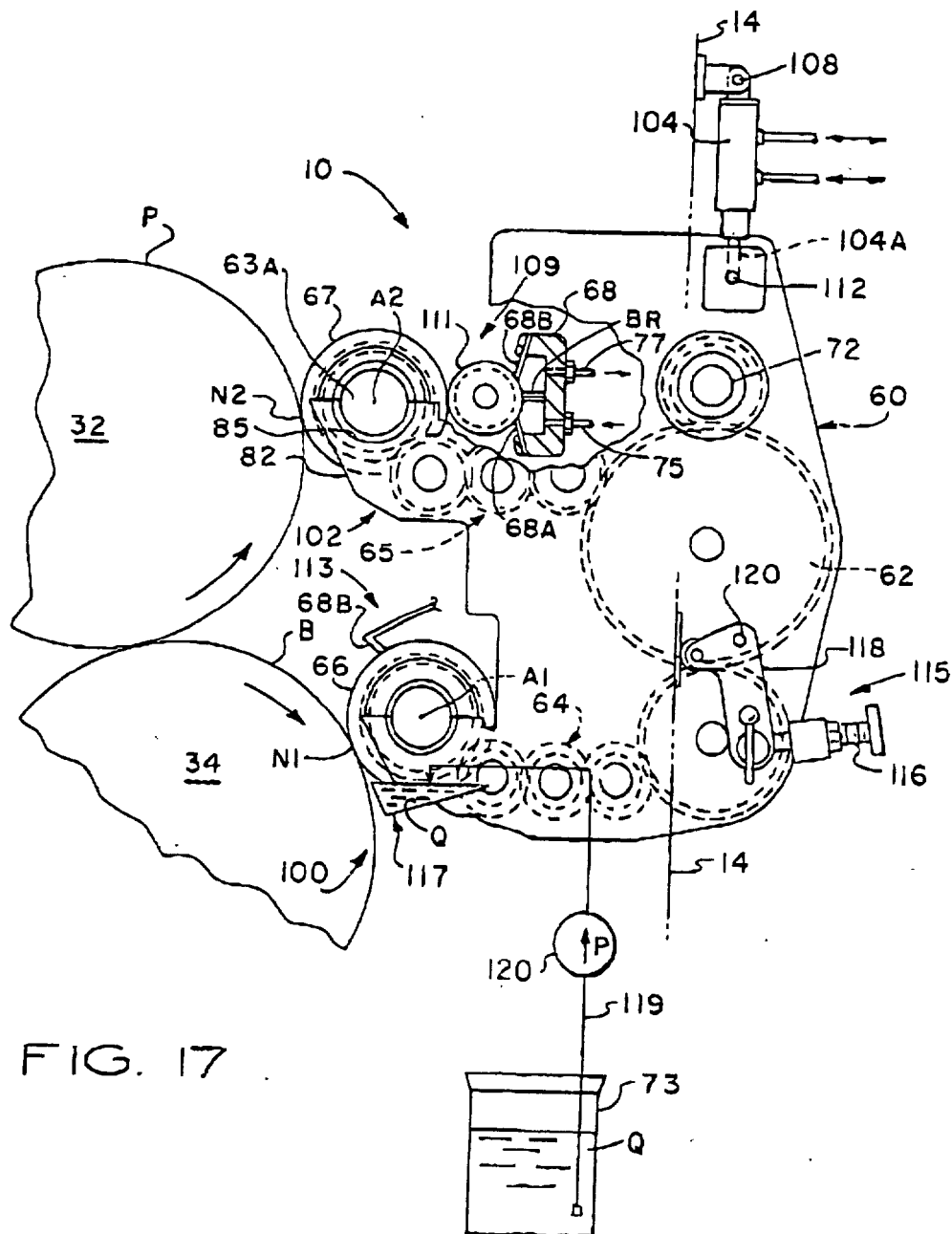


FIG. 16



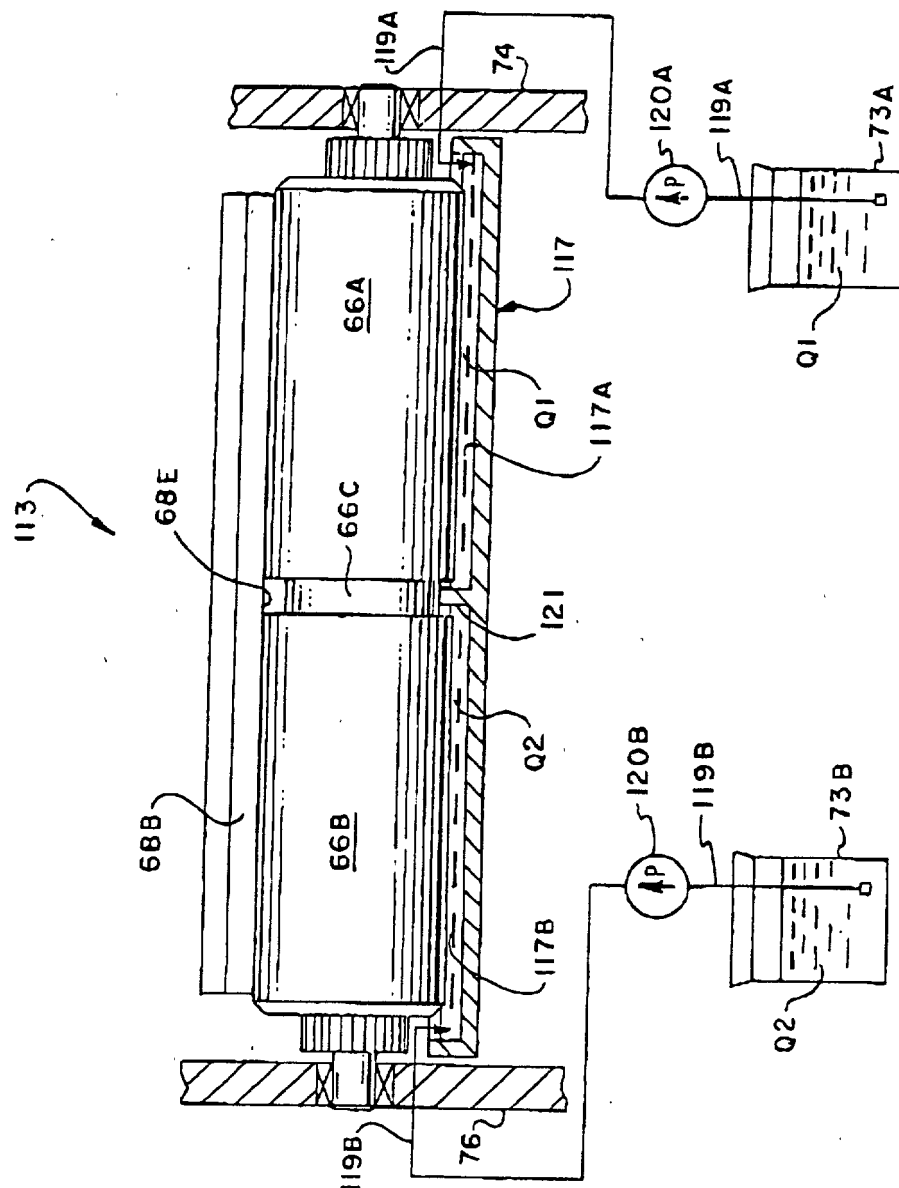


FIG. 18

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**RETRACTABLE PRINTING-COATING UNIT
OPERABLE ON THE PLATE AND BLANKET
CYLINDERS SIMULTANEOUSLY FROM THE
DAMPENER SIDE OF THE FIRST PRINTING
UNIT OR ANY CONSECUTIVE PRINTING
UNIT OR ANY ROTARY OFFSET PRINTING
PRESS**

**CROSS REFERENCE TO OTHER
APPLICATIONS**

This application is a continuation-in-part of prior application Ser. No. 08/538,422 filed Oct. 2, 1995, now abandoned by inventors Howard W. DeMoore, Ronald M. Rendleman and John W. Bird which in turn was a continuation-in-part of prior parent application Ser. No. 08/435,798, titled "Retractable Inking/Coating Apparatus Having Ferris Movement Between Printing Units", filed May 4, 1995 by the same inventors for which priority benefit under § 120 is claimed.

FIELD OF THE INVENTION

This invention relates generally to sheet-fed or web-fed, rotary offset lithographic printing presses, and more particularly, to a new and improved inking/coating apparatus for the in-line application of aqueous or flexographic printing inks, primer or protective/decorative coatings applied simultaneously to the plate and blanket of the first or any consecutive printing unit of any lithographic printing press.

BACKGROUND OF THE INVENTION

Conventional sheet-fed, rotary offset printing presses typically include one or more printing units through which individual sheets are fed and printed. After the last printing unit, freshly printed sheets are transferred by a delivery conveyor to the delivery end of the press where the freshly printed and/or coated sheets are collected and stacked uniformly. In a typical sheet-fed, rotary offset printing press such as the Heidelberg Speedmaster line of presses, the delivery conveyor includes a pair of endless chains carrying gripper bars with gripper fingers which grip and pull freshly printed sheets from the last impression cylinder and convey the sheets to the sheet delivery stacker.

Since the inks used with sheet fed rotary offset printing presses are typically wet and tacky, special precautions must be taken to prevent marking and smearing of the freshly printed or coated sheets as the sheets are transferred from one printing unit to another. The printed ink on the surface of the sheet dries relatively slowly and is easily smeared during subsequent transfer between printing units. Marking, smearing and smudging can be prevented by a vacuum assisted sheet transfer apparatus as described in the following U.S. Pat. Nos. 5,113,255; 5,127,329; 5,205,217; 5,228,391; 5,243,909; and 5,419,254, all to Howard W. DeMoore, co-inventor, and manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A. under its trademark BACVAC™.

In some printing jobs, offsetting is prevented by applying a protective and/or decorative coating material over all or a portion of the freshly printed sheets. Some coatings are formed of a UV-curable or water-dispersed resin applied as a liquid solution over the freshly printed sheets to protect the ink from offsetting or set-off and improve the appearance of the freshly printed sheets. Such coatings are particularly desirable when decorative or protective finishes are applied in the printing of posters, record jackets, brochures, magazines, folding cartons and the like.

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DESCRIPTION OF THE PRIOR ART

Various arrangements have been made for applying the coating as an in-line printing operation by using the last printing unit of the press as the coating application unit. For example, U.S. Pat. Nos. 4,270,483; 4,685,414; and 4,779,557 disclose coating apparatus which can be moved into position to permit the blanket cylinder of the last printing unit of a printing press to be used to apply a coating material over the freshly printed sheets. In U.S. Pat. No. 4,841,903 (Bird) there are disclosed coating apparatus which can be selectively moved between the plate cylinder or the blanket cylinder of the last printing unit of the press so the last printing unit can only be used for coating purposes. However, when coating apparatus of these types are being used, the last printing unit cannot be used to print ink to the sheets, but rather can only be used for the coating operation. Thus, while coating with this type of in-line coating apparatus, the printing press loses the capability of printing on the last printing unit as it is converted to a coating unit.

The coater of U.S. Pat. No. 5,107,790 (Slaker et al) is retractable along an inclined rail for extending and retracting a coater head into engagement with a blanket on the blanket cylinder. Because of its size, the rail-retractable coater can only be installed between the last printing unit of the press and the delivery sheet stacker, and cannot be used for interunit coating. The coater of U.S. Pat. No. 4,615,293 (Jahn) provides two separate, independent coatiers located on the dampener side of a converted printing unit for applying lacquer to a plate and to a rubber blanket. Consequently, although a plate and blanket are provided, the coating unit of Jahn's press is restricted to a dedicated coating operation only.

Proposals have been made for overcoming the loss of a printing unit when in-line coating is used, for example as set forth in U.S. Pat. No. 5,176,077 to Howard W. DeMoore (co-inventor and assignee), which discloses a coating apparatus having an applicator roller positioned to apply the coating material to the freshly printed sheet while the sheet is still on the last impression cylinder of the press. This allows the last printing unit to print and coat simultaneously, so that no loss of printing unit capability results.

Some conventional coatiers are rail-mounted and occupy a large amount of press space and reduce access to the press. Elaborate equipment is needed for retracting such coatiers from the operative coating position to the inoperative position, which reduces access to the printing unit.

Accordingly, there is a need for an in-line inking/coating apparatus which does not result in the loss of a printing unit, does not extend the length of the press, and which can print and coat aqueous and flexographic inks and coating materials simultaneously onto the plate and blanket on any lithographic printing unit of any lithographic printing press, including the first printing unit.

OBJECTS OF THE INVENTION

Accordingly, a general object of the present invention is to provide improved inking/coating apparatus which is capable of selectively applying ink or coating material to a plate on a plate cylinder or ink or coating material to a plate or blanket on a blanket cylinder.

A specific object of the present invention is to provide improved inking/coating apparatus of the character described which is extendable into inking/coating engagement with either a plate on a plate cylinder or to a plate or blanket on a blanket cylinder.

A related object of the present invention is to provide improved inking/coating apparatus of the character described which is capable of being mounted on any lithographic printing unit of the press and does not interfere with operator access to the plate cylinder, blanket cylinder, or adjacent printing units.

Another object of the present invention is to provide improved inking/coating apparatus of the character described, which can be moved from an operative inking/coating engagement position adjacent to a plate cylinder or a blanket cylinder to a non-operative, retracted position.

Still another object of the present invention is to provide improved inking/coating apparatus of the character described, which can be used for applying aqueous, flexographic and ultra-violet curable inks and/or coatings in combination with lithographic, flexographic and waterless printing processes on any rotary offset printing press.

A related object of the present invention is to provide improved inking/coating apparatus of the character described which is capable of applying aqueous or flexographic ink or coating material on one printing unit, for example the first printing unit, and drying the ink or coating material before it is printed or coated on the next printing unit so that it can be overprinted or overcoated immediately on the next printing unit with waterless, aqueous, flexographic or lithographic inks or coating materials.

Yet another object of the present invention is to provide improved inking/coating apparatus for use on a multiple color rotary offset printing press that can apply ink or coating material separately and/or simultaneously to the plate and/or blanket of a printing unit of the press from a single operative position, and from a single inking/coating apparatus.

A related object of the present invention is to provide improved inking/coating apparatus of the character described, in which virtually no printing unit adjustment or alteration is required when the inking/coating apparatus is converted from plate to blanket printing or coating and vice versa.

Another object of the present invention is to provide improved inking/coating apparatus that can be operably mounted in the dampener space of any lithographic printing unit for inking/coating engagement with either a plate on a plate cylinder or a plate or blanket on a blanket cylinder, and which does not interfere with operator movement or activities in the interunit space between printing units.

SUMMARY OF THE INVENTION

The foregoing objects are achieved by a retractable, in-line inking/coating apparatus which is mounted on the dampener side of any printing unit of a rotary offset press for movement between an operative (on-impression) inking/coating position and a retracted, disengaged (off-impression) position. The inking/coating apparatus includes an applicator roller which is movable into and out of engagement with a plate on a plate cylinder or a blanket on a blanket cylinder. The inking/coating applicator head is pivotally coupled to a printing unit by pivot pins which are mounted on the press side frames in the traditional dampener space of the printing unit in parallel alignment with the plate cylinder and the blanket cylinder. This dampener space mounting arrangement allows the inking/coating unit to be installed between any adjacent printing units on the press.

In the preferred embodiment, the applicator head includes vertically spaced pairs of cradle members with one cradle pair being adapted for supporting an inking/coating applicator roller in alignment with a plate cylinder, and the other cradle pair supporting an inking/coating applicator roller in alignment with the blanket cylinder, respectively, when the applicator head is in the operative position. Because of the pivotal support provided by the pivot pins, the applicator head can be extended and retracted within the limited space available in the traditional dampener space, without restricting operator access to the printing unit cylinders and without causing a printing unit to lose its printing capability.

When the inking/coating apparatus is used in combination with a flexographic printing plate and aqueous or flexographic ink or coating material, the water component of the aqueous or flexographic ink or coating material on the freshly printed or coated sheet is evaporated and dried by a high velocity, hot air interunit dryer and a high volume heat and moisture extractor assembly so that the freshly printed ink or coating material is dry before the sheet is printed or coated on the next printing unit. This quick drying process permits a base layer or film of ink, for example opaque white or metallic (gold, silver or other metallics) ink to be printed on the first printing unit, and then overprinted on the next printing unit without back-trapping or dot gain.

The construction and operation of the present invention will be understood from the following detailed description taken in conjunction with the accompanying drawings which disclose, by way of example, the principles and advantages of the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of a sheet fed, rotary offset printing press having inking/coating apparatus embodying the present invention;

FIG. 2 is a simplified perspective view of the single head, dual cradle inking/coating apparatus of the present invention;

FIG. 3 is a schematic side elevational view of the printing press of FIG. 1 having single head, dual cradle inking/coating apparatus installed in the traditional dampener position of the first, second and last printing units;

FIG. 4 is a simplified side elevational view showing the single head, dual cradle inking/coating apparatus in the operative inking/coating position for simultaneously printing on the printing plate and blanket on the fourth printing unit;

FIG. 5 is a simplified side elevational view showing the single head, dual cradle inking/coating apparatus in the operative position for spot or overall inking or coating on the blanket of the first printing unit, and showing the dual cradle inking/coating apparatus in the operative position for spot or overall inking or coating on the printing plate of the second printing unit;

FIG. 6 is a simplified side elevational view of the single head, dual cradle inking/coating apparatus of FIG. 4 and FIG. 5, partially broken away, showing the single head, dual cradle inking/coating apparatus in the operative coating position and having a sealed doctor blade reservoir assembly for spot or overall coating on the blanket;

FIG. 7 is a schematic view showing a heat exchanger and pump assembly connected to the single head, dual cradle inking/coating apparatus for circulating temperature controlled ink or coating material to the inking/coating apparatus;

FIG. 8 is a side elevational view, partially broken away, and similar to FIG. 6 which illustrates an alternative coating head arrangement;

FIG. 9 is a simplified elevational view of a printing unit which illustrates pivotal coupling of the inking/coating apparatus on the printing unit side frame members;

FIG. 10 is a view similar to FIG. 2 in which a pair of split applicator rollers are mounted in the upper cradle and lower cradle, respectively;

FIG. 11 is a side elevational view of a split applicator roller;

FIG. 12 is a perspective view of a doctor blade reservoir which is centrally partitioned by a seal element;

FIG. 13 is a sectional view showing sealing engagement of the split applicator roller against the partition seal element of FIG. 12;

FIG. 14 is a view similar to FIG. 8 which illustrates an alternative inking/coating embodiment;

FIG. 15 is a simplified side elevational view of a substrate which has a bronzed-like finish which is applied by simultaneous operation of the dual applicator roller embodiment of FIG. 14;

FIG. 16 is a side elevational view, partly in section, of a pan roller having separate transfer surfaces mounted on a split fountain pan;

FIG. 17 is a simplified side elevational view of the dual cradle inking/coating apparatus, partially broken away, which illustrates an alternative inking/coating head apparatus featuring a single doctor blade assembly, anilox applicator roller mounted on the lower cradle; and

FIG. 18 is a side elevational view, partly in section, of a single doctor blade anilox applicator roller assembly having separate transfer surfaces, and a split fountain pan having separate fountain compartments, with the separate fountain compartments being supplied with different inks or coating materials from separate off-press sources.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

As used herein, the term "processed" refers to printing and coating methods which can be applied to either side of a substrate, including the application of lithographic, waterless, UV-curable, aqueous and flexographic inks and/or coatings. The term "substrate" refers to sheet and web material. Also, as used herein, the term "waterless printing plate" refers to a printing plate having image areas and non-image areas which are oleophilic and oleophobic, respectively. "Waterless printing ink" refers to an oil-based ink which does not contain a significant aqueous component. "Flexographic plate" refers to a flexible printing plate having a relief surface which is wettable by flexographic ink or coating material. "Flexographic printing ink or coating material" refers to an ink or coating material having a base constituent of either water, solvent or UV-curable liquid. "UV-curable lithographic printing ink and coating material" refers to oil-based printing inks and coating materials that can be cured (dried) photomechanically by exposure to ultraviolet radiation, and that have a semi-paste or gel-like consistency. "Aqueous printing ink or coating material" refers to an ink or coating material that predominantly contains water as a solvent, diluent or vehicle. A "relief plate" refers to a printing plate having image areas which are raised relative to non-image areas which are recessed.

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line inking/coating apparatus, herein generally designated 10, for applying aqueous, flexographic or UV-curable inks or protective and/or decorative coatings to sheets or webs printed in a

sheet-fed or web-fed, rotary offset printing press, herein generally designated 12. In this instance, as shown in FIG. 1, the inking/coating apparatus 10 is installed in a four unit rotary offset printing press 12, such as that manufactured by Heidelberg Druckmaschinen AG of Germany under its designation Heidelberg Speedmaster SM102 (40", 102 cm).

The press 12 includes a press frame 14 coupled at one end, herein the right end, to a sheet feeder 16 from which sheets, herein designated S, are individually and sequentially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the freshly printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical sheet printing units 22, 24, 26 and 28 which can print four different colors onto the sheets as they are transferred through the press 12. The printing units are housed within printing towers T1, T2, T3 and T4 formed by side frame members 14, 15. Each printing tower has a delivery side 25 and a dampener side 27. A dampener space 29 is partially enclosed by the side frames on the dampener side of the printing unit.

As illustrated, the printing units 22, 24, 26 and 28 are substantially identical and of conventional design. The first printing unit 22 includes an in-iced transfer cylinder 30, a plate cylinder 32, a blanket cylinder 34 and an impression cylinder 36, all supported for rotation in parallel alignment between the press side frames 14, 15 which define printing unit towers T1, T2, T3 and T4. Each of the first three printing units 22, 24 and 26 have a transfer cylinder 38 disposed to transfer the freshly printed sheets from the adjacent impression cylinder and transfer the freshly printed sheets to the next printing unit via an intermediate transfer drum 40.

The last printing unit 28 includes a delivery cylinder 42 mounted on a delivery shaft 43. The delivery cylinder 42 supports the freshly printed sheet 18 as it is transferred from the last impression cylinder 36 to a delivery conveyor system, generally designated 44, which transfers the freshly printed sheet to the sheet delivery stacker 20. To prevent smearing during transfer, a flexible covering is mounted on the delivery cylinder 42, as described and claimed in U.S. Pat. No. 4,402,267 to Howard W. DeMoore, which is incorporated herein by reference. The flexible covering is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE®. Optionally, a vacuum-assisted sheet transfer assembly manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark BACVAC® can be substituted for the delivery transfer cylinder 42 and flexible covering.

The delivery conveyor system 44 as shown in FIG. 2 is of conventional design and includes a pair of endless delivery gripper chains 46, only one of which is shown carrying at regular spaced locations along the chains, laterally disposed gripper bars having gripper fingers used to grip the leading edge of a freshly printed or coated sheet 18 after it leaves the nip between the impression cylinder 36 and delivery cylinder 42 of the last printing unit 28. As the leading edge is gripped by the gripper fingers, the delivery chains 46 pull the sheet away from the last impression cylinder 36 and convey the freshly printed or coated sheet to the sheet delivery stacker 20.

Prior to reaching the delivery sheet stacker, the freshly printed and/or coated sheets S pass under a delivery dryer 48 which includes a combination of infra-red thermal radiation, high velocity hot air flow and a high performance heat and moisture extractor for drying the ink and/or the protective/

decorative coating. Preferably, the delivery dryer 48, including the high performance heat and moisture extractor is constructed as described in U.S. application Ser. No. 08/116,711, filed Sep. 3, 1993, entitled "Infra-Red Forced Air Dryer and Extractor" by Howard C. Secor, Ronald M. Rendleman and Paul D. Copenhaver, commonly assigned to the assignee of the present invention, Howard W. DeMoore, and licensed to Printing Research, Inc. of Dallas, Tex., U.S.A., which manufactures and markets the delivery dryer 48 under its trademark AJR BLANKET™.

In the exemplary embodiment shown in FIG. 3, the first printing unit 22 has a flexographic printing plate PF mounted on the plate cylinder, and therefore neither an inking roller train nor a dampening system is required. A flexographic printing plate PF is also mounted on the plate cylinder of the second printing unit 24. The form rollers of the inking roller train 52 shown mounted on the second printing unit 24 are retracted and locked off to prevent plate contact. Flexographic ink is supplied to the flexographic plate PF of the second printing unit 24 by the inking/coating apparatus 10.

A suitable flexographic printing plate PF is offered by E.I. du Pont de Nemours of Wilmington, Del., U.S.A., under its trademark CYREL®. Another source is BASF Aktiengesellschaft of Ludwigshafen, Germany, which offers a suitable flexographic printing plate under its trademark NYLOF-LEX®.

The third printing unit 26 as illustrated in FIG. 3 and FIG. 4 is equipped for lithographic printing and includes an inking apparatus 50 having an inking roller train 52 arranged to transfer ink Q from an ink fountain 54 to a lithographic plate P mounted on the plate cylinder 32. This is accomplished by a fountain roller 56 and a ductor roller 57. The fountain roller 56 projects into the ink fountain 54, whereupon its surface picks up ink. The lithographic printing ink Q is transferred from the fountain roller 56 to the inking roller train 52 by the ductor roller 57. The inking roller train 52 supplies ink Q to the image areas of the lithographic printing plate P.

The lithographic printing ink Q is transferred from the lithographic printing plate P to an ink receptive blanket B which is mounted on the blanket cylinder 34. The inked image carried on the blanket B is transferred to a substrate S as the substrate is transferred through the nip between the blanket cylinder 34 and the impression cylinder 36.

The inking roller arrangement 52 illustrated in FIG. 3 and FIG. 4 is exemplary for use in combination with lithographic ink printing plates P. It is understood that a dampening system 38 having a dampening fluid reservoir DF is coupled to the inking roller train 52 (FIG. 4), but is not required for waterless or flexographic printing.

The plate cylinder 32 of printing unit 28 is equipped with a waterless printing plate PW. Waterless printing plates are also referred to as dry planographic printing plates and are disclosed in the following U.S. Pat. Nos.: 3,910,187; Re. 30,670; 4,086,093; and 4,853,313. Suitable waterless printing plates can be obtained from Toray Industries, Inc. of Tokyo, Japan. A dampening system is not used for waterless printing, and waterless (oil-based) printing ink is used. The waterless printing plate PW has image areas and non-image areas which are oleophilic/hydrophilic and oleophobic/hydrophobic, respectively. The waterless printing plate PW is engraved or etched, with the image areas being recessed with respect to the non-image areas. The image area of the waterless printing plate PW is rolled-up with the flexographic or aqueous printing ink which is transferred by the

applicator roller 66. Both aqueous and oil-based inks and coatings are repelled from the non-image areas, and are retained in the image areas. The printing ink or coating is then transferred from the image areas to an ink or coating receptive blanket B and is printed or coated onto a substrate S.

For some printing jobs, a flexographic plate PF or a waterless printing plate PW is mounted over a resilient packing such as the blanket B on the blanket cylinder 34, for example as indicated by phantom lines in printing unit 22 of FIG. 5. An advantage of this alternative embodiment is that the waterless plate PW or the flexographic plate PF are resiliently supported over the blanket cylinder by the underlying blanket B or other resilient packing. The radial deflection and give of the resilient blanket B provides uniform, positive engagement between the applicator roller 66 and a flexographic plate or waterless plate.

In that arrangement, a plate is not mounted on the plate cylinder 32; instead, a waterless plate PW is mounted on the blanket cylinder, and the inked image on the waterless printing plate is not offset but is instead transferred directly from the waterless printing plate PW to the substrate S. The water component of flexographic ink on the freshly printed sheet is evaporated by high velocity, hot air dryers and high volume heat and moisture extractors so that the freshly printed aqueous or flexographic ink is dried before the substrate is printed on the next printing unit.

Referring now to FIG. 2, FIG. 3 and FIG. 9, the inking/coating apparatus 10 is pivotally mounted on the side frames 14, 15 for rotation about an axis X. The inking/coating apparatus 10 includes a frame 60, a hydraulic motor 62, a lower gear train 64, an upper gear train 65, an applicator roller 66, a sealed doctor blade assembly 68 (FIG. 6), and a drip pan DP, all mounted on the frame 60. The external peripheral surface of the applicator roller 66 is wetted by contact with liquid coating material or ink contained in a reservoir 70.

The hydraulic motor 62 drives the applicator roller 66 synchronously with the plate cylinder 32 and the blanket cylinder 34 in response to an RPM control signal from the press drive (not illustrated) and a feedback signal developed by a tachometer 72. While a hydraulic drive motor is preferred, other drive means such as an electric drive motor or an equivalent can be used.

When using waterless printing plate systems, the temperature of the waterless printing ink and of the waterless printing plate must be closely controlled for good image reproduction. For example, for waterless offset printing with TORAY waterless printing plates PW, it is absolutely necessary to control the waterless printing plate surface and waterless ink temperature to a very narrow range, for example 24° C. (75° F.) to 27° C. (80° F.).

Referring to FIG. 7, the reservoir 70 is supplied with ink or coating which is temperature controlled by a heat exchanger 71. The temperature controlled ink or coating material is circulated by a positive displacement pump, for example a peristaltic pump, through the reservoir 70 and heat exchanger 71 from a source 73 through a supply conduit 75 and a return conduit 77. The heat exchanger 71 cools or heats the ink or coating material and maintains the ink or coating and the printing plate within the desired narrow temperature range.

According to one aspect of the present invention, aqueous/flexographic ink or coating material is supplied to the applicator roller 66, which transfers the aqueous/flexographic ink or coating material to the printing plate

(FIG. 7), which may be a waterless printing plate or a flexographic printing plate. When the inking/coating apparatus is used for applying aqueous/flexographic ink or coating material to a waterless printing plate FW, the inking roller train 52 is not required, and is retracted away from the printing plate. Because the viscosity of aqueous/flexographic printing ink or coating material varies with temperature, it is necessary to heat or cool the aqueous/flexographic printing ink or coating material to compensate for ambient temperature variations to maintain the ink viscosity in a preferred operating range.

For example, the temperature of the printing press can vary from around 60° F. (15° C.) in the morning, to around 85° F. (29° C.) or more in the afternoon. The viscosity of aqueous/flexographic printing ink or coating material can be marginally high when the ambient temperature of the press is near 60° F. (15° C.), and the viscosity can be marginally low when the ambient temperature of the press exceeds 85° F. (29° C.). Consequently, it is desirable to control the temperature of the aqueous/flexographic printing ink or coating material so that it will maintain the surface temperature of waterless printing plates within the specified temperature range. Moreover, the ink/coating material temperature should be controlled to maintain the tack of the aqueous/flexographic printing ink or coating material within a desired range when the ink or coating material is being used in connection with flexographic printing processes.

The applicator roller 66 is preferably an anilox fluid metering roller which transfers measured amounts of printing ink or coating material to a plate or blanket. The surface of an anilox roller is engraved with an array of closely spaced, shallow depressions referred to as "cells". Ink or coating from the reservoir 70 flows into the cells as the anilox roller turns through the reservoir. The transfer surface of the anilox roller is "doctored" (wiped or scraped) by dual doctor blades 68A, 68B to remove excess ink or coating material. The ink or coating metered by the anilox roller is that contained within the cells. The dual doctor blades 68A, 68B also seal the supply reservoir 70.

The anilox applicator roller 66 is cylindrical and may be constructed in various diameters and lengths, containing cells of various sizes and shapes. The volumetric capacity of an anilox roller is determined by cell size, shape and number of cells per unit area. Depending upon the intended application, the cell pattern may be fine (many small cells per unit area) or coarse (fewer large cells per unit area).

By supplying the ink or coating material through the inking/coating apparatus 10, more ink or coating material can be applied to the sheet S as compared with the inking roller train of a lithographic printing unit. Moreover, color intensity is stronger and more brilliant because the aqueous or flexographic ink or coating material is applied at a much heavier film thickness or weight than can be applied by the lithographic process, and the aqueous or flexographic colors are not diluted by dampening solution.

Preferably, the sealed doctor blade assembly 68 is constructed as described in U.S. Pat. No. 5,176,077 to Howard W. DeMoore, co-inventor and assignee, which is incorporated herein by reference. An advantage of using a sealed reservoir is that fast drying ink or coating material can be used. Fast drying ink or coating material can be used in an open fountain 53 (see FIG. 8); however, open air exposure causes the water and solvents in the fast-drying ink or coating material to evaporate faster, thus causing the ink or coating material to dry prematurely and change viscosity. Moreover, an open fountain emits unwanted odors into the

press room. When the sealed doctor blade assembly is utilized, the pump (FIG. 7) which circulates ink or coating material to the doctor blade head is preferably a peristaltic pump, which does not inject air into the feeder lines which supply the ink or coating reservoir 70 and helps to prevent the formation of air bubbles and foam within the ink or coating material.

An inking/coating apparatus 10 having an alternative applicator roller arrangement is illustrated in FIGS. 10-13. In this arrangement, the engraved metering surface of the anilox applicator rollers 66, 67 are partitioned by smooth seal surfaces 66C which separates a first engraved peripheral surface portion 66A from a second engraved peripheral surface portion 66B. Likewise, smooth seal surfaces 66D, 66E are formed on the opposite end portions of the applicator roller 66 for engaging end seals 134, 136 (FIG. 12) of the doctor blade reservoir. The upper applicator roller 67 has engraved anilox metering surfaces 67A and 67B which are separated by a smooth seal band 67C.

Referring now to FIG. 12 and FIG. 13, the reservoir 70 of the doctor blade head 68 is partitioned by a curved seal element 130 to form two separate chambers 70A, 70B. The seal element 130 is secured to the doctor blade head within an annular groove 132. The seal element 130 is preferably made of polyurethane foam or other durable, resilient foam material. The seal element 130 is engaged by the seal band 66, thus forming a rotary seal which blocks the leakage of ink or coating material from one reservoir chamber into the other reservoir chamber. Moreover, the seal band provides an unprinted or uncoated area which separates the printed or coated areas from each other, which is needed for work and turn printing jobs or other printing jobs which print two or more separate images onto the same substrate.

Another advantage of the split applicator roller embodiment is that it enables two or more flexographic inks or coating materials to be printed simultaneously within the same lithographic printing unit. That is, the reservoir chambers 70A, 70B of the upper doctor blade assembly can be supplied with gold ink and silver ink, for example, while the reservoir chambers 70A, 70B of the lower doctor blade assembly can be supplied with inks of two additional colors, for example opaque white ink and blue ink. This permits the opaque white ink to be overprinted with the gold ink, and the blue ink to be overprinted with the silver ink on the same printing unit on any lithographic press.

Moreover, a catalyst can be used in the upper doctor blade reservoir and a reactive ink or coating material can be used in the lower doctor blade reservoir. This can provide various effects, for example improved chemical resistance and higher gloss levels.

The split applicator roller sections 67A, 67B in the upper cradle position can be used for applying two separate inks or coating materials simultaneously, for example flexographic, aqueous and ultra-violet curable inks or coating materials, to separate surface areas of the plate, while the lower applicator roller sections 66A, 66B can apply an initiator layer and a microencapsulated layer simultaneously to separate blanket surface areas. Optionally, the metering surface portions 66A, 66B can be provided with different cell metering capacities for providing different printing effects which are being printed simultaneously. For example, the screen line count on one half-section of an anilox applicator roller is preferably in the range of 200-600 lines per inch (79-236 lines per cm) for half-tone images, and the screen line count of the other half-section is preferably in the range of 100-300 lines per inch (39-118 lines per cm) for overall coverage, high

weight applications such as opaque white. This split arrangement in combination with dual applicator rollers is particularly advantageous when used in connection with "work and turn" printing jobs.

Referring again to FIG. 8, instead of using the sealed doctor blade reservoir assembly 68 as shown in FIG. 6, an open fountain assembly 69 is provided by the fountain pan 53 which contains a volume of liquid ink Q or coating material. The liquid ink or coating material is transferred to the applicator roller 66 by a pan roller 55 which turns in contact with ink Q or coating material in the fountain pan. If a split applicator roller is used, the pan roller 55 is also split, and the pan is divided into two pan sections 53A, 53B by a separator plate 53P, as shown in FIG. 16.

In the alternative embodiment of FIG. 16, the pan roller 55 is divided into two pan roller sections 55A, 55B by a centrally located, annular groove 59. The separator plate 53P is received within and centrally aligned with the groove 59, but does not touch the adjoining roller faces. By this arrangement, two or more inks or coating materials Q1, Q2 are contained within the open pan sections 55A, 55B for transfer by the split pan roller sections 53A, 53B, respectively. This permits two or more flexographic inks or coating materials to be transferred to two separate image areas on the plate or on the blanket of the same printing unit. This arrangement is particularly advantageous for work and turn printing jobs or other printing jobs which print two or more separate images onto the same substrate.

The frame 60 of the inking/coating apparatus 10 includes side support members 74, 76 which support the applicator roller 66, gear train 64, gear train 65, doctor blade assembly 68 and the drive motor 62. The applicator roller 66 is mounted on stub shafts 63A, 63B which are supported at opposite ends on a lower cradle assembly 100 formed by a pair of side support members 78, 80 which have sockets 79, 81 and retainer caps 101, 103. The stub shafts are received in roller bearings 105, 107 which permit free rotation of the applicator roller 66 about its longitudinal axis A1 (axis A2 in the upper cradle). The retainer caps 101, 103 hold the stub shafts 63A, 63B and bearings 105, 107 in the sockets 79, 81 and hold the applicator roller 66 in parallel alignment with the pivot axis X.

The side support members 74, 76 also have an upper cradle assembly 102 formed by a pair of side support members 82, 84 which are vertically spaced with respect to the lower side plates 78, 80. Each cradle 100, 102 has a pair of sockets 79, 81 and 83, 85, respectively, for holding an applicator roller 66, 67 for spot coating or inking engagement with the printing plate P on the plate cylinder 32 (FIG. 4) or with a printing plate P or a blanket B on the blanket cylinder 34.

Preferably, the applicator roller 67 (FIG. 8, FIG. 9) the upper cradle (plate) position is an anilox roller having a resilient transfer surface. In the dual cradle arrangement as shown in FIG. 2, the press operator can quickly change from blanket inking/coating to plate inking/coating within minutes, since it is only necessary to release, remove and reposition or replace the applicator roller 66.

The capability to simultaneously print in the flexographic mode, the aqueous mode, the waterless mode, or the lithographic mode on different printing units of the same lithographic press and to print or coat from either the plate position or the blanket position on any one of the printing units is referred to herein as the LITHOFLEX™ printing process or system. LITHOFLEX™ is a trademark of Printing Research, Inc. of Dallas, Tex., U.S.A., exclusive licensee of the present invention.

Referring now to FIG. 14, an inking/coating apparatus 10 having an inking/coating assembly 109 of an alternative design is installed in the upper cradle position for applying ink and/or coating material to a plate P on the plate cylinder 32. According to this alternative embodiment, an applicator roller 67R having a resilient transfer surface is coupled to an anilox fluid metering roller which transfers measured amounts of printing ink or coating material to the plate P. The anilox roller 111 has a transfer surface constructed of metal, ceramic or composite material which is engraved with cells. The resilient applicator roller 67R is interposed in transfer engagement with the plate P and the metering surface of the anilox roller 111. The resilient transfer surface of the applicator roller 67R provides uniform, positive engagement with the plate.

Referring now to FIG. 17, an inking/coating apparatus 10 having an alternative inking/coating assembly 113 is installed in the lower cradle assembly 100 for applying flexographic or aqueous ink and/or coating material Q to a plate or blanket mounted on the blanket cylinder 34. Instead of using the sealed, dual doctor blade reservoir assembly 68 as shown in FIG. 6, an open, single doctor blade anilox roller assembly 113 is supplied with liquid ink Q or coating material contained in an open fountain pan 117. The liquid ink or coating material Q is transferred to the engraved transfer surface of the anilox roller 66 as it turns in the fountain pan 117. Excess ink or coating material Q is removed from the engraved transfer surface by a single doctor blade 68B. The liquid ink or coating material Q is pumped from an off-press source, for example the drum 73 shown in FIG. 17, through a supply conduit 119 into the fountain pan 117 by a pump 120.

For overall inking or coating jobs, the metering transfer surface of the anilox roller 66 extends over its entire peripheral surface. However, for certain printing jobs which print two or more separate images onto the same substrate, for example work and turn printing jobs, the metering transfer surface of the anilox applicator roller 66 is partitioned by a centrally located, annular undercut groove 66C which separates first and second metering transfer surfaces 66A, 66B as shown in FIG. 11 and FIG. 18.

The single doctor blade 68B has an edge 68E which wipes simultaneously against the split metering transfer surfaces 66A, 66B. In this single blade, split anilox roller embodiment 113, it is necessary to provide dual supply sources, for example drums 73A, 73B, dual supply lines 119A, 119B, and dual pumps 120A, 120B. Moreover, the fountain pan 117 is also split, and the pan 117 is divided into two pan sections 117A, 117B by a separator plate 121, as shown in FIG. 18. The separator plate 121 is centrally aligned with the undercut groove 66C, but does not touch the adjoining roller faces.

Although the single blade, split anilox applicator roller assembly 113 is shown mounted in the lower cradle position (FIG. 17), it should be understood that the single blade, split anilox applicator roller assembly 113 can be mounted and used in the upper cradle position, as well.

According to another aspect of the present invention, the inking/coating apparatus 10 is pivotally coupled on horizontal pivot pins 88P, 90P which allows the single head, dual cradle inking/coating apparatus 10 to be mounted on any lithographic printing unit. Referring to FIG. 9, the horizontal pivot pins 88P, 90P are mounted within the traditional dampener space 29 of the printing unit and are secured to the press side frames 14, 15, respectively. Preferably, the pivot support pins 88P, 90P are secured to the press side frames by

a threaded fastener. The pivot support pins are received within circular openings 88, 90 which intersect the side support members 74, 76 of the inking/coating apparatus 10. The horizontal support pins 88P, 90P are disposed in parallel alignment with rotational axis X and with the plate cylinder and blanket cylinder, and are in longitudinal alignment with each other.

Preferably, the pivot pins 88P, 90P are located in the dampener space 29 so that the rotational axes A1, A2 of the applicator rollers 66, 67 are elevated with respect to the nip contact points N1, N2. By that arrangement, the transfer point between the applicator roller 66 and a blanket on the blanket cylinder 34 (as shown in FIG. 8) and the transfer point between the applicator roller 66 and a plate on the plate cylinder 32 (as shown in FIG. 5) are above the radius lines R1, R2 of the plate cylinder and the blanket cylinder, respectively. This permits the inking/coating apparatus 10 to move clockwise to retract the applicator roller 66 to an off-impression position relative to the blanket cylinder in response to a single extension stroke of the power actuator arms 104A, 106A. Similarly, the applicator roller 66 is moved counterclockwise to the on-impression operative position as shown in FIGS. 4, 5, 6 and 8 by a single retraction stroke of the actuator arms 104A, 106A, respectively.

Preferably, the pivot pins are made of steel and the side support members are made of aluminum, with the steel pivot pins and the aluminum collar portion bordering the circular openings 88, 90 forming a low friction journal. By this arrangement, the inking/coating apparatus 10 is freely rotatable clockwise and counterclockwise with respect to the pivot pins 88P, 90P. Typically, the arc length of rotation is approximately 60 mils (about 1.5 mm). Consequently, the inking/coating apparatus 10 is almost totally enclosed within the dampener space 29 of the printing unit in the on-impression position and in the off-impression position.

The cradle assemblies 100 and 102 position the applicator roller 66 in inking/coating alignment with the plate cylinder or blanket cylinder, respectively, when the inking/coating apparatus 10 is extended to the operative (on-impression) position. Moreover, because the inking/coating apparatus 10 is installed within the dampener space 29, it is capable of freely rotating through a small arc while extending and retracting without being obstructed by the press side frames or other parts of the printing press. This makes it possible to install the inking/coating apparatus 10 on any lithographic printing unit. Moreover, because of its internal mounting position within the dampener space 29, the projection of the inking/coating apparatus 10 into the space between printing units is minimal. This assures unrestricted operator access to the printing unit when the applicator head is in the operative (on-impression) and retracted (off-impression) positions.

As shown in FIG. 4 and FIG. 5, movement of the inking/coating apparatus 10 is counterclockwise from the retracted (off-impression) position to the operative (on-impression) position.

Although the dampener side installation is preferred, the inking/coating apparatus 10 can be adapted for operation on the delivery side of the printing unit, with the inking/coating apparatus being movable from a retracted (off-impression) position to an on-impression position for engagement of the applicator roller with either a plate on the plate cylinder or a blanket on the blanket cylinder on the delivery side 25 of the printing unit.

Movement of the inking/coating apparatus 10 to the operative (on-impression) position is produced by power

actuators, preferably double acting pneumatic cylinders 104, 106 which have extendable/retractable power transfer arms 104A, 106A, respectively. The first pneumatic cylinder 104 is pivotally coupled to the press frame 14 by a pivot pin 108, and the second pneumatic cylinder 106 is pivotally coupled to the press frame 15 by a pivot pin 110. In response to selective actuation of the pneumatic cylinders 104, 106, the power transfer arms 104A, 106A are extended or retracted. The power transfer arm 104A is pivotally coupled to the side support member 74 by a pivot pin 112. Likewise, the power transfer arm 106A is pivotally coupled to the side support member 76 by a pivot pin 114.

As the power arms extend, the inking/coating apparatus 10 is rotated clockwise on the pivot pins 88P, 90P, thus moving the applicator roller 66 to the off-impression position. As the power arms retract, the inking/coater apparatus 60 is rotated counterclockwise on the pivot pins 88P, 90P, thus moving the applicator roller 66 to the on-impression position. The torque applied by the pneumatic actuators is transmitted to the inking/coating apparatus 10 through the pivot pin 112 and pivot pin 114.

Fine adjustment of the on-impression position of the applicator roller relative to the plate cylinder or the blanket cylinder, and of the pressure of roller engagement, is provided by an adjustable stop assembly 115. The adjustable stop assembly 115 has a threaded bolt 116 which is engagable with a bell crank 118.

The bell crank 118 is pivotally coupled to the side support member 74 on a pin 120. One end of the bell crank 118 is engagable by the threaded bolt 116, and a cam roller 122 is mounted for rotation on its opposite end. The striking point of engagement is adjusted by rotation of the bolt 116 so that the applicator roller 66 is properly positioned for inking/coating engagement with the plate P or blanket B and provides the desired amount of inking/coating pressure when the inking/coating assembly 60 is moved to the operative position.

This arrangement permits the in-line inking/coating apparatus to operate effectively without encroaching in the interunit space between any adjacent printing units, and without blocking or obstructing access to the cylinders of the printing units when the inking/coating apparatus is in the extended (off-impression) position or retracted (on-impression) position. Moreover, when the in-line inking/coating apparatus is in the retracted position, the doctor blade reservoir and coating circulation lines can be drained and flushed automatically while the printing press is running as well as when the press has been stopped for change-over from one job to another or from one type of ink or coating to another.

Substrates which are printed or coated with aqueous flexographic printing inks require high velocity hot air for drying. When printing a flexographic ink such as opaque white or metallic gold, it is always necessary to dry the printed substrates between printing units before overprinting them. According to the present invention, the water component on the surface of the freshly printed or coated substrate S is evaporated and dried by high velocity, hot air interunit dryer and high volume heat and moisture extractor units 124, 126 and 128, as shown in FIG. 2, FIG. 4 and FIG. 5. The dryer/extractor units 124, 126 and 128 are oriented to direct high velocity heated air onto the freshly printed/coated substrates as they are transferred by the impression cylinder 36 and the intermediate transfer drum 40 of one printing unit and to another transfer cylinder 30 and to the impression cylinder 36 of the next printing unit. By that

arrangement, the freshly printed flexographic ink or coating material is dried before the substrate S is overprinted by the next printing unit.

The high velocity, hot air dryer and high performance heat and moisture extractor units 124, 126 and 128 utilize high velocity air jets which scrub and break-up the moist air layer which clings to the surface of each freshly printed or coated sheet or web. Within each dryer, high velocity air is heated as it flows across a resistance heating element within an air delivery haffle tube. High velocity jets of hot air are discharged through multiple airflow apertures into an exposure zone Z (FIG. 4 and FIG. 5) and onto the freshly printed/coated sheet S as it is transferred by the impression cylinder 36 and transfer drum 40, respectively.

Each dryer assembly includes a pair of air delivery dryer heads 124D, 126D and 128D which are arranged in spaced, side-by-side relationship. The high velocity, hot air dryer and high performance heat and moisture extractor units 124, 126 and 128 are preferably constructed as disclosed in co-pending U.S. patent application Ser. No. 08/132,584, filed Oct. 6, 1993, entitled "High Velocity Hot Air Dryer", to Howard W. DeMoore, co-inventor and assignee of the present invention, and which is incorporated herein by reference, and which is marketed by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE HV™.

The hot moisture-laden air displaced from the surface of each printed or coated sheet is extracted from the dryer exposure zone Z and exhausted from the printing unit by the high volume extractors 124, 126 and 128. Each extractor head includes an extractor manifold 124E, 126E and 128E coupled to the dryer heads 124D, 126D and 128D and draws the moisture, volatiles, odors and hot air through a longitudinal air gap G between the dryer heads. Best results are obtained when extraction is performed simultaneously with drying. Preferably, an extractor is closely coupled to the exposure zone Z at each dryer location as shown in FIG. 4. Extractor heads 124E, 126E and 128E are mounted on the dryer heads 124D, 126D and 128D, respectively, with the longitudinal extractor air gap G facing directly into the exposure zone Z. According to this arrangement, each printed or coated sheet is dried before it is printed on the next printing unit.

The aqueous water-based inks used in flexographic printing evaporate at a relatively moderate temperature provided by the interunit high velocity hot air dryers/extractors 124, 126 and 128. Sharpness and print quality are substantially improved since the flexographic ink or coating material is dried before it is overprinted on the next printing unit. Since the freshly printed flexographic ink is dry, dot gain is substantially reduced and back-trapping on the blanket of the next printing unit is virtually eliminated. This interunit drying/extracting arrangement makes it possible to print flexographic inks such as metallic ink and opaque white ink on the first printing unit, and then dry-trap and overprint on the second and subsequent printing units.

Moreover, this arrangement permits the first printing unit 22 to be used as a coater in which a flexographic, aqueous or UV-curable coating material is applied to the lowest grade substrate such as recycled paper, cardboard, plastic and the like, to trap and seal-in lint, dust, spray powder and other debris and provide a smoother, more durable printing surface which can be overprinted on the next printing unit.

A first down (primer) aqueous coating layer seals-in the surface of a low grade, rough substrate, for example, re-cycled paper or plastic, and improves overprinted dot

definition and provides better ink lay-down while preventing strike-through and show-through. A flexographic UV-curable coating material can then be applied downstream over the primer coating, thus producing higher coating gloss.

Preferably, the applicator roller 66 is constructed of composite carbon fiber material, metal or ceramic coated metal when it is used for applying ink or coating material to the blanket B or other resilient material on the blanket cylinder 34. When the applicator roller 66 is applied to the plate, it is preferably constructed as an anilox roller having a resilient, compressible transfer surface. Suitable resilient roller surface materials include Buna N synthetic rubber and EPDM (terpolymer elastomer). EPDM is known to be completely acceptable for use with UV-curable inks and coating applications.

A demonstration resilient anilox roller was made by covering a steel core with about 1/4 inch of rubber to a diameter of about four inches. The rubber had a hardness of about 80 on the Shore "A" scale. The surface was laser engraved by Consolidated Engravers, 2255 West Longhorn Dr., Lancaster, Tex. 76134 with four different patterns in approximately 10 inch wide bands across the face comprising about 125, 150, 175 and 200 lines/inch with what was a "hexagonal" cell pattern. Satisfactory coatings were applied via the plate cylinder to a substrate with all four patterns. A second resilient anilox roll was obtained which had only one 150 lines/inch overall pattern with a cell volume of about 9 cubic billion microns (CBM). Satisfactory coating was applied from this roll against a plate. Coating was applied in the roll by a sealed doctor blade assembly like assembly 68 in FIG. 6. The roller produced useful film weight. Water based inks were applied satisfactorily in various colors. The surface speed of the plate and resilient anilox rollers were kept about the same. No reason is seen why a roller train similar to fountain assembly 69 in FIG. 8 could not be used to supply coating to a resilient anilox roller 66. The resilient anilox roller will accommodate slight variations in elevation of a printing plate or blanket much better than a ceramic or hard surface anilox roller.

It has been demonstrated in prototype testing that the inking/coating apparatus 10 can apply a wide range of ink and coating types, including fluorescent (Day Glo), pearlescent, metallics (gold, silver and other metals), glitter, scratch and sniff (micro-encapsulated fragrance), scratch and reveal, luminous, pressure-sensitive adhesives and the like, as well as UV-curable and aqueous coatings.

With the dampener assembly removed from the printing unit, the inking/coating apparatus 10 can easily be installed in the dampener space for selectively applying flexographic inks and/or coatings to a flexographic or waterless printing plate or to the blanket. Moreover, overprinting of the flexographic inks and coatings can be performed on the next printing unit since the flexographic inks and/or coatings are dried by the high velocity, hot air interunit dryer and high volume heat and moisture extractor assembly of the present invention or by Ultra Violet curing.

The flexographic inks and coatings as used in the present invention contain colored pigments and/or soluble dyes, binders which fix the pigments onto the surface of the substrate, waxes, defoamers, thickeners and solvents. Aqueous printing inks predominantly contain water as a diluent and/or vehicle. The thickeners which are preferred include alginates, starch, cellulose and its derivatives, for example cellulose esters or cellulose ethers and the like. Coloring agents including organic as well as inorganic pigments may

be derived from dyes which are insoluble in water and solvents. Suitable binders include acrylates and/or polyvinylchloride.

When metallic inks are printed, the cells of the anilox roller must be appropriately sized to prevent the metal particles from getting stuck within the cells. For example, for metallic gold ink, the anilox roller should have a screen line count in the range of 175-300 lines per inch (68-118 lines per cm). Preferably, in order to keep the anilox roller cells clear, the doctor blade assembly 68 is equipped with a bristle brush BR (FIG. 14) as set forth in U.S. Pat. No. 5,425,809 to Steven M. Person, assigned to Howard W. DeMoore, and licensed to Printing Research, Inc. of Dallas, Tex., U.S.A., which is incorporated herein by reference.

The inking/coating apparatus 10 can also apply UV-curable inks and coatings. If UV-curable inks and coatings are utilized, ultra-violet dryers/extractors are installed adjacent to the high velocity hot air dryer/extractor units 124, 126 and 128, respectively.

It will be appreciated that the LITHOFLEX™ printing process described herein makes it possible to selectively operate a printing unit of a press in the lithographic printing mode while simultaneously operating another printing unit of the same press in either the flexographic printing mode or in the waterless printing mode, while also providing the capability to print or coat, separately or simultaneously, from either the plate position or the blanket position. The dual cradle support arrangement of the present invention makes it possible to quickly change over from inking/coating on the blanket cylinder position to inking/coating on the plate cylinder position with minimum press down-time, since it is only necessary to remove and reposition or replace the applicator roller 66 while the inking/coating apparatus 10 is in the retracted position. It is only necessary to remove four cap screws, lift the applicator roller 66 from the cradle, and reposition it in the other cradle. All of this can be accomplished in a few minutes, without removing the inking/coating apparatus 10 from the press.

It is possible to spot coat or overall coat from the plate position or from the blanket position with flexographic inks or coatings on one printing unit and then spot coat or overall coat with UV-curable inks or coatings from the plate position or from the blanket position on another printing unit during the same press run. Moreover, the press operator can spot or overall coat from the plate for one job, and then spot and/or overall coat from the blanket on the next job.

The positioning of the applicator roller relative to the plate or blanket is repeatable to a predetermined preset operative position. Consequently, only minor printing unit modifications or alterations may be required for the LITHOFLEX™ process. Although automatic extension and retraction have been described in connection with the exemplary embodiment, extension to the operative (on-impression) position and retraction to a non-operative (off-impression) position can be carried out manually, if desired. In the manual embodiment, it is necessary to latch the inking/coating apparatus 10 to the press side frames 14, 15 in the operative (on-impression) position, and to mechanically prop the inking/coating apparatus in the off-impression (retracted) position.

Referring again to FIG. 8, an applicator roller 66 is mounted on the lower cradle assembly 100 by side support members 78, 80, and a second applicator roller 66 is mounted on the upper cradle assembly 102 by side support members 82, 84. According to this arrangement, the inking/coating apparatus 10 can apply printing ink and/or coating

material to a plate on the plate cylinder, while simultaneously applying printing ink and/or coating material to a plate or a blanket on the blanket cylinder of the same printing unit. When the same color ink is used by the upper and lower applicator rollers from the plate position and from the blanket position simultaneously on the same printing unit, a "double bump" or double inking films or coating layers are applied to the substrate S during a single pass of the substrate through the printing unit. The tack of the two inks or coating materials must be compatible for good transfer during the double bump. Moreover, the inking/coating apparatus 10 can be used for supplying ink or coating material to the blanket cylinder of a rotary offset web press, or to the blanket of a dedicated coating unit.

According to conventional bronzing techniques, a metallic (bronze) powder is applied off-line to previously printed substrate which produces a grainy, textured finish or appearance. The on-line application of bronze material by conventional flexographic or lithographic printing will only produce a smooth, continuous appearance. However, a grainy, textured finish is preferred for highest quality printing which, prior to the present invention, could only be produced by off-line methods.

Referring now to FIG. 14 and FIG. 15, metallic ink or coating material is applied on-line to the substrate S by simultaneous operation of the upper and lower applicator rollers 67R, 66 to produce an uneven surface finish having a bronze-like textured or grainy appearance. According to the simulated bronzing method of the present invention, the flexographic bronze ink is applied simultaneously to the plate and to the blanket by the dual cradle inking/coating apparatus 10 as shown in FIG. 14. A resilient applicator roller 67R is mounted in the upper cradle 102, and an anilox applicator roller 66 is mounted on the lower cradle 100. The rollers are supplied from separate doctor blade reservoirs 70. The doctor blade reservoir 70 in the upper cradle position supplies bronze ink or coating material having relatively coarse, metallic particles 140 dispersed in aqueous or flexographic ink. The coarse particle ink or coating material is applied to the plate P by the resilient applicator roller 67R in the upper cradle position 102. At the same time, flexographic and/or bronze ink or coating material having relatively fine, metallic particles 142 is transferred to the blanket B by the anilox roller 66 which is mounted on the lower cradle 100.

The metering surfaces of the upper and lower applicator rollers have different cell sizes and volumetric capacities which accommodate the coarse and fine metallic particles. For example, the anilox roller 111 mounted in the upper cradle position 102 which transfers the coarse metallic particles 140 preferably has a screen line count in the range of 100-300 lines per inch (39-118 lines per cm), and the metering surface of the anilox roller 66 mounted on the lower cradle 100 which transfers the relatively fine metallic particles 142 preferably has a screen line count in the range of 200-600 lines per inch (79-236 lines per cm).

After transfer from the plate to the blanket, the fine metallic particles 142 form a layer over the coarse metallic particles 140. As both bronze layers are offset onto the substrate S, the layer of fine metallic particles 142 is printed onto the substrate S with the top layer of coarse metallic particles 140 providing a textured, grainy appearance. The fine metallic particles 142 cover the substrate which would otherwise be visible in the gaps between the coarse metallic particles 140. The combination of the coarse particle layer over the fine particle layer thus provides a textured, bronzed-like finish and appearance.

Particulate materials other than metal can be used for producing a textured finish. For example, coarse and fine particles of metallized plastic (glitter), mica particles (pearlescent) and the like, can be substituted for the metallic particles for producing unlimited surface variations, appearances and effects. All of the particulate material, including the metallic particles, are preferably in solid, flat platelet form, and have a size dimension suitable for application by an anilox applicator roller. Other particulate or granular material, for example stone grit having irregular form and size, can be used to good advantage.

Solid metal particles in platelet form, which are good reflectors of light, are preferred for producing the bronzed-like appearance and effect. However, various textured finishes, which could have light-reflective properties, can be produced by using granular materials such as stone grit. Most commonly used metals include copper, zinc and aluminum. Other ductile metals can be used, if desired. Moreover, the coarse and fine particles need not be made of the same particulate material. Various effects and textured appearances can be produced by utilizing diverse particulate materials for the coarse particles and the fine particles, respectively. Further, either fine or coarse particle ink or coating material can be printed from the upper cradle position, and either fine or coarse particle ink or coating material can be printed from the lower cradle position, depending on the special or surface finish that is desired.

It will be appreciated that the last printing unit 28 can be configured for additional inking/coating capabilities which include lithographic, waterless, aqueous and flexographic processes. Various substrate surface effects (for example double bump or triple bump inking/coating or bronzing) can be performed on the last printing unit. For triple bump inking/coating, the last printing unit 28 is equipped with an auxiliary in-line inking or coating apparatus 97 as shown in FIG. 3 and FIG. 4. The in-line inking or coating apparatus 97 allows the application of yet another film of ink or a protective or decorative layer of coating material over any freshly printed or coated surface effects or special treatments, thereby producing a triple bump. The triple bump is achieved by applying a third film of ink or layer of coating material over the freshly printed or coated double bump simultaneously while the substrate is on the impression cylinder of the last printing unit.

When the in-line inking/coating apparatus 97 is installed, it is necessary to remove the SUPER BLUE® flexible covering from the delivery cylinder 42, and it is also necessary to modify or convert the delivery cylinder 42 for inking/coating service by mounting a plate or blanket B on the delivery cylinder 42, as shown in FIG. 3 and FIG. 4. Packing material is placed under the plate or blanket B, thereby packing the plate or blanket B at the correct packed-to-print radial clearance so that ink or coating material will be printed or coated onto the freshly printed substrate S as it transfers through the nip between the plate or blanket B on the converted delivery cylinder 42 and the last impression cylinder 36. According to this arrangement, a freshly printed or coated substrate is overprinted or overcoated with a third film or layer of ink or coating material simultaneously while a second film or layer of ink or coating material is being over-printed or over-coated on the last impression cylinder 36.

The auxiliary inking/coating apparatus 97 and the converted or modified delivery cylinder 42 are mounted on the delivery drive shaft 43. The inking/coating apparatus 97 includes an applicator roller, preferably an anilox applicator roller 97A, for supplying ink or coating material to a plate

or blanket B on the modified or converted delivery cylinder 42. The in-line inking/coating apparatus 97 and the modified or converted delivery cylinder 42 are preferably constructed as described in U.S. Pat. No. 5,176,077 to Howard W. DeMoore (co-inventor and assignee), which is hereby incorporated by reference. The in-line inking/coating apparatus 97 is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A., under its trademark SUPER BLUE EZ COATER.™

After the delivery cylinder 42 has been modified or converted for inking/coating service, and because of the reduced nip clearance imposed by the plate or blanket B, the modified delivery cylinder 42 can no longer perform its original function of guiding and transferring the freshly printed or coated substrate. Instead, the modified or converted delivery cylinder 42 functions as a part of the inking/coating apparatus 97 by printing or coating a third down film of ink or layer of coating material onto the freshly printed or coated substrate as it is simultaneously printed or coated on the last impression cylinder 36. Moreover, the mutual tack between the second down ink film or coating layer and the third down ink film or coating layer causes the overprinted or overcoated substrate to cling to the plate or blanket, thus opposing or resisting separation of the substrate from the plate or blanket.

To remedy this problem, a vacuum-assisted transfer apparatus 99 is mounted adjacent the modified or converted delivery cylinder 42 as shown in FIG. 3 and FIG. 4. Another purpose of the vacuum-assisted transfer apparatus 99 is to separate the freshly overprinted or overcoated triple bump substrate from the plate or blanket B as the substrate transfers through the nip. The vacuum-assisted transfer apparatus 99 produces a pressure differential across the freshly overprinted or overcoated substrate as it transfers through the nip, thus producing a separation force onto the substrate and providing a clean separation from the plate or blanket B.

The vacuum-assisted transfer apparatus 99 is preferably constructed as described in U.S. Pat. Nos. 5,113,255; 5,127,329; 5,205,217; 5,228,391; 5,243,909; and 5,419,254, all to Howard W. DeMoore, co-inventor, which are incorporated herein by reference. The vacuum-assisted transfer apparatus 99 is manufactured and sold by Printing Research, Inc. of Dallas, Tex., U.S.A. under its trademark BACVAC.™

Although the present invention and its advantages have been described in detail, it should be understood that various changes, substitutions and alterations can be made herein without departing from the spirit and scope of the present invention as defined by the appended claims.

What is claimed is:

1. In a rotary offset printing press having first and second side frame members and a plurality of printing units each having a plate cylinder, a blanket cylinder, and an impression cylinder supported for rotation in operable combination, the printing units having a delivery side and a dampener side opposite the delivery side, an interunit operator space between printing units and a dampener or a space for a dampener on the dampener side of each unit, the improvement comprising:

a printing apparatus for inking or coating, the printing apparatus having a frame movably coupled to at least one printing unit in the space for a dampener, the printing apparatus being movable between an on-impression operative position and an off-impression retracted position;

the movable frame supporting a removable first applicator roller and a removable second applicator roller, the first

applicator roller, being supported for adjustment into and out of ink or coating association with the plate cylinder and the second applicator roll being supported for adjustment into and out of ink or coating association with the blanket cylinder, when the printing apparatus is moved respectively to the on-impression operative position and the off-impression retracted position;

whereby a continuous or spot film of ink or coating can be applied simultaneously by the printing apparatus to a plate on the plate cylinder and the blanket cylinder and ink or coating can be selectively applied to the plate cylinder or blanket cylinder or a plate mounted thereon if one of the first or second applicator rollers is removed from the frame.

2. The invention as set forth in claim 1 wherein the printing apparatus includes:

a doctor blade assembly having a reservoir for receiving ink or coating material coupled to the first or second applicator roll.

3. The invention as set forth in claim 2, the applicator roller comprising:

a roller having a resilient transfer surface.

4. The invention as set forth in claim 1, including:

first and second pivot pins mounted on the first and second side frame members, respectively, said pivot pins extending in alignment with the rotational axis of the plate and blanket cylinders; and

the printing apparatus being pivotally coupled for rotational movement on the pivot pins.

5. The invention as set forth in claim 1, further comprising:

a power actuator pivotally coupled to the printing unit, the power actuator having a power transfer arm which is extendable and retractable; and,

apparatus coupled to the power transfer arm and to the printing apparatus for converting extension or retraction movement of the power transfer arm into pivotal movement of the printing apparatus relative to the plate and blanket cylinder.

6. The invention as set forth in claim 5, in which the movement converting apparatus comprises:

a bell crank plate having a first end portion pivotally coupled to the printing apparatus for engaging the printing unit and having a second end portion for engaging a stop member; and,

a stop member coupled to the inking or coating apparatus for engaging the second end portion of the bell crank plate.

7. The invention as set forth in claim 1, the printing apparatus comprising:

the movable frame having first and second side support members;

the ink or coating applicator rollers being mounted between the first side support member and second side support member and having a reservoir or fountain pan for receiving ink or coating material;

cradle means mounted on the first and second side support members, respectively for removably supporting the first and second applicator rollers in the movable frame;

power transfer means coupled to the applicator rollers for rotation thereof.

8. The invention as set forth in claim 7,

the cradle means including a first cradle assembly disposed on the first and second side support members, respectively, and a second cradle assembly disposed on the first and second side support members, respectively;

the first applicator roller is mounted for rotation on the first cradle assembly; and

the second applicator roller is mounted for rotation on the second cradle assembly.

9. The invention as set forth in claim 1 wherein a container means for containing liquid ink or coating material and means for applying ink or coating material from the container means to a peripheral surface portion of the first and second applicator rolls is provided and supported by the printing apparatus.

10. The invention as set forth in claim 9 wherein the container means comprises a doctor blade assembly having a reservoir or fountain pan for supplying ink or coating material to each of said applicator rollers, and having a doctor blade disposed for wiping engagement with each of said applicator rollers when it is received in rolling contact with ink or coating material in the reservoir or pan.

11. The invention as set forth in claim 9, wherein the container means comprises a fountain pan and the inking applying means comprises a pan for transferring ink or coating material from the fountain pan to said first and second applicator rollers.

12. A rotary offset printing press having a printing unit of the type having a delivery side and a dampener side, said dampener side having a dampener space for receiving a dampener, comprising, in combination:

a plate cylinder mounted on the printing unit between the delivery side and the dampener side, and a printing plate mounted on the plate cylinder;

a blanket cylinder having an ink or coating receptive blanket disposed in ink or coating transfer engagement with the plate for transferring ink or coating material from the image surface areas of the printing plate to the ink or coating receptive blanket;

an impression cylinder disposed adjacent the blanket cylinder thereby forming a nip between the blanket and the impression cylinder whereby the printing ink or coating material is transferred from the blanket to a substrate as the substrate is transferred through the nip;

support means mounted on the dampener side of the printing unit;

an inking or coating apparatus having a removable first applicator roller and a removable second applicator roller, being positioned in the dampener space in place of a dampener, the inking or coating apparatus being coupled to the support means for movement between an on-impression operative position and an off-impression retracted position wherein the first applicator roller is adjustably supported for movement into and out of ink or coating association with the plate on the plate cylinder while the second applicator roller is adjustably supported for simultaneous movement into and out of ink or coating association with the blanket on the blanket cylinder; and

whereby a continuous or spot film of ink or coating can be applied by the inking and coating apparatus to a plate on the plate cylinder and a blanket on the blanket cylinder and ink or coating can be selectively applied to the plate on the plate cylinder or the blanket cylinder blanket or a plate thereon.

13. The invention as defined in claim 12 wherein the plate cylinder, blanket cylinder, impression cylinder and inking or coating apparatus forms a first printing unit, the printing press having a second printing unit for printing or coating the substrate subsequently to the first printing unit, the printing press further including:

- a dryer mounted on the printing press for discharging heated air onto a freshly printed or coated substrate from the first printing unit before the freshly printed or coated substrate is subsequently printed, coated or otherwise processed in the second printing unit.
14. The invention as defined in claim 13 wherein:
the dryer is mounted adjacent to the impression cylinder for discharging heated air onto a freshly printed or coated substrate while the substrate is in contact with the impression cylinder.
15. The invention as defined in claim 13 comprising:
an extractor coupled to the dryer for extracting hot air, moisture, odors and volatiles from an exposure zone between the dryer and the freshly printed or coated substrate.
16. The invention as defined in claim 12 wherein the printing press has an interunit position, comprising:
a transfer cylinder disposed in the interunit position on the press and coupled in sheet transfer relation with the impression cylinder; and
an interunit dryer disposed adjacent the transfer cylinder for discharging heated air onto a freshly printed or coated substrate after it has been transferred from the impression cylinder and while it is in contact with the transfer cylinder.
17. A printing press as defined in claim 12 wherein the plate cylinder, blanket cylinder, impression cylinder, support means and inking or coating apparatus form a first printing unit, the printing press having a second printing unit including a plate cylinder, a blanket cylinder and an impression cylinder in operable combination, further including:
a transfer drum coupled in substrate transfer relation with the impression cylinder of the first printing unit and in substrate transfer relation with the impression cylinder of the second printing unit;
a first dryer mounted adjacent the impression cylinder of the first printing unit for discharging heated air onto a freshly printed or coated substrate while the substrate is in contact with the impression cylinder of the first printing unit;
a second dryer mounted adjacent the transfer drum for discharging heated air onto a freshly printed or coated substrate after it has been transferred from the impression cylinder of the first printing unit and while it is in contact with the transfer drum; and,
a third dryer disposed adjacent the impression cylinder of the second printing unit for discharging heated air onto a freshly printed or coated substrate after it has been transferred from the transfer drum and while it is in contact with the impression cylinder of the second printing unit.
18. The invention as defined in claim 12 wherein the inking or coating apparatus includes:
first cradle means for supporting the first applicator roller for engagement with the plate when the inking or coating apparatus is in the operative position; and,
second cradle means for supporting the second applicator roller for engagement with the blanket when the inking or coating apparatus is in the operative position.
19. The invention as defined in claim 12, said support means comprising:
first and second pivot means mounted on the first and second side frame members, respectively.

20. The invention as defined in claim 12, further comprising:
a power actuator pivotally coupled to the inking or coating apparatus, the power actuator having a power transfer arm which is selectively extendable or retractable; and,
apparatus coupled to the power transfer arm and to the inking or coating apparatus for converting extension or retraction movement of the power transfer arm into pivotal movement of the inking or coating apparatus relative to the printing unit.
21. The invention as defined in claim 12 further comprising:
a bell crank plate having a first end portion coupled to the inking or coating apparatus and having a second end portion for engaging a stop member; and,
a stop member secured to the inking or coating apparatus for engaging the second end portion of the bell crank plate.
22. The invention as defined in claim 1 or 12 wherein the inking or coating apparatus comprises:
the first applicator roller having a resilient transfer surface.
23. A printing press as defined in any one of claims 1 or 12 including:
a supply container for containing a volume of liquid ink or coating material;
circulation means coupled between the supply container and the inking or coating apparatus for inducing the flow of liquid ink or coating material from said supply container to the inking or coating apparatus and for returning liquid ink or coating material from the inking or coating apparatus to the supply container; and,
heat exchanger means coupled to the circulation means for maintaining the temperature of the liquid ink or coating material within a predetermined temperature range.
24. A printing press as defined in any one of the claims 1 or 12 wherein the inking or coating apparatus comprises:
a fountain pan for containing a volume of liquid ink or coating material;
an applicator roller having a metering surface; and,
a pan roller mounted for rotation in the fountain pan and coupled to the applicator roller for transferring ink or coating material from the fountain pan to the applicator roller.
25. A printing press as defined in any one of claims 1 or 12 characterized in that:
a resilient packing is mounted on the blanket cylinder, and
a printing plate is mounted on the resilient packing.
26. A printing press as defined in any one of claims 1 or 12 further including means for applying ink or coating material to the first and second applicator rollers, and the inking or coating apparatus is pivotally mounted on the printing unit in a position in which the nip contact point between the applicator rollers and the blanket and plate cylinders is offset with respect to a radius line projecting through the center of the plate cylinder and blanket cylinder to the axis of pivotal motion of the inking or coating apparatus.

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United States Patent [19]

DeMoore

[11] 4,402,267

[45] Sep. 6, 1983

[54] METHOD AND APPARATUS FOR HANDLING PRINTED SHEET MATERIAL

[75] Inventor: Howard W. DeMoore, Dallas, Tex.

[73] Assignee: Printing Research Corporation, Dallas, Tex.

[21] Appl. No.: 242,715

[22] Filed: Mar. 11, 1981

[51] Int. Cl.³ B41F 21/00[52] U.S. Cl. 101/419; 101/422;
101/426; 118/DIG. 15[58] Field of Search 101/42.2, 416 R, 417,
101/418, 419, 426; 29/120, 130, 131, 121.3;
118/DIG. 15

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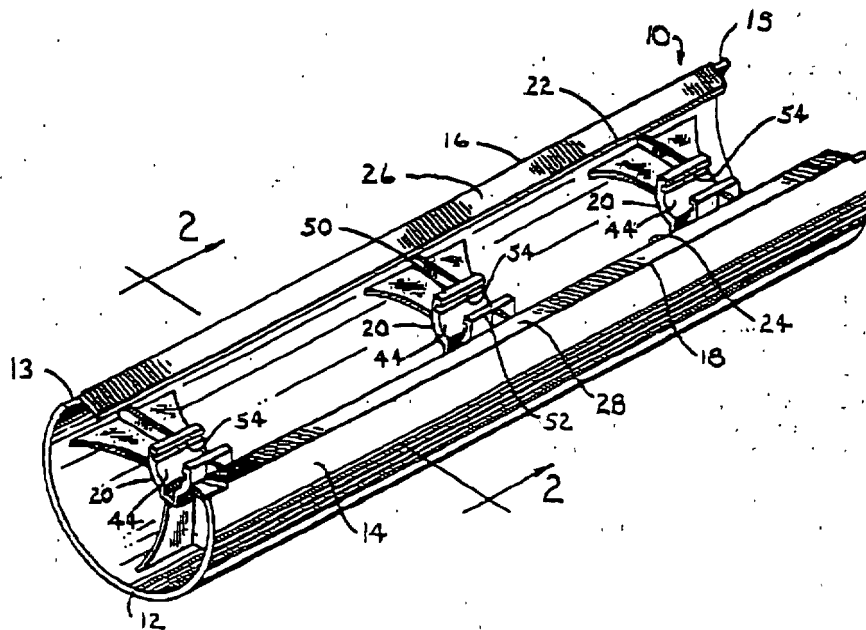
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Attorney, Agent, or Firm—Fulwider, Patton, Rieber, Lee & Utcht

[57] ABSTRACT

A skeleton wheel or cylinder for supporting freshly printed sheet material between printing stations or at the delivery station of a printing press is provided with a loosely retained ink repellent fabric covering for supporting and conveying the sheet material without transfer of wet ink from one sheet to a successive sheet and without smearing the ink or indenting the surface of the sheet material. The circumferential surface of the skeleton cylinder is provided with a coating of a fluorocarbon plastic having a fabric base portion bonded to the surface of the cylinder structure. The low friction properties of the coating permit ease of shuffling movement of the fabric covering and the coating structure provides a cushioning effect to prevent smearing or indenting the sheet material by the fabric cover. The improved cylinder is provided with a plurality of retaining plates slidably fitted in axially spaced hub portions of the cylinder which plates are each locked in place by a set screw. The rim portion of the cylinder includes opposed parallel flanges on which the opposite ends of the fabric covering may be removably retained.

25 Claims, 4 Drawing Figures



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Sep. 6, 1983

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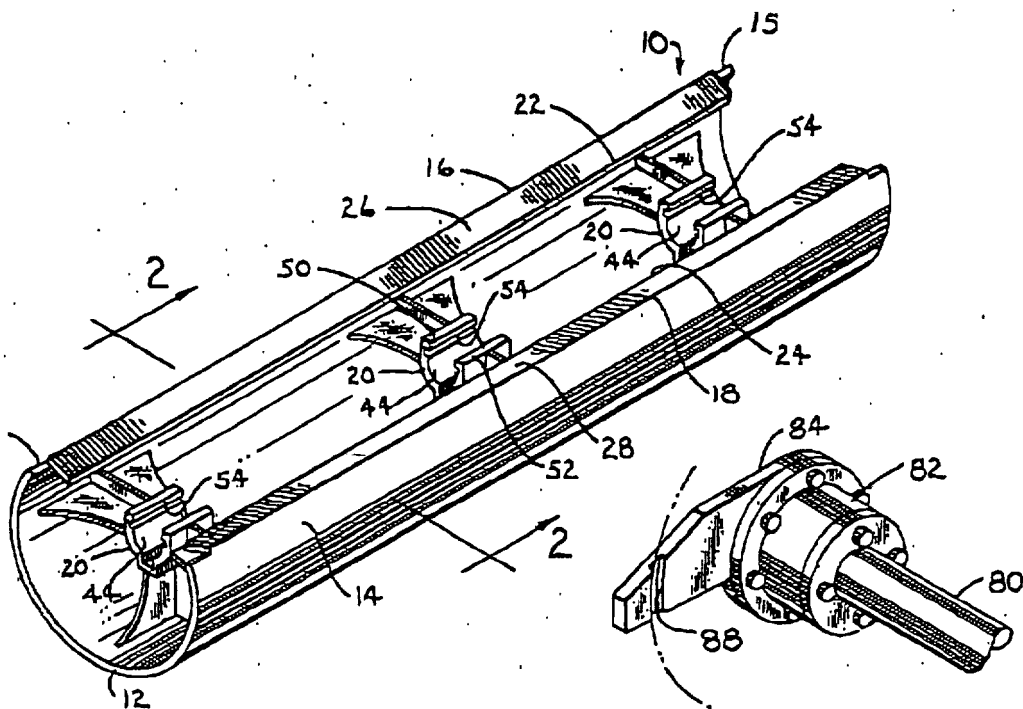


FIG. 1

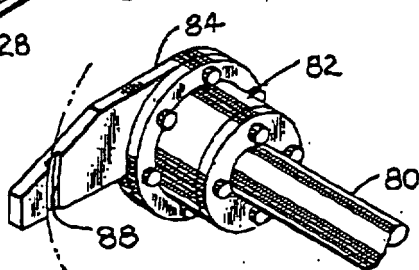


FIG. 4

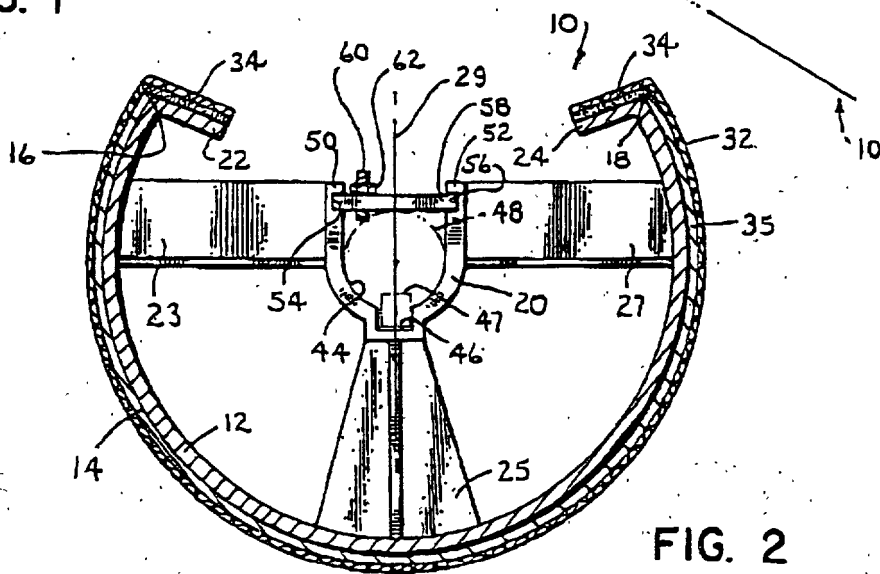


FIG. 2

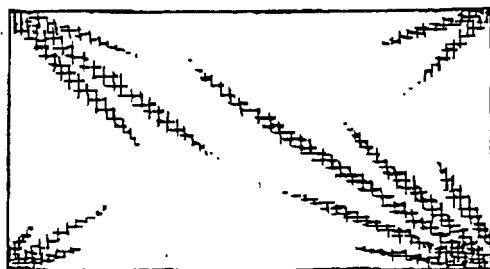


FIG. 3

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METHOD AND APPARATUS FOR HANDLING PRINTED SHEET MATERIAL

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention pertains to a method and apparatus for providing improved support for freshly inked sheet material in a printing press or the like.

2. Background Art

It has been traditional in the art of printing press apparatus and the like to provide devices for supporting freshly inked sheet material when transferring the material from one printing station to another or when handling the sheets as they are delivered from the press wherein said devices comprise wheels of relatively narrow width and characterized by having circumferentially spaced teeth. Such devices are known by the term skeleton wheels in the printing press art. The problems inherent in handling freshly inked printed sheets and the like by skeleton wheels have been longstanding. In order to minimize the contact area between the skeleton wheels and the printed sheet traditional thinking led to the provision of wheels in the form of relatively thin disks having a toothed or serrated circumference. However, these types of wheels have not overcome the problems of smearing and marring the inked surface of the sheet material due to sliding action between the material and the projections or serrations. Moreover, the attempts to minimize the surface area in contact with the sheet material has also resulted in actual indenting or dimpling of the material itself.

Various efforts have been made to overcome the disadvantages of thin disk skeleton wheels. One of the more successful approaches has been completely contrary to the concept of minimizing the surface area. This more recent development is disclosed and claimed in my U.S. Pat. No. 3,791,644 wherein I provide for a substantially cylindrical drum or roller coated with an improved ink repellent surface comprising a layer of polytetrafluoroethylene. Although this improved skeleton wheel has been commercially successful, with continuous use such as is common in many commercial printing operations, there is over a period of time a slight accumulation of ink on the surface of the wheel.

In high speed commercial printing equipment, for example, it has been determined that in order to provide satisfactory printing quality the surface of the coated wheel must be washed relatively frequently with a solvent to remove any ink accumulation. Moreover, it has also been determined that the TFE coated wheels do not provide a cushioning effect which is important for the tightly stretched sheet material as it engages and is supported by the skeleton wheel.

In accordance with the present invention the problems with the prior art thin disk and other type skeleton wheel concepts have been overcome with a skeleton wheel of relatively great width and with an improved ink repellent and supportive structure which may be used in conjunction with the teaching of U.S. Pat. No. 3,791,644 as well as further improvements which I have made in support and handling apparatus for handling freshly inked sheet material.

SUMMARY OF THE INVENTION

The present invention provides an improved method for handling sheet material which has been freshly inked or printed on at least one side wherein the sheet

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material is supported by a cylindrical roller or skeleton wheel which has mounted on a cylindrical surface thereof a relatively loose woven fabric or the like. In accordance with one aspect of the present invention there is provided a method for handling freshly printed sheet material in a printing press delivery apparatus or the like wherein a cylindrical roller or skeleton wheel has mounted on the support surface of the wheel a woven fabric of cotton or the like and which is relatively loosely supported on the support surface of the wheel. In accordance with another aspect of the present invention there is provided a method of supporting freshly printed sheet material or the like by means of a cylindrical skeleton wheel or roller having a support surface for a relatively lightweight fabric which is provided by a liquid repellent material of low friction characteristics such as one of the fluoroplastics or the like.

In accordance with another aspect of the present invention there is provided an improved skeleton wheel or roller for a printing press which includes a fabric covered supporting surface for engaging freshly printed sheet material or the like. In a preferred embodiment of the present invention the fabric covering for the skeleton wheel or roller comprises a lightweight cotton fabric or the like treated with a suitable liquid repellent. The fabric is relatively loosely supported on the surface of the cylinder or wheel to accommodate any slight relative movement between the sheet material and the skeleton wheel without marring the freshly inked surface or damaging the sheet material itself. The improved support roller or skeleton wheel of the present invention also contemplates a supporting surface for the fabric covering which may include a low friction fluoropolymer layer.

In accordance with another aspect of the improved skeleton wheel of the present invention the cylindrical support surface for the fabric covering may comprise a coated or impregnated fabric bonded to the cylindrical wheel surface and forming a supporting surface for the loosely secured fabric covering which is directly engageable with the sheet material.

The present invention provides a substantially improved yet simple and reliable handling apparatus and method in the form of a skeleton wheel for printing equipment and the like which is adapted to support sheet material including freshly inked surfaces thereof, without smearing or marking the printed surface and without damaging the sheet material itself. The improved fabric covered skeleton wheel of the present invention is easily installed on a printing press and the fabric covering is easily removed for cleaning or replacement as needed. Those skilled in the art will recognize these advantages as well as other superior features of the present invention upon reading the detailed description which follows in conjunction with the drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view of the improved skeleton wheel of the present invention before application of the coating and fabric covering.

FIG. 2 is a detail section view taken along the line 2-2 of FIG. 1 showing the layers of materials covering the circumferential surface of the wheel;

FIG. 3 is a plan view of a piece of fabric covering adapted for mounting on the skeleton wheel of the present invention; and

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FIG. 4 is a detailed perspective view of a portion of a press adapted to use the skeleton wheel of the present invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

The improved method and apparatus for handling sheet material in accordance with the present invention is used in a preferred form on high speed printing equipment of the type used, for example, in off-set printing. Such equipment may include one or more support rollers or wheels for handling the sheet material between printing stages and upon delivery of the printed material to a discharge magazine or stack. The particular location of the improved skeleton wheel or roller of the present invention in a typical printing press is believed to be readily understandable to those skilled in the art. Accordingly, a detailed description of the printing press is not believed to be necessary to a complete understanding of the present invention. In any case, reference may be made to my earlier U.S. Pat. No. 3,791,644 which discloses details regarding the location and function of a skeleton wheel for a typical multistation printing press. The present invention may, of course, be utilized with printing presses having any number of printing and delivery stations.

Referring to FIG. 1 of the drawings there is illustrated an elongated member or skeleton wheel generally designated by the numeral 10 comprising the improved skeleton wheel or roller in accordance with the present invention. The skeleton wheel 10 is characterized by a partial cylindrical rim portion 12 which is adapted to be mounted on a press adjacent apparatus, not shown, such as delivery grippers or the like. Accordingly, the outer cylindrical surface 14 of the rim portion 12 has an opening extending the axial width of the skeleton wheel defined by leading and trailing edges 16 and 18, respectively. The skeleton wheel 12 includes a plurality of spaced apart hub portions 20 which may be integrally formed with the rim 12 to comprise a one piece integral casting of aluminum, for example. The hub portions 20 are connected to the rim portion 12 by webs 23, 25 and 27 and are adapted to provide for supporting the skeleton wheel rigidly secured for rotation on a shaft on a printing press in a manner similar to the mounting arrangement disclosed in U.S. Pat. No. 3,791,644 or by an improved arrangement to be discussed herein. As shown in FIG. 1, the skeleton wheel 10 includes opposed elongated integral flange portions 22 and 24 which extend generally inwardly from the surface 14 of the rim 12. The flange portions 22 and 24 include elongated flat surfaces 26 and 28 provided for a purpose to be described further herein.

Referring now to FIG. 2 of the drawings there is illustrated in detail the improved surface construction of the skeleton wheel of the present invention including the fabric covering providing supporting contact with the printed side of a piece of sheet material while conveying the sheet toward a printing station or toward the press delivery magazine. Although the fluoroplastic covered skeleton wheel disclosed in my previous patent provided improvements in handling freshly inked sheet material I have discovered that, unexpectedly, the provision of a layer of fabric on the supporting surface of the skeleton wheel and rather loosely secured thereto further enhances the ability of the skeleton wheel to support and convey successive sheets of printed material with wet ink thereon without transferring the wet

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ink from a previous sheet to a successive sheet and without marring or depressing the surface of the paper. In accordance with the present invention it has been determined that a woven fabric, preferably cotton, of a relatively loose weave on the order of what is commonly known as gauze has produced the unexpected improvement in a method and apparatus for handling printed material that has wet ink on the surface thereof as it passes over and is supported by the skeleton cylinder. A suitable fabric in accordance with the present invention and illustrated in the embodiment of FIG. 3 comprises a loosely woven, lightweight cotton material such as gauze. A cloth having a forty count or forty mesh, such as the piece of fabric 32 illustrated in FIGS. 2 and 3, treated in accordance with the present invention and attached to the surfaces of the flanges 22 and 24 in a suitable manner has produced the unexpected improvement in the handling of printed sheet material in printing presses and the like. The piece of fabric 32 is preferably of rectangular shape dimensioned to completely cover the outer cylindrical surface of the rim 12.

A preferred method of preparing the fabric piece 32 in accordance with the present invention involves washing the fabric in water in the presence of a suitable fabric softener dissolved therein in rather liberal quantities. One suitable fabric softener which has been used in preparation of the fabric piece 32 is manufactured under the trademark "DOWNY" and, in the washing process, two to three times the normal recommended quantity of softener has been used for washing the fabric in plain water. After washing the fabric piece 32 and allowing same to dry a suitable fabric protector is applied to enhance the liquid repellancy characteristics of the material. A preferred type of fabric protector is, manufactured under the trademark SCOTCHGARD by the 3M Manufacturing Company, Minneapolis, Minn. as their Part No. FC4101-C-12. Moreover, it has been determined that even though some ink will accumulate on the surface of the fabric threads over an extended period of operating time the provision of the fabric protector permits the occasional rubbing or agitation of the fabric by the press operator in place on the skeleton cylinder to break loose and remove dried ink particles or crystals which have accumulated on the fabric without requiring removal and washing of the fabric piece.

Referring to FIG. 2 a suitable method of attaching the fabric piece 32 to the outer surface of the rim 12 is by a double sided adhesive tape strip 32 disposed on and extending the length of each of the respective surfaces 26 and 28. Another suitable method of attaching the fabric piece 32 would be by the use of fastener strips such as of the type made under the trademark VELCRO. Those skilled in the art will appreciate that other means may be provided for attaching the fabric piece 32 to the flanges 22 and 24, however, the abovementioned methods provide for quickly attaching and removing the fabric piece 32 with respect to the wheel 10.

An important aspect of the present invention concerns the type of fabric support surface provided on the rim 12 and overlying the surface 14. The improved surface is preferably of a low coefficient of friction such as may be provided by coating the metal surface 14 of the cylinder with a fluoroplastic as taught by U.S. Pat. No. 3,791,644. Although the combination of the coating described in the abovementioned patent together with the fabric member 32 attached thereover provides suitable performance it has been discovered that the fabric covering for the skeleton wheel 10 per-

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forms somewhat better in eliminating any marring or depressions in the surface of the sheet material by the application of a coating including a fabric reinforcement as will be described herein.

Referring to FIG. 2 the rim portion 12 of the skeleton wheel 10 is provided with a coating 35 comprising a fluorocarbon composite coating material applied in one or more coats over a fabric base which is adhesively bonded to the cylindrical circumferential 14 of the rim portion 12. It is believed that the provision of the fabric base for the coating such as described herein provides a cushioning effect for the fabric piece 32 which is applied over the coating 35 and which reduces the tendency for the fabric piece 32 to indent or form depressions in the surface of the sheet material as well as substantially preventing the transfer of wet ink from one sheet to a successive sheet.

In a preferred method of preparing and forming the coating 35 a suitable piece of fabric such as cotton canvas of approximately 0.022 inch nominal thickness and having a waterproofing applied to one side thereof is cut somewhat oversize, approximately 4 to 5 inches all around, from the actual size required to cover the entire surface 14. The fabric is then suitably lapped to a substantially flat and smooth preparation surface to prevent movement or shrinkage while a first coat of the fluoropolymer or fluorocarbon material is applied thereto. A preferred composition for providing the coating 35 is a liquid fluoropolymer coating made under the trademark XYLAN by the Whitford Corporation, Westchester, Pa. A satisfactory coating material of the type referred to hereinabove is XYLAN 1010 composite type coating material which is self curing at room temperature.

After the aforesaid fabric base is temporarily fastened to a suitable surface with the waterproof side facing said surface the non waterproofed side of the fabric is sanded lightly with a 220 grit paper to bring out the nap of the fabric. One coat of XYLAN 1010 coating material is then applied to the aforesaid fabric and allowed to cure at room temperature. Once the first coating layer has been allowed to dry the coated fabric is removed from the temporary preparation surface and bonded to the surface 14 of the rim 12 using a suitable adhesive such as a contact cement made by 3M Corporation. The surface of the coated fabric piece which is applied to the surface of the rim portion 12 is the waterproofed side. The surface 14 is normally prepared for application of the adhesive in the prescribed manner to be clean and dry. Care should be taken to roll out the coated fabric piece of the coating 35 when it is applied to the surface 14 to prevent entrapment of air bubbles or the like.

After the adhesive is allowed to dry the fabric is trimmed to size and additional coatings of the fluoropolymer are applied and allowed to dry between coats. A suitable coating 35 is formed by the application of three additional layers of XYLAN 1010 coating material after the fabric base has been bonded to the surface of the rim 12. The surface formed by the coating 35 is preferably sanded lightly between each coat of fluoropolymer with, for example, 400 grit finishing paper.

The preparation of the surface coating 35 as aforescribed provides a substantially glazed surface with a low coefficient of friction which is ink repellent and also provides for ease of movement of the fabric piece 32 when the same is attached to the cylinder 10. Although, in accordance with the present invention, the fluoropolymer coating described is particularly advan-

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tageous it is contemplated that other low friction plastic coatings may be applied to the aforementioned fabric base to produce a suitable surface for the fabric member 32. The particular fluorocarbon type coating of the general class of coatings referred to herein has produced the unexpected improvement of reducing ink transfer of one sheet to another in high speed printing equipment and has also, in combination with the fabric member 32, reduced depressing or indenting of the paper surface of the sheets. After the coating 35 has been prepared the fabric piece 32 is applied to the flanges 22 and 24 by the adhesive stripes 34 or other suitable fastening means loose enough so that with normal finger pressure the fabric may be locally moved over the surface of the coating 35 in all directions at least one eighth inch to one inch. Moreover, in printing presses in which the drive train has become loose with wear, for example, relative movement between the press impression cylinder and the skeleton wheel will not result in smearing of the ink thanks to the movability of the fabric covering with respect to the cylinder rim.

The improved skeleton wheel or cylinder of the present invention also includes improved means for attaching the wheel to the associated driving shaft of the printing press. Referring to FIGS. 1 and 2, the spaced apart hub portions 20 are provided with semi-cylindrical support surfaces 44 which are intersected by a suitable keyway 46 in which may be disposed a key 47 for drivingly engaging the skeleton wheel 12 with a press drive shaft indicated by the numeral 48 in FIG. 2. The hub portions 20 are provided with an improved retention means for mounting the skeleton wheel 10 on the shaft 48. The spaced apart hub portions 20 are each formed with integral axially extending bosses 50 and 52 spaced apart sufficiently to allow the skeleton wheel to be slipped radially on and off of the shaft 48. The bosses 50 and 52 are provided with opposed axially extending slots 54 and 56, respectively, which are aligned with each other to permit the insertion of a retaining plate 58. The retaining plate 58 is preferably of a length slightly less than the span between the bottoms of the grooves 54 and 56 so that the plate fits snugly in the respective grooves. The plate is preferably of a width equal to the axial length of the bosses 50 and 52. As shown in FIG. 2, the retaining plate 58 is provided with a socket head lock screw 60 threadedly engaged with the retaining plate and provided with a suitable lock nut 62. The lock screw 60 is offset from the center line which bisects the opening between the spaced apart bosses 50 and 52.

The lock screws 60 are adapted to be tightened to engage the periphery of the shaft 48 to prevent axial sliding of the skeleton wheel 10 with respect to the shaft and to permit minor radial adjustment of the skeleton wheel with respect to the shaft. When installing the cylinder 10 on the shaft 48 or removing the cylinder from the shaft the improved retaining plate 58 may be inserted in and removed from the respective grooves 54 and 56 followed by tightening or loosening of the screws 60, as the case may be, to provide a simplified arrangement for mounting and removing the cylinder with respect to the associated press drive shaft. The leading and trailing edges 16 and 18 are advantageously disposed substantially equidistant from the centerline 29 so that in some applications the skeleton wheel 10 can be turned end for end when the leading edge becomes worn or damaged.

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Another feature of the present invention which has permitted improved retrofitting of a skeleton wheel such as the wheel 10 on certain types of press equipment is provided by the axially extending portions 13 and 15 of the rim 12 which extend in opposite directions respectively from the flanges 22 and 24. In certain types of presses such as a model TP-38A made by the Miller Printing Equipment Company one or more stationary side plates are located adjacent ends of the skeleton wheel or cylinder and are positioned such that certain lengths of printed material will overlap the side plates and will be disfigured while being conveyed past the plates under the support of the skeleton wheel because the wheel cannot be moved axially on the shaft to the non printed area of the sheet. However, with the improved skeleton cylinder 10 having the axially extending rim portions 13 and 15, a suitable annular groove may be cut in the side plates to accommodate the axial length of the wheel 10 to thereby substantially support the full length of the sheet material as it is conveyed by the wheel.

Referring to FIG. 4 there is shown a detail view of a portion of a skeleton wheel support shaft 80 similar to the shaft 48. The shaft 80 is supported in a bearing assembly 82 which is bolted to a support assembly including a side plate member 84. The plate 84 is stationary and prevents the use of a skeleton wheel or cylinder having a length substantially equal to the length of the sheet and providing adequate support thereof. However, by forming the annular groove 86 to have radial and axial dimensions with respect to the longitudinal centerline of the shaft 80 sufficient to clear the axial end portions 13 or 15 of the rim 12, the cylinder 10 may be installed on a press equipped as shown to support substantially the entire length of the sheet material.

Those skilled in the art will appreciate that various modifications to the method and apparatus of the present invention may be made without departing from the scope of the invention as defined in the appended claims.

What I claim is:

1. A method for supporting and conveying sheet material which has been freshly printed and discharged from a printing press or the like without marring the freshly inked surface, comprising the steps of:

providing a skeleton wheel having a sheet supporting surface thereon;

providing a piece of fabric;

attaching said piece of fabric to said skeleton wheel to be disposed over at least that part of said surface which supports said sheet material, said piece of fabric being attached relatively loosely to permit and accommodate slight movement between the fabric and the skeleton wheel when the sheet material is supported and conveyed by skeleton wheel and

rotating said skeleton wheel to engage successive sheets of said sheet material in supportive and conveying relationship thereto by said piece of fabric without marring said freshly printed surface.

2. The method as set forth in claim 1 together with the steps of:

providing said piece of fabric of woven cloth.

3. The method set forth in claim 2 wherein:

said cloth is provided of woven substantially gauze-like cotton material on the order of about forty mesh.

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4. The method set forth in claim 1 or 3 together with the steps of:

treating said fabric with a liquid repellent prior to attaching said piece of fabric to said skeleton wheel.

5. The method set forth in claim 4 together with the steps of treating said fabric with a fabric softening material prior to treating said fabric with liquid repellent.

6. The method set forth in claim 1 together with the steps of:

providing an ink repellent coating on said surface for supporting said piece of fabric.

7. The method set forth in claim 6 wherein:

said coating includes a polytetrafluoroethylene.

8. The method set forth in claim 6 together with the step of:

providing a fabric base portion for said coating.

9. In a skeleton wheel for supporting and transferring a freshly printed sheet from a printing station on a printing press or the like without marring the freshly inked surface;

a generally cylindrical rim segment having a generally cylindrical support surface formed thereon; and

a fabric covering disposed over at least a part of said support surface for supportively engaging one side of said sheet during the transfer thereof; and

means for securing said fabric covering to extend relatively loosely over said support surface to permit and accommodate slight movement between the fabric covering and said support surface when the printed sheet is supported and transferred by the skeleton wheel so that the freshly printed sheet is not marred.

10. The invention set forth in claim 9 wherein:

said fabric covering comprises woven substantially gauze-like cotton material on the order of about forty mesh.

11. The invention set forth in claim 10 wherein:

said fabric covering is treated with a liquid repellent.

12. The invention set forth in claim 10 wherein said fabric covering is treated with a fabric softening agent.

13. The invention set forth in claim 9 wherein:

said generally cylindrical support surface is delimited in a circumferential direction by opposed elongated flanges, and said skeleton wheel includes means for removably attaching said fabric covering to said wheel along said flanges.

14. The invention set forth in claim 13 wherein:

said means for attaching includes an adhesive strip mounted on said flanges.

15. The invention set forth in claim 13 wherein:

said rim segment extends axially beyond said flanges for supporting substantially the entire length of said sheet.

16. The invention set forth in claim 9 or 13 wherein:

said surface includes a low friction coating thereon.

17. The invention set forth in claim 16 wherein:

said coating comprises at least one layer comprising polytetrafluoroethylene.

18. The invention set forth in claim 16 wherein:

said coating includes a fabric layer on which at least one layer of a fluoropolymer coating is applied.

19. The invention set forth in claim 18 wherein:

said fabric layer is a woven canvas.

20. A method of supporting and conveying sheet material which has been freshly inked and discharged

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from a printing press or the like without marring the freshly inked surface, comprising the steps of:

forming an ink repellent coating on a sheet supporting surface of a skeleton wheel;

treating a piece of fabric with a fabric softening agent; treating the piece of fabric with a liquid repellent subsequent to treatment with said fabric softening agent;

attaching the piece of fabric to the skeleton wheel to cover the sheet supporting surface, said attaching step including mounting the piece of fabric relatively loosely over the sheet supporting surface such that the piece of fabric is capable of accommodating relative movement between the sheet material and the sheet supporting surface substantially without marring or damaging the freshly inked sheet material; and

rotating the skeleton wheel to engage successive sheets of the sheet material in supportive and conveying relation with the piece of fabric.

21. The method of claim 20 wherein said step of forming an ink repellent coating comprises the steps of applying an ink repellent agent to a fabric base portion and securing the fabric base portion to the skeleton wheel.

22. The method of claim 20 wherein the skeleton wheel sheet supporting surface has a generally cylindrical shape interrupted by an opening extending the axial width of the skeleton wheel, said opening being bounded by a pair of generally radially inwardly di-

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rected flanges, and wherein said attaching step comprises wrapping the piece of fabric about the sheet supporting surface and securing opposite ends of the piece of fabric respectively to the flanges.

23. A skeleton wheel for supporting and transferring a freshly inked printed sheet from a printing station of a printing press or the like without marring the freshly inked surface, comprising:

a wheel member having a generally cylindrical sheet supporting surface with an ink repellent coating formed thereon;

a fabric covering comprising a woven cloth treated with a fabric softening agent and then treated with a liquid repellent agent; and

means for attaching said fabric covering relatively loosely to said wheel member to cover said sheet supporting surface such that said fabric covering is capable of accommodating sufficient relative movement between a printed sheet supported and transferred thereby and said sheet supporting surface substantially without marring or damaging the printed sheet.

24. The skeleton wheel of claim 23 wherein said ink repellent coating comprises a fabric base portion with at least one layer of a fluoropolymer material applied thereon.

25. The skeleton wheel of claim 24 wherein said fabric base portion is formed from a canvas sheet.

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(54) Retractable inking/coating apparatus having ferris movement between printing units

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26, 28) or dedicated coating unit, and is extendable into and retractable out of an operative inking/coating position by a carriage assembly (58) which is pivotally coupled to the printing unit. Because of the pivotal support provided by a cantilevered support arm (88, 90), the inking/coating apparatus is extended and retracted through a Ferris wheel arc between adjacent printing units.

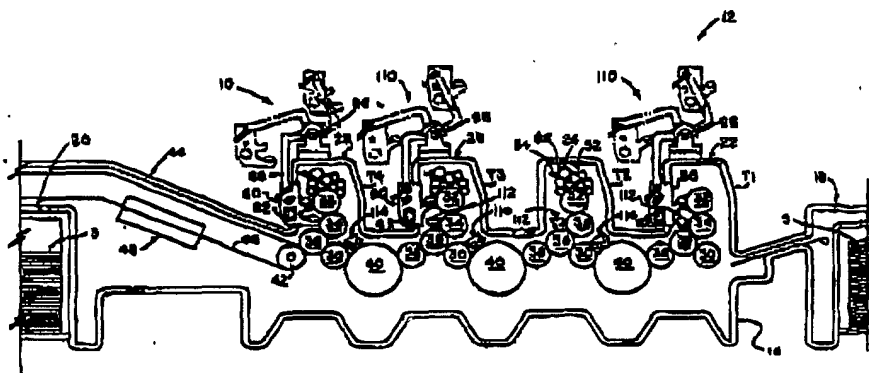


FIG. 1

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EUROPEAN SEARCH REPORT

Application Number
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DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claims	CLASSIFICATION OF THE APPLICATION (INCL. 6)
X Y	US 4 841 903 A (BIRD) * abstract; claims; figure 1 * ---	1,15-17 4-6,8,9, 13	B41F31/30 B41F5/24 B41F23/08
X	US 5 107 790 A (SLIKER ET AL.) * abstract; claim 1; figures * * column 2, line 9 - line 22 *	1,18	
Y	US 5 335 596 A (DEMOORE ET AL.) * abstract; figures 1-4 * * column 7, line 32 - line 58 *	4,5,8,9	
Y	US 4 617 865 A (SWITALL) * abstract; figures 1-3 * * column 6, line 9 - line 42 *	6	
Y	US 4 825 804 A (DIRICO ET AL.) * abstract; figures 2,3 * * column 3, line 10 - line 21 *	13	
A	EP 0 647 524 A (DEMOORE) * abstract; figures 1,2,5 * * column 4, line 32 - line 40 *	15-22	TECHNICAL FIELDS SEARCHED (Int. Cl. 6) B41F
A	PAPIER + KUNSTSTOFF VERARBEITER, vol. 26, no. 6, 1 June 1991, page 129 XP000232825 "LACKIER-AGGREGAT FUER SPEEDMASTER-MASCHINEN" -----	1	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 20 March 1997	Examiner Helpiö, T
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons a : member of the same patent family, corresponding document</p>			

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and retractable out of an operative inking/coating position by a carriage assembly (58) which is pivotally coupled to the printing unit. Because of the pivotal support provided by a cantilevered support arm (88, 90), the inking/coating apparatus is extended and retracted through a Ferris wheel arc between adjacent printing units.

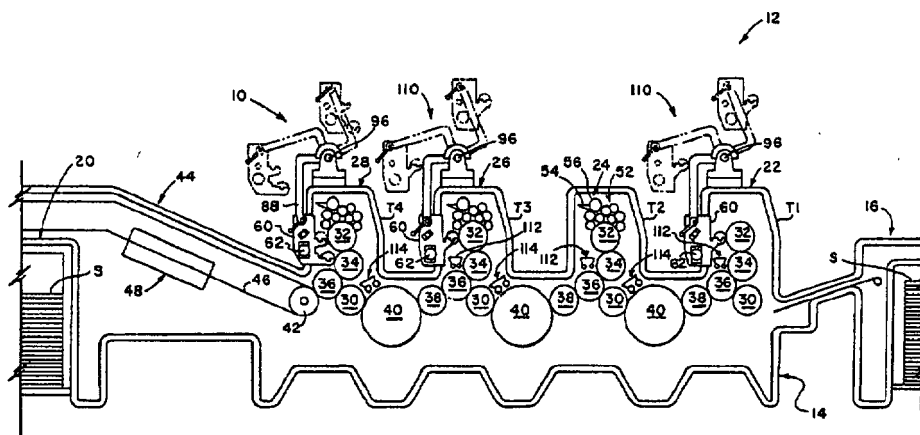


FIG. 1

Description

This invention relates to sheet-fed or web-fed, rotary offset or flexographic printing presses, and more particularly, to a new and improved inking/coating apparatus for the in-line application of printing inks or protective or decorative coatings to sheet or web substrates.

Conventional sheet-fed, rotary offset printing presses typically include one or more printing units through which individual sheets are fed and printed with wet ink. Since the inks used with rotary offset printing presses typically remain wet and tacky for some time after printing, special precautions must be taken to insure that the freshly printed sheets are not marked or smeared as the sheets are transferred from one printing unit to another, and while being conveyed to the sheet delivery stacker. The printed surface of the freshly printed sheet dries relatively slowly and can be smeared during subsequent transfer between printing units. In order to reduce smearing and offsetting, spray powder is applied on the printed sheet.

In some printing applications, offset and smearing are prevented by applying a protective and/or decorative coating over all or a portion of the freshly printed sheets. Various arrangements have been proposed for applying the protective or decorative coating as an in-line operation by using the last printing unit of the press as the coating application unit. However, when such in-line coating is performed, the last printing unit cannot be used to apply ink to the sheets, and can only be used for the coating operation. Thus, while coating with these types of in-line coating apparatus, the press loses the capability of printing its full range of colors since the last printing unit is converted to a coating unit.

It will be appreciated that the time required to reconfigure a press for coating or non-coating is non-productive and costly. Accordingly, there is a need for an in-line coating apparatus that minimizes the time to clean-up from one printing run and set-up and run the next job. Where consecutive jobs require the same type of coating, particularly blanket coating, it may not be necessary to clean-up the coater between jobs. However, the coating material cannot be allowed to dry on the rollers. Therefore, especially when switching from blanket to spot coating or vice versa, or if there is a delay between jobs, it is necessary to wash-up the coater after each job is completed.

In addition, coater wash-up is necessary when switching between different coating compositions, such as aqueous and ultra violet (UV) curable coatings. Such coating materials are not interchangeable, and consequently, the coater must be washed between applications of different coating media.

The foregoing limitations are overcome, according to the present invention, by a retractable, in-line inking/coating apparatus which is mounted on a printing unit for pivotal, Ferris wheel movement between an operative inking/coating position and a retracted, overhead idle position. The inking/coating apparatus

includes an applicator head which, is positioned in alignment with either the plate cylinder or the blanket cylinder by a carriage assembly which includes a cantilevered support arm. The support arm is pivotally coupled between the inking/coating head and the printing unit tower. This cantilevered, pivotal mounting arrangement allows the inking/coating unit to be used between two printing units, as well as on the last printing unit of the press.

In the preferred embodiment, the applicator head includes vertically spaced pairs of cradle members with one cradle pair being adapted for supporting a metal or ceramic coating roller in alignment with a blanket cylinder, and the other cradle pair supporting a resilient anilox coating roller in alignment with the plate cylinder, respectively, when the carriage assembly is in the operative position. Because of the cantilevered, pivotal support provided by the support arm, the applicator head can be lifted and lowered through an arc, similar to Ferris wheel movement, in the limited space between adjacent printing units. When fully retracted, the applicator head and carriage assembly are lifted to an elevated, retracted overhead position, preferably an overhead position overlying the printing unit tower, thus providing complete access to the interstation space and the printing unit cylinders without causing the printing unit to lose its printing capability. The inking/coating applicator roller of the applicator head can be inspected, cleaned or replaced and the doctor blade assembly can be washed-up automatically while the inking/coating apparatus is in the retracted position.

When the inking/coating apparatus is used in combination with a flexographic printing plate and aqueous ink or aqueous coating, the water component of the aqueous ink or coating on the freshly printed sheet is evaporated by a high velocity, hot air interstation dryer and a high volume heat and moisture extractor assembly so that the freshly printed ink or coating is completely dry before the sheet is printed on the next printing unit. This quick drying flexographic printing/coating arrangement permits a base coat of ink, for example opaque white or metallic ink (gold, silver or other metallics) to be applied in the first printing unit, and then overprinted by a lithographic process on the next printing unit.

Exemplary embodiments of the present invention are illustrated in the drawing figures wherein:

FIGURE 1 is a schematic side elevational view of a sheet-fed, rotary offset printing press having inking/coating apparatus embodying the present invention;

FIGURE 2 is a perspective view of the printing press of FIGURE 1 in which a dual head inking/coating apparatus is in the operative coating position and a single head coater is in a retracted, overhead position;

FIGURE 3 is an enlarged simplified perspective view showing one side of the single head ink-

ing/coating apparatus of FIGURE 1 in the operative position;

FIGURE 4 is a simplified side elevational view showing the dual head inking/coating apparatus in the operative coating position for spot or overall coating from the blanket position;

FIGURE 5 is a simplified side elevational view showing the single head inking/coating apparatus in the operative coating position for spot or overall coating from the plate position; and,

FIGURE 6 is a simplified side elevational view of the dual head inking/coating apparatus of FIGURE 4, partially broken away, which illustrates the hydraulic drive assembly and doctor blade assembly.

As used herein, the term "processed" refers to various printing methods which may be applied to either side of a substrate, including the application of UV-curable and aqueous inks and/or coatings. The term "substrate" refers to sheet or web material. Also, as used herein, the term "waterless printing plate" refers to a printing plate having non-image surface areas which are hydrophobic and also having image surface areas which are hydrophilic, wherein the non-image surface areas are characterized by a surface tension value which is less than the surface tension of aqueous ink, and the image surface areas are characterized by a surface tension value which is greater than the surface tension of aqueous ink. "Flexographic" refers to flexible printing plates having a relief surface which is wettable by aqueous ink or aqueous coating material.

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line inking/coating apparatus 10, for applying inks or protective and/or decorative coatings to sheets or webs printed in a sheet-fed or web-fed, rotary offset or flexographic printing press, herein generally designated 12. In this instance, as shown in FIGURE 1, the inking/coating apparatus 10 is installed in a four color printing press 12, such as that manufactured by Heidelberg Druckmaschinen AG of the Federal Republic of Germany under its designation Heidelberg Speedmaster 102V. The press 12 includes a press frame 14 coupled at one end, herein the right end, to a sheet feeder 16 from which sheets, herein designated S, are individually and serially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the freshly printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical rotary offset printing units 22, 24, 26 and 28 which can print different color inks onto the sheets as they are transferred through the press 12. The printing units are housed within printing towers T1, T2, T3 and T4 formed by side frame members 14, 15.

As illustrated, the printing units 22, 24, 26 and 28 are substantially identical and of conventional design. The first printing unit 22 includes an in-feed transfer cyl-

inder 30, a plate cylinder 32, a blanker cylinder 34 and an impression cylinder 36, all supported for rotation in parallel alignment between the press side frames 14, 15. Each of the first three printing units 22, 24 and 26 have an interunit transfer cylinder 38 disposed to transfer the freshly printed sheets from the adjacent impression cylinder to the next printing unit via an interstation transfer cylinder 40. The last printing unit 28 is shown equipped with a delivery cylinder 42 which guides each freshly printed sheet 18 as it is transferred from the last impression cylinder 36 to a delivery conveyor system, generally designated 44, to the sheet delivery stacker 20.

The delivery conveyor system 44 as shown in FIGURE 2 is of conventional design and includes a pair of continuous delivery gripper chains 46, only one of which is shown carrying at regular spaced locations along the chains, laterally disposed gripper bars having gripper fingers for gripping the leading edge of a freshly printed sheet 18 after it leaves the nip between the delivery cylinder 42 and impression cylinder 36 of the last printing unit 28. As the leading edge is gripped by the grippers, the delivery chains 46 pull the freshly printed sheet away from the impression cylinder 36 and deliver the freshly printed sheet to the sheet delivery stacker 20.

Prior to reaching the delivery sheet stacker, the freshly printed and/or coated sheets S pass under a delivery dryer 48 which includes a combination of infrared thermal radiation, high velocity hot air flow and heat and moisture extraction for drying the ink and/or the protective/decorative coating on the freshly printed sheets.

In the exemplary embodiment shown in FIGURE 1, the first printing unit 22 is equipped with a flexographic printing plate, and does not require an inking roller train or a dampening system. If an ink roller train is mounted on the first printing unit, the form rollers are retracted and locked off when the printing unit goes on impression. Flexographic aqueous ink is supplied by the inking/coating unit 110. The remaining printing units 24, 26 and 28 are equipped for lithographic printing and include an inking apparatus 50 having an inking roller train 52 arranged to transfer ink from an ink fountain 54 to the plate cylinder 32. This is accomplished with the aid of a fountain roller 56 and a ductor roller. The fountain roller 56 projects into the ink fountain 54, whereupon its surface is wetted with printing ink Q. The printing ink Q is transferred intermittently to the inking roller train 52 by the ductor roller. The inking roller train 52 supplies printing ink Q to the image areas of a printing plate P mounted on the plate cylinder 32.

The printing ink Q is transferred from the printing plate P to an ink receptive blanket B which is mounted on the blanket cylinder 34. The inked image carried on the blanket B is transferred to a sheet S as the sheet is transferred through the nip between the impression cylinder 36 and the blanket B.

The inking roller arrangement 52 illustrated in FIGURE 1 is exemplary for use in combination with lithographic ink printing plates. It will be understood that

dampening rollers (not illustrated) will be in direct engagement with the lithographic plate P, but are not used in combination with the flexographic plate of printing unit 22.

Referring now to FIGURE 4, FIGURE 5 and FIGURE 6, the in-line inking/coating apparatus 10 includes a carriage assembly 58 which supports an applicator head 60. The applicator head 60 includes a hydraulic motor 62, a lower gear train 64, an upper gear train 65, an applicator roller 66 and a doctor blade assembly 68. The external peripheral surface of the applicator roller 66 is inserted into wetting contact with liquid coating material or ink contained in a reservoir 70. The reservoir 70 is continuously supplied with ink or coating which is circulated through the reservoir 70 from an off-press source by a pump (not illustrated). The hydraulic motor 62 drives the applicator roller 66 synchronously with the plate cylinder 32 and the blanket cylinder 34 in response to an RPM control signal from the press drive (not illustrated) and a feedback signal developed by a tachometer 72. While a hydraulic drive motor is preferred, an electric drive motor can be used.

The applicator roller 66 is preferably a fluid metering anilox roller which transfers measured amounts of printing ink or coating material onto the printing plate or blanket. The surface of an anilox roller is engraved with an array of closely spaced, shallow depressions referred to as "cells". Ink or coating material from the reservoir 70 flows into the cells as the anilox roller turns through the reservoir. The transfer surface of the anilox roller is scraped with a doctor blade 73 to remove excess ink or coating. The ink or coating remaining on the anilox roller is the measured amounts contained within the cells.

The applicator roller 66 is cylindrical and may be constructed in various diameters and lengths, containing cells of various sizes and shapes. The volumetric capacity of an anilox roller is established during manufacturing and is dependent upon the selection of cell size, shape and number of cells per unit area. Depending upon the intended application, the cell pattern may be fine (many small cells per unit area) or coarse (fewer larger cells per unit area).

By applying the ink or coating material through the inking/coating applicator head 60, more ink or coating material can be delivered to the sheet S as compared with the inking roller train of a lithographic printing unit. Moreover, color intensity is stronger and more brilliant because the flexographic ink is applied at a much larger film thickness than can be applied by the lithographic process and is not diluted by dampening solution.

The inking/coating applicator head 60 includes side frame members 74, 76 that support the applicator roller 66, gear train 64, gear train 65, doctor blade assembly 68 and the drive motor 62. The applicator roller 66 is supported at opposite ends on a lower cradle formed by a pair of end plates 78, 80 which hold the applicator roller 66 in parallel alignment with the blanket cylinder 34 (FIGURE 5). The side frames 74, 76 are also pro-

vided with an upper cradle formed by a pair of side plates 82, 84 which are vertically spaced with respect to the lower side plates 78, 80. Each cradle has a pair of sockets 79, 81 and 83, 85, respectively, for holding the applicator roller 66 for spot coating or inking engagement against the plate P of the plate cylinder 32 (FIGURE 4) or the blanket B of the blanket cylinder 34.

Preferably, the applicator roller 66 for the upper cradle (plate) position is an anilox roller having a resilient transfer surface. In the dual cradle arrangement, the press operator can quickly change over from blanket inking/coating and plate inking/coating with minimum press down time, since it is only necessary to remove and reposition or replace the applicator roller 66, and wash-up the doctor blade assembly if changing from ink to coating or vice versa. The capability to selectively operate in either the flexographic mode or the lithographic mode and to print or coat from either the plate or blanket position is referred to herein as the "LITHOFLEX" process.

Referring again to FIGURE 2 and FIGURE 3, the applicator head 60 is supported by the carriage assembly 58 in a cantilevered, pivotal arrangement which allows the dual cradle inking/coating apparatus 10 and a single cradle inking/coating apparatus 110 to be used between any two adjacent printing units, as well as used on the first and last printing units of the press. This is made possible by a pair of cantilevered support arms 88, 90 that are pivotally coupled to the side plates 74, 76, respectively, on a pivot shaft 77. Each support arm has a hub portion 88A, 90A, respectively, and an elongated shank portion 88B, 90B, respectively.

The cantilevered support arms are pivotally mounted on the printing tower by pivot blocks 92, 94, respectively. The hub portions 88A, 90A are journaled for rotation on pivot shafts 96, 98, respectively. The pivot blocks 92, 94 are securely fastened to the tower 14D, so that the carriage assembly 86 is pivotally suspended from the pivot shafts 96, 98 in a cantilevered Ferris support arrangement. The shank portions 88B, 90B are pivotally coupled to the pivot shaft 77, so that the carriage assembly 58 and the applicator head 60 are capable of independent rotation with respect to each other and with respect to the pivot shaft 77. By this arrangement, the applicator head 60 is pivotally suspended from the pivot shaft 77, and remains in an upright orientation as the support arms rotate from the operative position to the fully retracted position, and vice versa.

Thus, the cradles 78, 80 and 82, 84 position the applicator roller 66 in vertical and horizontal alignment with the plate cylinder or blanket cylinder when the applicator head is extended to the operative position, for example as shown in FIGURE 4 and FIGURE 5. Moreover, because of the transverse relationship between the hub portion and shank portion of the support arms, the applicator head 60 and carriage assembly 58 are capable of rotating through a Ferris arc without touching the adjacent printing tower. This makes it possible to install the inking/coating apparatus 10 on any intermedi-

When the inking/coating apparatus is used for applying an aqueous ink or an aqueous coating material, the water component on the freshly printed sheet S is evaporated by a high velocity, hot air interstation dryer and high volume heat and moisture extractor units 112 and 114, as shown in FIGURE 1, FIGURE 4 and FIGURE 5. The dryer/extractor units 112 and 114 are oriented to direct high velocity heated air onto the freshly printed/coated sheets as they are transferred by the interunit and the intermediate transfer cylinders 36, 40. By this arrangement, the freshly printed aqueous ink or coating material is completely dry before the sheet is overprinted in the next printing unit.

The high velocity, hot air dryer and high performance heat and moisture extractor units 112, 114 utilize high velocity air jets which scrub and break-up the moist air level which clings to the surface of each freshly printed sheet. Within each dryer, high velocity air is heated to a high temperature as it flows across a resistance heating element within an air delivery baffle tube. High velocity jets of hot air are discharged through multiple airflow apertures through an exposure zone Z (FIGURE 4 and FIGURE 5) onto the freshly printed/coated sheet S as it is transferred by the transfer cylinder 36 and intermediate transfer cylinder 40, respectively. Each dryer assembly includes a pair of air delivery dryer heads which are arranged in spaced, side-by-side relation as shown in FIGURE 4 and FIGURE 5.

The high velocity, hot moisture-laden air displaced from each freshly printed sheet is extracted from the dryer exposure zone Z and completely exhausted from the printing unit by the high volume extractors. Each extractor head includes a manifold coupled to the dryer heads and draws the moisture, volatiles and high velocity hot air through a longitudinal gap between the dryer heads. According to this arrangement, each printed sheet is dried before it is run through the next printing unit.

The water-based inks used in flexographic printing dry at a relatively moderate drying temperature provided by the interstation high velocity hot air dryers/extractors 112, 114. Consequently, print quality is substantially improved since the aqueous ink is dried at each printing unit before it enters the next printing unit. Moreover, back-trapping on the blanket of the next printing unit is completely eliminated. This interstation drying arrangement makes it possible to print aqueous inks such as metallic ink and opaque white ink at one printing unit, and then overprint at the next printing unit.

This arrangement also permits the first printing unit to be used as a coater in which an aqueous coating is applied to low grade paper, for example recycled paper, to trap and seal in lint, dust, spray powder and other debris and provide a smoother, durable surface that can be overprinted in the next printing unit. The first down coating seals the surface of the low grade, rough substrate and improves overprinted dot definition while preventing strike-through and show-through. A UV-curable

protective and/or decorative coating can be applied over the first down overprinted (aqueous) coating in the last printing unit.

Preferably, the applicator roller 66 is constructed of metal or ceramic when it is used for applying a coating material to the blanket B on the cylinder 34. When the applicator roller 66 is applied to the plate, it is preferably constructed as an anilox roller having a resilient transfer surface for engaging a flexographic printing plate. Suitable resilient roller surface materials include Buna N synthetic rubber and EPDM (terpolymer elastomer).

It will be appreciated that the inking/coating apparatus 10 is capable of applying a wide range of ink types, including fluorescent (Day Glo), pearlescent, metallics (gold, silver and other metallics), glitter, scratch and sniff (micro-encapsulated fragrance), scratch and reveal, luminous, pressure-sensitive adhesives and the like.

The press operator can eliminate the dampener roller assembly altogether, and the inking/coating apparatus 10 can selectively apply aqueous inks and coatings to a flexographic or waterless printing plate and the blanket. Moreover, overprinting of the aqueous inks and coatings can be carried out in the next printing unit since the aqueous inks and coatings are completely dried by the high velocity, hot air interstation dryer and high volume heat and moisture extractor assembly.

The aqueous inks and coatings as used in the present invention contain colored pigments and/or soluble dyes, binders that fix the pigments onto the surface of the printed sheet, and waxes, defoamers and thickeners. Aqueous printing inks predominantly contain water as a solvent, diluent and/or vehicle. The thickeners which are preferred include algonates, starch, cellulose and its derivatives, for example cellulose esters or cellulose ethers and the like. Coloring agents including organic as well as inorganic pigments may be derived from dyes which are insoluble in water. Also, the printing ink may contain water and can be predominantly glycol or the like, with the pigment being bound by an appropriate resin. When metallic inks are printed, the cells of the anilox roller must be appropriately sized to prevent the metal particles from getting stuck within the cells. The cell size is critical, and for metallic gold ink, the anilox roller should have a screen line count in the range of 175-300 lines per inch (69-118 lines per cm).

The inking/coating apparatus 10 can also apply UV-curable inks and coatings. If UV-curable inks and coatings are utilized, ultra-violet dryers/extractors are installed adjacent the high velocity hot air dryer/extractor units 112, 114, respectively.

It will be appreciated that the inking/coating apparatus 10 described herein makes it possible to selectively operate a printing unit in either the flexographic printing mode or the lithographic printing mode, while also providing the capability to print or coat from either the plate or blanket position. The dual cradle support arrangement of the present invention makes it possible to quickly change over from inking/coating at the blanket

cylinder position to inking/coating at the plate cylinder position with minimum press down-time, since it is only necessary to remove and reposition or replace the applicator roller 66 while the printing/inking apparatus is in the retracted position.

Moreover, the press operator may elect to spot or overall coat with aqueous ink/coating from the plate during one job, and then spot and/or overall coat from the blanket during the next job. Since the doctor blade assembly can be flushed and washed-up quickly and the applicator roller can be replaced quickly, it is possible to spot coat or overall coat from the plate position or the blanket position with aqueous inks or coatings during the first press run and then spot coat or overall coat with UV-curable inks or coatings from the plate position or from the blanket position during the next press run. The inking/coating apparatus 10 is completely out of the way in the retracted position; consequently, the doctor blade reservoir and supply lines can be flushed and washed-up by automatic wash-up equipment while the printing unit is printing another job.

The positioning of the applicator head and roller assembly relative to the plate and blanket is repeatable to a predetermined, preset impression position. Consequently, no printing unit adjustment or alteration is required, except for flushing the doctor blade assembly and cleaning or replacing the applicator roller to accommodate a different kind of ink or coating material. Although manual extension and retraction have been described in connection with the exemplary embodiment, extension to the operative position and retraction to a non-operative idle position can be carried out automatically by hydraulic or electric motor servomechanisms.

The Ferris wheel support arrangement allows the inking/coating apparatus to operate effectively in the interstation space between any adjacent printing units, as well as on the first or last printing units of the press, without blocking or obstructing the interstation space or restricting operator access to the cylinders of any of the printing units.

Finally, because the inking/coating apparatus of the present invention is mounted on a printing unit tower and is extendable to the operative position without requiring adjustment or alteration of the printing unit cylinders, it can be used for applying printing ink or coating material to the blanket cylinder of a rotary offset web press, or to the blanket of a dedicated coating unit.

Claims

1. Inking/coating apparatus (10) for use in a printing press (12) of the type having a printing unit (22, 24, 26, 28) on which a plate cylinder (32), a blanket cylinder (34) and an impression cylinder (36) are mounted for rotation, wherein the inking/coating apparatus is characterized by:

an applicator head (60) for applying ink or coating material to a plate (P) mounted on the plate cylinder or to a blanket (B) mounted on the blanket cylinder, either separately or simultaneously when the inking/coating apparatus is in an operative position relative to the plate and blanket cylinders; and,

a carriage assembly (58) for moving the applicator head to the operative position in which the applicator head is disposed laterally adjacent to the plate and blanket cylinders and for moving the applicator head from the operative position to a retracted position in which the applicator head is elevated with respect to the plate and blanket cylinders.

2. Inking/coating apparatus (10) as set forth in claim 1, wherein the carriage assembly (58) is characterized by:

a support arm (88, 90) having a first end portion (88A) constructed for pivotal attachment to the printing unit and having a second end portion (88B) pivotally coupled to the applicator head (60), the applicator head being movable on the support arm to the operative position.

3. Inking/coating apparatus (10) as set forth in claim 1, characterized in that a counterweight (100, 102) is coupled to the carriage assembly.

4. Inking/coating apparatus (10) as set forth in claim 1, wherein the applicator head (60) is characterized by:

a doctor blade assembly (68) having a reservoir (70) for receiving ink or liquid coating material; and,
an applicator roller (66) coupled to the doctor blade assembly in fluid communication with the reservoir, the applicator roller being engagable with a printing plate (P) on the plate cylinder or with a blanket (B) on the blanket cylinder when the applicator head (60) is in the operative position.

5. Inking/coating apparatus (10) as set forth in claim 4, characterized in that the applicator roller (66) is an anilox roller having a resilient transfer surface.

6. Inking/coating apparatus (10) as set forth in claim 1, characterized in that:

a power actuator (104, 106) is movably coupled to the applicator head (60), the power actuator having a power transfer arm (104A, 106A) which is extendable and retractable; and, movement converting apparatus (108) is coupled to the power transfer arm for converting

the applicator roller (66) is selectively mountable for rotation on either the first and second sockets or on the third and fourth sockets for applying ink or coating material to either the plate or blanket when the applicator head is in the operative position.

- 55 **14.** Inking/coating apparatus (10) as set forth in claim 1, wherein the carriage assembly (58) is characterized by an elongated shank portion (88B, 90B) and a hub portion (88A, 90A), the elongated shank portion being pivotally coupled to the applicator head

(60) and the hub portion being constructed for pivotal attachment onto the printing unit.

15. A rotary offset printing press (12) having first and second printing units (22, 24) and the inking/coating apparatus (10) of claim 1 is movably coupled to the first printing unit (22) as set forth in claim 1, characterized by:

a dryer (112) mounted on the first printing unit adjacent the impression cylinder (36) of the first printing unit for discharging heated air onto a freshly printed substrate while the freshly printed substrate is in contact with said impression cylinder.

16. A rotary offset printing press (12) as defined in claim 15, characterized in that:

an extractor (112E) is disposed adjacent the dryer for extracting hot air, moisture and volatiles from an exposure zone (Z) between the dryer and the freshly printed substrate.

17. A rotary offset printing press (12) as defined in claim 15, characterized in that:

an intermediate transfer cylinder (40) is coupled in sheet transfer relation with the impression cylinder (36) of the first printing unit (22); and, an interstation dryer (114) is disposed adjacent the intermediate transfer cylinder for discharging heated air onto a freshly printed or coated substrate after it has been transferred from the impression cylinder of the first printing unit and while it is in contact with the intermediate transfer cylinder (40).

18. A method for rotary offset printing in a printing press (12) of the type including first and second rotary offset printing units (22, 24), and using aqueous or UV-curable printing ink or coating material in the operation of at least the first printing unit, characterized by the following steps performed at each printing unit in succession:

spot or overall coating a plate (P) with aqueous ink/aqueous coating material or UV-curable ink/UV-curable coating material;
spot and/or overall coating a blanket (B) with aqueous ink/aqueous coating material or UV-curable ink or UV-curable coating material;
transferring the printing ink or coating material from the printing plate (P) to the blanket (B);
transferring the inked or coated image from the blanket to a substrate (S) as the substrate is transferred through the nip between the

impression cylinder (36) and the blanket (B); and,

drying the ink or coating material on the freshly printed substrate before the substrate is subsequently processed.

19. A method for rotary offset printing as defined in claim 18, wherein the drying step is characterized by:

discharging high velocity, heated air onto the freshly printed/coated substrate (S) while the freshly printed/coated substrate is in contact with the impression cylinder (36) of the first printing unit (22).

20. A method for rotary offset printing as defined in claim 18, characterized by the steps:

transferring the freshly printed substrate (S) from the first printing unit (22) to an intermediate transfer cylinder (40); and, drying the freshly printed substrate while it is in contact with the intermediate transfer cylinder.

21. A method for rotary offset printing as defined in claim 18, characterized by the step:

extracting hot air, moisture and volatiles from an exposure zone (Z) above the freshly printed/coated substrate (S) while the freshly printed/coated substrate is in contact with the impression cylinder (36).

22. A method for rotary offset printing as defined in claim 18, characterized by the steps:

applying a primer coating of an aqueous coating material or UV-curable coating material to a substrate (S) in the first printing unit (22); and, drying the primer coating on the substrate before the substrate is processed in the second printing unit.

FIG. 1

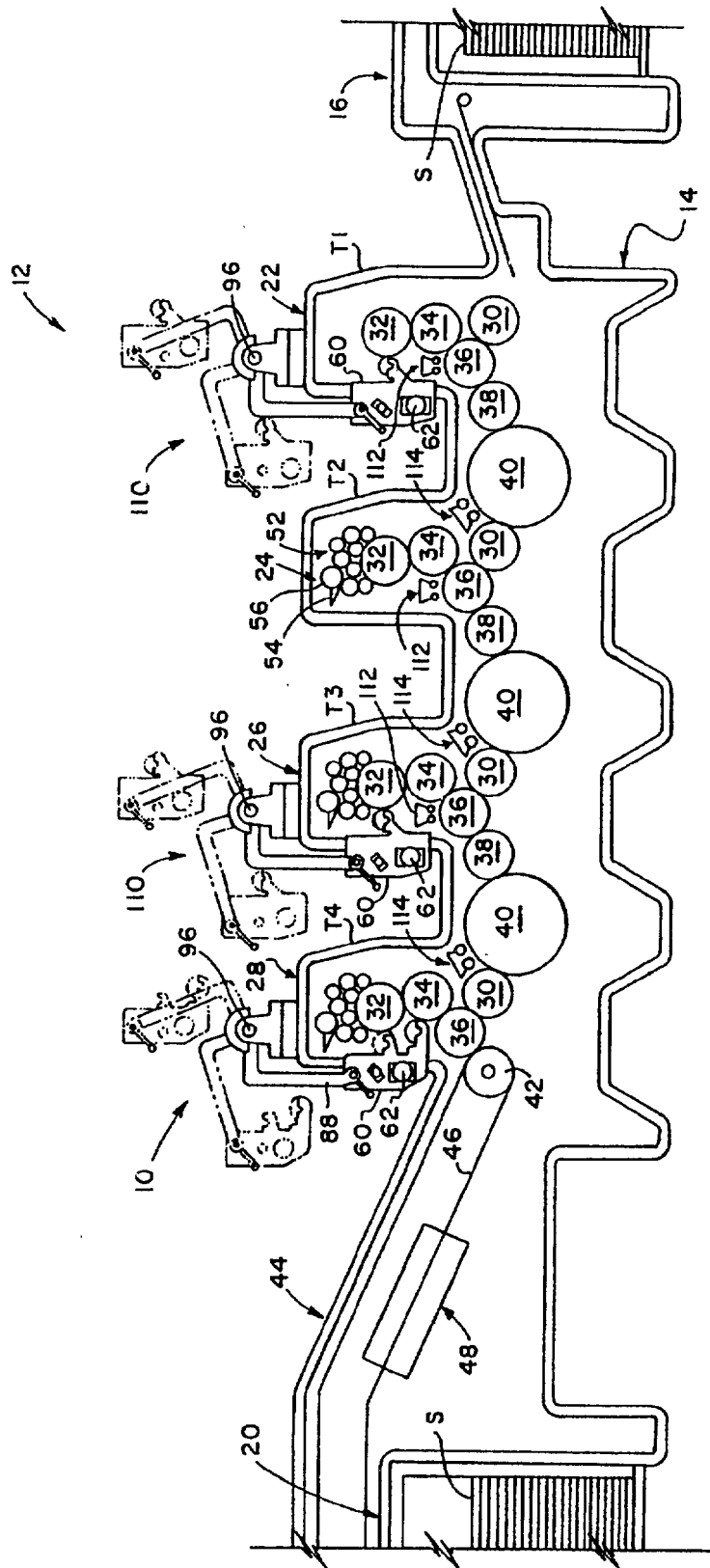


FIG. 1

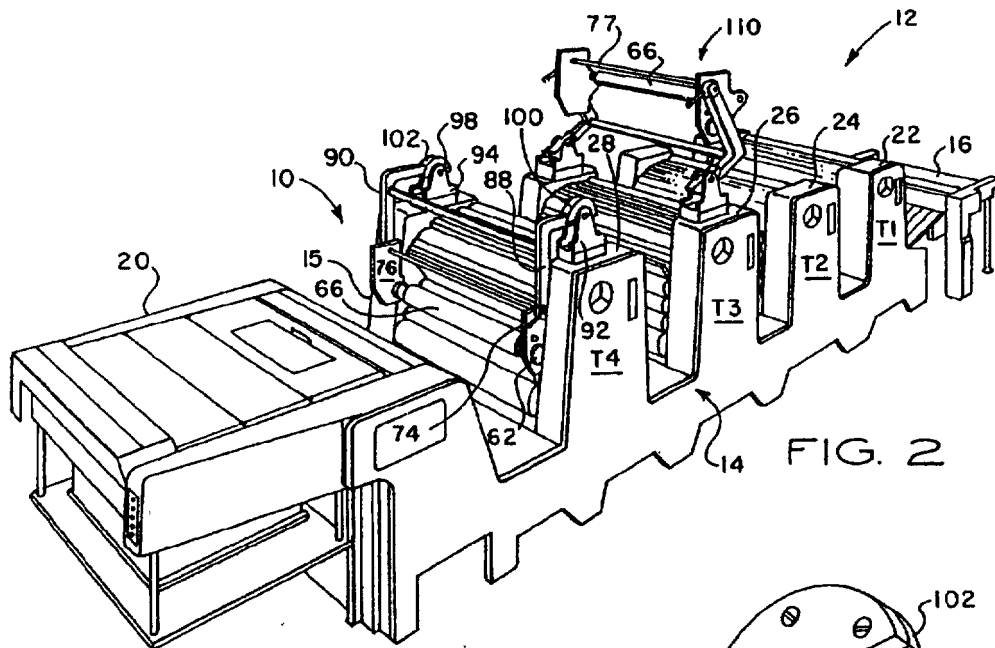


FIG. 2

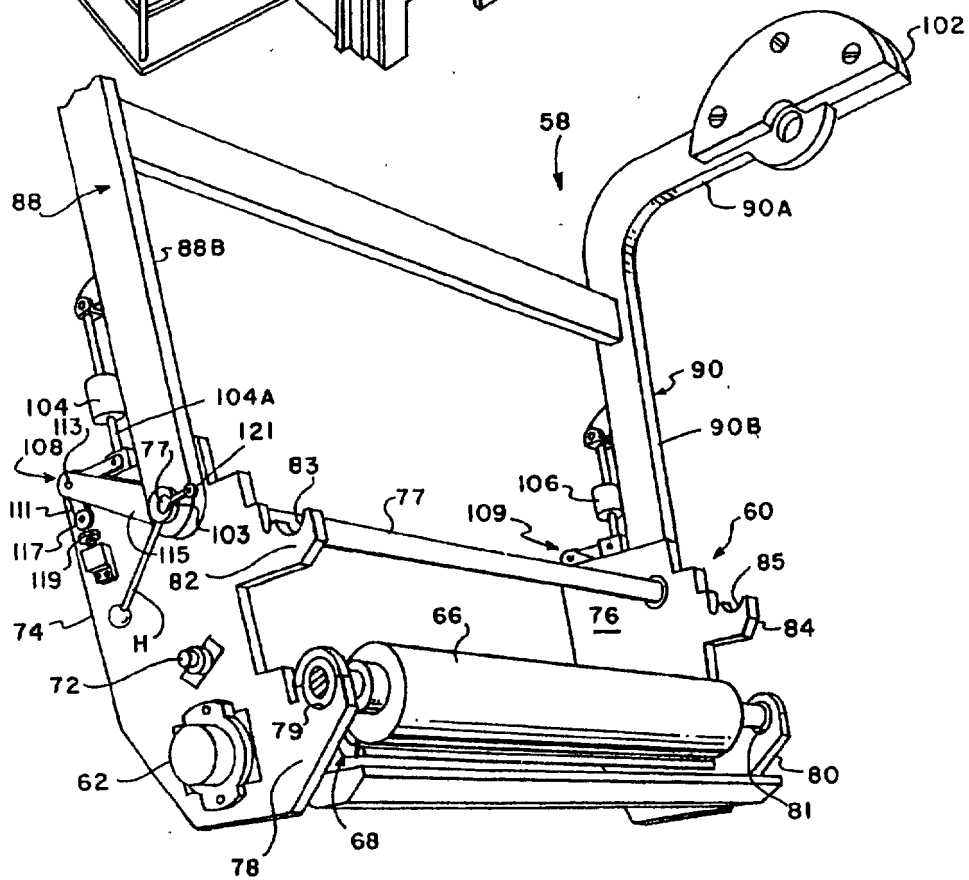


FIG. 3

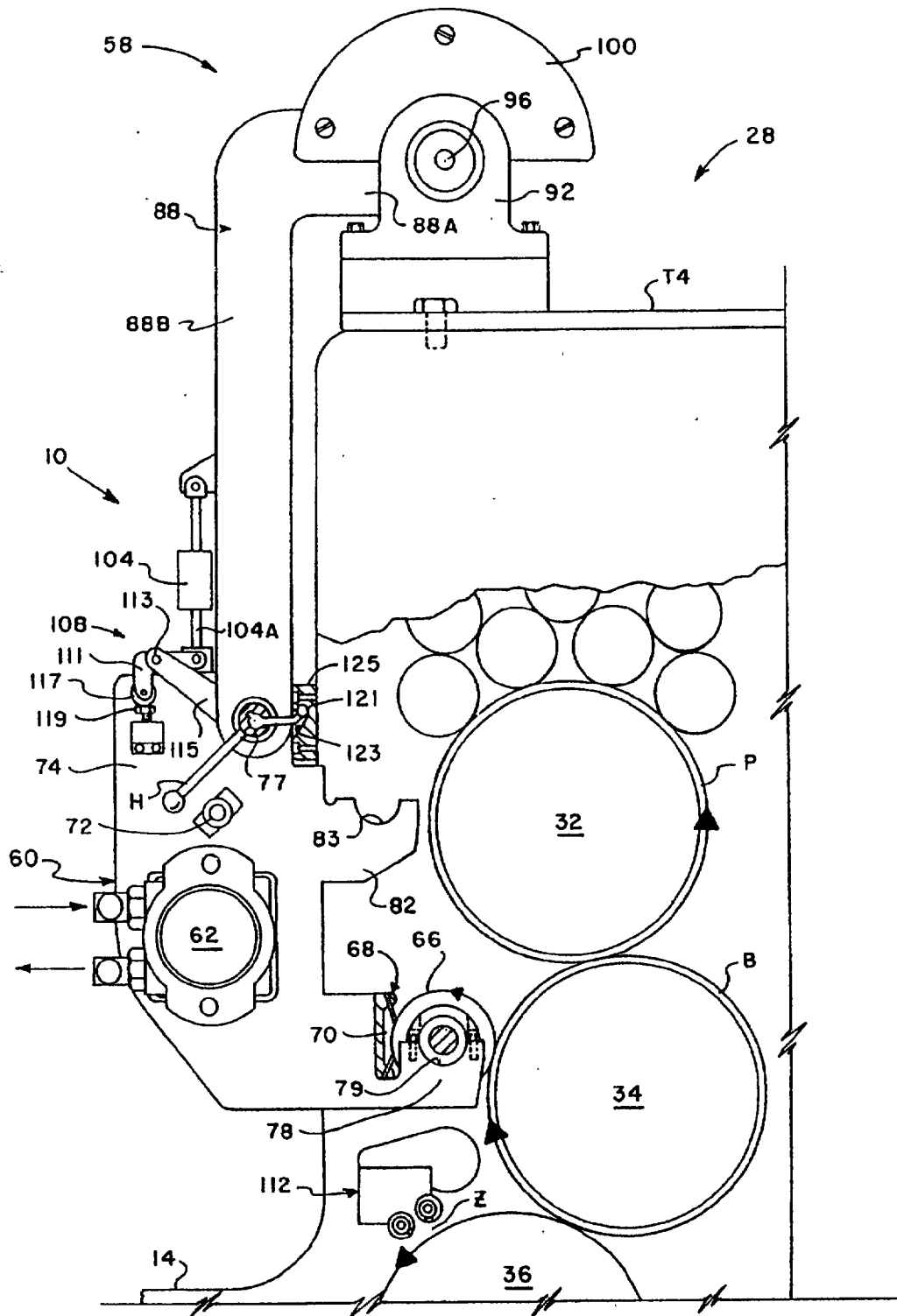


FIG. 4



TOBACCO ADVERTISING

C

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re the Reissue Application of:
BILL L. DAVIS and JESSE S. WILLIAMSON

For Reissue of U. S. Patent 5,630,363
Issued May 20, 1997
Serial No. 08/515,097

Filing Date: May 20, 1999 (Reissue)

Serial No.: 09/315,796 (Reissue)

For: COMBINED LITHOGRAPHIC/
FLEXOGRAPHIC PRINTING
APPARATUS AND PROCESS



Group Art Unit: 2854

Examiner: _____

DECLARATION OF SCOTT BROWN

TO: The Honorable Commissioner of
Patents and Trademarks
Washington, D.C. 20231

SIR:

I, Scott Brown, declare on my oath the following:

1. I am a sales representative for Heidelberg, U.S.A., Incorporated, having come to work for my present employer in April 1994. I am 34 years of age, and reside at 2813 Seminary Circle, Garland, Texas 75043 and am competent to make this testimony. I have never been convicted of any felony.

2. Shortly after I came to work for Heidelberg U.S.A. in April 1994, I became involved in a sales campaign to sell Williamson Printing Company ("Williamson") a number of offset lithography presses, all to be manufactured in Heidelberg, Germany. I met Jesse Williamson and Bill Davis in the late spring of 1994, and was told by them of their WIMS proprietary process for printing metallic inks by offset lithography. Upon learning the fundamentals of this process as explained to me by Jesse Williamson and Bill Davis, I told the

DECLARATION OF SCOTT BROWN

RECEIVED 09/24/99

WEISLOCH SB
12/20/99

093111000001

President of Heidelberg U.S.A., Hans Peetz-Larsen, of this process. See Exhibit A. As I recall, sometime in June or July of 1994, Williamson made an oral commitment to buy Heidelberg's presses, as is evidenced by a letter from Jerry Williamson, Chairman of Williamson, to Bob Boyer, my supervisor, of August 5, 1994. See Exhibit B, which came from our company's files and was filed in the normal course of business and is part of Heidelberg's U.S.A.'s records. At about the time of the August 5, 1994 Jerry Williamson letter, Exhibit B, Jesse Williamson and Bill Davis explained to me that they intended to improve the existing WIMS process by having flexography performed prior to offset lithography in an on-line operation, all in one pass. They indicated several methods that this could be done, in one manner with a dedicated flexography station, and another by an auxiliary add-on unit. They mentioned the use of a high velocity drying system being employed, and the possibility of using a modified Printing Research, Inc. printer-coater as an interstation add-on for flexographic applications. They wanted to perform tests to demonstrate the merits of this new, improved process to be conducted in Germany.

3. Accordingly, I contacted Gregory Canty of BASF in Holland, Michigan concerning their company's flexographic "round exposure unit" for making flexographic plates, and received a proposal from him for Williamson (Exhibits C, D) in early September 1994. The type of BASF plate-making equipment which Canty proposed to me already existed at our company's facilities in Heidelberg, Germany. Heidelberg U.S.A. was amenable to changing the design of one of its stations to adapt it for an anilox roller and flexographic operation, passing on the increase in costs due to acquired equipment to the customer, such as Williamson. We demonstrated a triple tower and an anilox roller (located at the first tower) to Jesse Williamson on the North American continent at the location of one of Heidelberg Canada's customers located in Montreal, Canada, in early November 1994. See Group Exhibit E. Jesse Williamson and Bill Davis wanted off-line tests conducted on their new process – i.e., simulations of a one-pass operation using flexography as a step prior to offset lithography – done at our parent company's offices (Heidelberg Drucksmaschinen A.G.) in Germany. Accordingly, we originally scheduled

COATING (83)

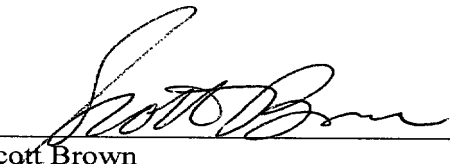
66
u/2019

these tests for December 10, 1994. See Exhibit F. That trip was subsequently rescheduled for January 20-21, 1995. After the trip to Montreal, detailed preparations were commenced for the tests in Germany (at Jesse Williamson's and Bill Davis' instructions), using BASF plate-making equipment already existing at Heidelberg, Germany, flexographic inks acquired from Wolstenholme in the United Kingdom, and plates made from Eckart, a German manufacturer, from negatives of Williamson's using the BASF equipment. See Exhibit G.

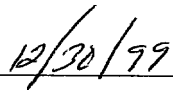
4. I left for Germany on January 17, 1995, according to my schedule book. I recall taking an American Airlines wide-body jet to Frankfurt, and the following morning leaving on an unexpectedly 20 minute-late train to Heidelberg, Germany. I recall it was very cold and windy and all of us nearly froze to death on the train platform, especially Jesse Williamson. I remember January 20-21, 1995 and the tests at Heidelberg, Germany quite well. This was my first trip to Germany. We stayed at the Holiday Inn in Heidelberg. January 20 was Jesse Williamson's birthday. It was a very cold and gray day in Germany on January 20, 1995. We had a nice lunch at the Company's café, and I recall I had salmon, and there were nice wines and a dessert of sorbets and ice-cream-shaped to look like tomatoes. See Exhibit H, a group of pages concerning the trip from my scheduling book. In attendance at the tests were Jerry Williamson, Jesse Williamson and Bill Davis, all from Williamson, who were directing the tests, Michael Yates and Steve Clark from Wolstenholme, Peter Schwaab, Reginald Retting, and Klaus Sauer from Heidelberg Drucksmaschinen A.G., and Bob Boyer (my supervisor) and the undersigned from Heidelberg, U.S.A.

5. The day-long tests on January 20, 1995 involved comparisons of the results of the new WIMS improved process over the old process and involved rerunning some established Williamson advertisements made for Rolex, some art work involving (I recall) a 1957 Chevrolet bumper grill, an apple of some configuration, a memorable portion of an automobile brochure comprising a silver Lexus driving on a wet cobblestone road (having a shimmery look with a gold reflection off of puddles on the cobblestone), and finally some test-type patterns, all

statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code.



Scott Brown



Date:

DECLARATION OF SCOTT BROWN

**HEIDELBERG
USA**Office of the President
Corporate - New York

TELEFAX MESSAGE

June 3, 1994

To: BOB BOYER, DALLAS

From: Hans Peetz-Larsen, New York

Re: Williamson Printing Corp.

Attached is draft of letter to Williamson Printing. Please critique and make sure nothing was left out of what you wanted to include.

Also, what is WIMS and inGrain process that you speak about?

HP-Lrmp
HP-Lrmp

ATTCH.

Total pages of fax: 2

WIMS = WILLIAMSON INTEGRATED METALIC SEPARATION

SIX COLOR SEPARATION OF PROCESS COLORS AND
SILVER AND GOLD METALIC. THE PROCESS GREATLY
ENHANCES SILVER AND GOLD IMAGES (WATCHES, CHROME, ETC)

WIMS IS A PATENTED PROCESS

TO 6060 96757660

HEIDELBERG USA

*Personal
Letter to each*

Mr. Jerry Williamson, Chairman of the Board
Mr. Jesse Williamson, President
Williamson Printing Corporation
8700 Denton Drive
Dallas, Texas 75235

Office of the President

Heidelberg USA, Inc.
80-30 Metropolitan Avenue
Rego Park, NY 11374
Phone 718-830-7802, Fax 718-275-8863

June 3, 1994

Dear Jerry and Jesse,

We have always held Williamson Printing Corporation in high esteem and recognize you as a pioneer in new printing technologies such as WIMS and inGrain processing. Your contribution to our industry is well known and it is indeed an honor for me to serve with Jerry on the Boards of PIA and GATF.

Family companies at their best can achieve tremendous successes. You are one of those, well known and well respected for top quality printing and certainly one of the top award winning printers in our country.

Below I quote our Mission Statement, which reads.

" Heidelberg USA is totally committed to be the partner of choice to the U.S. Printing Industry. We are determined to set standards as the leader in technology and quality of equipment. Each and every employee of Heidelberg USA is dedicated to provide excellent customer service and support. "

We feel we have many things in common with you and it has been one of our key goals to earn your trust and to become a business partner of yours. *YOUR PARTNER OF CHOICE.*

Thank you very much for your courtesy to my colleagues during prior visits to your company. I now look forward very much to visit with you on Tuesday, June 7th, and hope that we will find common ground so that we can become business partners for the mutual benefit of Williamson Printing Corporation and the Heidelberg Group.

Sincerely,

HP-L/mp

Hans Peetz-Larsen
President



Heidelberg Offset Presses • Polar Cutters & Paper Handling Systems • Stahl/Baum Folders & Stitchers

00315796-000001



Williamson Printing Corporation

6700 Denton Drive • Dallas, Texas 75235 • (214) 904-2100

August 5, 1994

Mr. Bob Boyer
Regional Manager
Heidelberg USA
1801 Royal Lane, Suite 1012
Dallas, TX 75229

Re: Sheetfed Press Transaction
WPC and Heidelberg USA

Dear Bob:

I have reviewed your letter dated August 5, 1994, which was in response to my letter addressed to you dated August 1, 1994, regarding the above referenced. Pursuant to our meeting and discussion of this morning, I will respond to each of your paragraphs in the order as presented in your letter, being the same order as presented in my letter, but will omit those paragraphs on which you have stated your agreement.

WPC's response is as follows:

- 1) Site preparation - We understand your position here that the cost of "site preparation" can vary tremendously, and is not normally included in the financing. However, we would like to include the cost of "site preparation" as part of our installation cost because it does represent part of the total capital expenditure. As soon as we have details and a cost budget, we will relay that information to you.
- 2) Six (6) color triple tower, double coater press - We understand that you do not have one of these presses currently in the Heidelberg "pipeline," and therefore not available before five (5) to six (6) months. We agreed to substitute this six (6) color triple tower, double coater press for the first eight (8) color press we had originally ordered in the first press order.
- (3) UV Drying capabilities for the six (6) triple tower, double coater press - We understand that this unit has not been included in the quoted prices. We agree with your suggestion not to place an order for this unit until after we have had our demonstration at Interglobe Printing in Montreal, Canada, and after having received a presentation from the manufacturer. We understand that there will be additional cost for this unit.

page 1 of 3

August 5, 1994

page 2 of 3

Re: Sheetfed Press Transaction
WPC and Heidelberg USA

- 08/05/94
10:00 AM
- (5) Bailment arrangements on first two (2) presses - We have a mutual understanding as to the reasons we must delay transfer of title or payment of consideration prior to January 1, 1995, and you have assured me that Heidelberg will resolve this concern to our satisfaction in order to reach our objective. Perhaps a bailment agreement with some type of guarantee, maybe a side-letter agreement, transferring title after January 1, 1995, would satisfy both parties.
 - (7) "Pre-DRUPA"/"DRUPA" trade-in agreement - We agree to modify our paragraph (7) to reflect those changes, establishing a trade-in value of market value, or 70% of purchase price, whichever is greater, in the second year, and establishing a fixed purchase price on the "DRUPA" presses, not to exceed 5% over the cost/quoted price/final price, of the "Pre-DRUPA" presses.
 - (11) Expenses for WPC personnel - we agree that there should not be available an unlimited number of WPC personnel sent on demonstrations and/or tests. We agree that three (3) people representing WPC is a reasonable number, with the understanding that you will extend us some flexibility on that number should there be a good reason to add one or two more.
 - (12) Expenses for WPC personnel - Same as described in (11) above.
 - (13) Expenses for WPC personnel - Same as described in (11 and 12) above.
 - (14) Expenses for training - We need to better clarify just how many WPC people you are willing to include here, for example, number of press crew personnel, and engineering/maintenance personnel - a total of four (4) does not seem adequate under the circumstances. It is in both of our best interest for us to get off to a very good start, which will require superior training and preparation.
 - (16) Legal review of changes to contract - We await the response from your legal division after they have had an opportunity to review the revised contracts, including our cover letter. You stated that you did not feel that there would be any problem in getting such an approval from your legal division.

August 5, 1994

page 3 of 3

Re: Sheetfed Press Transaction
WPC and Heidelberg USA

Bob, I hope my comments stated above in response to your's, will bring us closer to a "meeting of the minds," and that your legal division will see fit to approve all of the details, which I believe are in accordance with our agreement and understanding.

I appreciate your coming by this morning so we could try to resolve the unanswered issues. I also appreciate your bringing by Hugh and Ian Lyons, whom I enjoyed meeting, and my having the opportunity of visiting with all of you, all be it briefly.

Speaking in behalf of all of us here at WPC, we are all very much looking forward to establishing a good strong business alliance and long-term partnership.

If you have any questions, please do not hesitate to give me a call.

Very truly yours,



Jerry Williamson
Chairman of the Board

JBW:db

cc: Bill Davis
Woody Dixon
Bob Emrick
Jesse Williamson

106000-000000

C

Page 1 of 15

BASF CORPORATION

PROPOSAL FOR

WILLIAMSON PRINTING CORPORATION

Figure 1 consists of 12 bar charts, labeled (a) through (l), each representing a different fish species. The y-axis for all charts is 'Percentage of total catch' ranging from 0 to 100. The x-axis for all charts is 'Year' from 1990 to 2001. The species and their corresponding data are as follows:

- (a) Atlantic croaker: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (b) Striped bass: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (c) Weakfish: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (d) Spot: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (e) Blue crab: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (f) Rockfish: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (g) Atlantic silverside: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (h) Atlantic herring: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (i) Atlantic menhaden: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (j) Atlantic tomcod: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (k) Atlantic bluefish: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.
- (l) Atlantic sea herring: 1990: 10, 1991: 10, 1992: 10, 1993: 10, 1994: 10, 1995: 10, 1996: 10, 1997: 10, 1998: 10, 1999: 10, 2000: 10, 2001: 10.

Mr. Richard Torres
Pre-Press Director
Williamson Printing Corporation
6700 Denton Drive
Dallas, Texas 75235

We are pleased to offer Williamson Printing Corporation a proposal designed to provide you with the most advanced, efficient and profit producing plate technology in the world today. We are certain it will enhance your productivity, quality and safety while reducing your costs for many years to come.

We are delighted with your interest and consideration. We look forward to a long, friendly and beneficial relationship.

Gregory Canty
Technical Sales Representative
Printing Plate Systems
Enclosures

cc: Carl Weber
Brian Reilly
File

[illegible]

Extensive research capabilities focused on all aspects of printing technology and supply keeps BASI[®] on the leading edge of technology around the world.

[illegible]

- I. Introduction
- II. Product and Benefits
- III. Proposal and Options of Financing
- IV. Proposed Plate Pricing
- V. Terms and Conditions
- VI. Rebate Proposal
- VII. Duration of Agreement
- VIII. Technical and Customer Service Support

Appendix:

- Product Specification Sheets
- Equipment Brochures
- Quality Assurance

I. INTRODUCTION

BASF Corporation, Printing Plates Systems is pleased to offer this proposal for our nyloflex® LW 116 coating plates and processing equipment to Williamson Printing Corporation, Dallas, Texas. The benefits detailed in this proposal, such as optimized value, efficient service, product quality and consistency will in our opinion yield significant improvements.

II. PRODUCT AND BENEFITS

nyloflex® LW 116 Coating Plates

BASF coating plates have replaced hand-cut blankets to reduce press "make-ready" and downtime. They are suitable for either aqueous or UV coatings. These plates meet all of the requirements for fine detail coating jobs due to their capacity to hold high resolution elements. They offer high dimensional stability and are mounted comparable to any other printing plate. A register system facilitates accurate positioning.

The nyloflex® LW 116 coating plates represents an ideal combination of advantages.

High contrast

Sharp edges

Uniform coating film

No build-up of offset ink

Technical Information

0.046 inches thick

0.001 inches Polyester base

0.036 inches relief depth

Shore A 75 hardness

Available sheet sizes: 35 x 42, 50 x 58, 51 x 57.8. 8 sheets per carton. LW 116, 35 x 42, are available at \$203.86 per plate.

106000-96257600

nyloflex® RB 270 L Round Exposing Unit

The newly developed BASF RB 270L round exposing unit exposes nyloflex® coating plates. Different cylinder circumferences allow 1:1 transfer from negatives without time consuming and cost intensive film distortion.

Advantages

- Guide rails provide easy access to the exposing cylinder
- Exposing cylinders of differing diameters and widths are available as necessary
- Fast plate mounting with register bar using conventional register punch. The plate and film are mounted outside of the unit
- Easy to use wrap around vacuum sheet
- Fast vacuum build up
- Short exposure time with high output UV exposure lamps with reflectors
- Simply UV lamp function review
- Electronic timer
- Table-top unit supporting frame or legs available as extra accessories

Technical Data

Maximum plate size	32.5 x 55.25 inches*
Cylinder weight	410 lbs. gross, 220 lbs. net
Exposing unit weight	915 lbs. gross, 540 lbs. net
Dimensions	L 79.5 inches W 32.5 inches H 35.5 inches
Power	220 V, Three phase, 60 HZ, 16 amps
Lamps	20 Philips TL 80 W/10 R 59 1/16 inches

*valid for diameters of 10.625 inches. Maximum exposure cylinder 10.625

nyloflex® DW 135L Washout Unit

The BASF nyloflex® DW 135L continuous flow washout unit provides a convenient, efficient method of processing LW 116 coating plates. The exposed plates are automatically transported by a roller system through the processing section. The nyloflex®

DW 135L utilizes the proven principle of friction washout with oscillating plush pads gently removing the unexposed photopolymer with a solution of 1 percent caustic soda maintained between 122 and 131° F. The system provides totally automatic washout, rinsing, and pre-drying.

Advantages

Dry to dry plate handling

User friendly operation and maintenance

Easily removable, long lasting plush pads

Individually adjustable plush pad supports

Variable speed plate through put within a suitable range

Digital displayed flow speed

Pre-drying by circulated warm air

Easily readable displays for water temperature and pre-drying temperature

Technical Data

Maximum plate width	53.125 inches
Minimum plate length	15.75 inches
Weight	Approximately 1,430 lbs.
Dimensions	L 144 inches W 87 inches H 52 inches
Tank capacity	53 gallons each
Exhaust rate	280 feet per minute, 4 inch diameter
Power	220 V, Three phase, 60 HZ, 16 amps

nyloflex[®] F III Dryer

The BASF nyloflex[®] F III dryer provides an ease of operation in an energy efficient, user friendly unit. The F III dryer ensures uniform temperature distribution of +/- 1° C within the drawers. Operator safety is enhanced by an automatic shut off of the heating elements and circulation fans when opening the drawers. Additional safety features include an automatic shut down should temperatures exceed safety thresholds.

Advantages

User friendly

Uniform temperature distribution

Energy efficient

Automatic safety shut off

Technical Data

Maximum plate size	36.25 x 47.25 inches
Dimensions	L 80.8 inches W 42.9 inches H 36.2 inches
Weight	772 lbs.
Exhaust	5 inches diameter
Power	220 V, Three phase, 60 Hz, 50 amps

TOP SECRET

III. PROPOSAL AND OPTIONS OF FINANCING

- A. BASF will supply, at a substantial discount, its nyloflex[®] coating plates processing systems to Williamson Printing Corporation, Dallas, Texas.
- B. A certified BASF equipment engineer will assist you in the design of your platemaking facility, as well as the installation of the systems.
- C. Qualified BASF technicians will train the in-plant platemakers to properly operate and maintain the systems, maximizing their value.
- D. BASF will provide personnel at no charge to remain on location until all in-plant personnel are qualified in the proper platemaking skills. In addition we will conduct periodic quality control audits of systems procedures to ensure that plate preparation systems are correct and maximizing performance.

THE 3000 3600 4000 4500 5000 5500 6000 6500 7000 7500 8000 8500 9000 9500 10000

nyloflex® COATING PLATE PROCESSING EQUIPMENT

<u>Description</u>	<u>List Price</u>	<u>Williamson Printing</u>
RB 270L 32 x 55.25 inches	\$18,972	\$14,373
DW 135L Max. Plate Width 53.125 inches	\$62,937	\$47,680
F III Dryer 36 x 47.25 inches	\$32,367	\$24,520
Total	\$114,276	\$86,573

Note: The above items have an approximate eight to twelve weeks delivery after receipt of written order. Shipping is F.O.B., Zeeland, Michigan.

T060000-96251E60

EQUIPMENT PURCHASE OPTIONS

The following options are available to Williamson Printing Corporation from the BASF, Printing Plate Systems Division, and are as follows for the purchase of the desired equipment:

- OPTION 1 BASF will provide the desired equipment to Williamson Printing Corporation at the special price requiring a twenty-five (25%) down payment of \$21,643.25 with the order. Williamson Printing Corporation to pay the balance (\$64,929.75) in normal billing time of thirty (30) days.
- OPTION 2 BASF will provide the desired equipment to Williamson Printing Corporation at list price requiring a twenty-five (25%) down payment of \$28,569. Williamson Printing Corporation shall pay the balance of \$85,707 during a period of twelve (12) months in equal payments of \$7,142.25. No interest charges will apply.

BASF will apply plate purchases to our rebate program should Williamson Printing Corporation choose to accept Option 1. BASF will not apply plate purchases to our rebate program should Williamson Printing Corporation choose to accept Option 2. We will apply plate purchases to our rebate program after the payment period in the case of Option 2.

BASF will file the necessary UCC-1 forms while Williamson Printing Corporation pays for the equipment. In addition, Williamson Printing Corporation and BASF must sign an Equipment Sales Agreement.

106000-3643160

VI. REBATE PROPOSAL

BASF proposes the following rebate schedule:

<u>ANNUAL PURCHASE VOLUME</u>	<u>REBATE</u>
\$ 25,000 - \$ 49,999	1.5%
\$ 50,000 - \$ 99,999	2.5%
\$ 100,000 - \$ 249,999	5.0%
\$ 250,000 - \$ 499,999	8.0%

Rebate schedule applies only to plate purchases.

VII. DURATION OF AGREEMENT

BASF submits this proposal to Williamson Printing Corporation with all prices on equipment confirmed as of October 13, 1994.

VIII. TECHNICAL AND CUSTOMER SERVICE SUPPORT

Technical Support

BASF provides a 24 hour, 7 days a week, Technical BASF hot line, 1-800-343-4700.

Customer Service

BASF provides extended Customer Service office hours from 8:00 AM to 5:00 PM eastern time.

Priority Service - BASF will specify a Customer Service Representative to work with Williamson Printing Corporation to expedite orders and answer any questions that may arise.

T06030-96257260

THEORY OF SETS

D

BASF Corporation

BASF

Graphics Group

ROUND EXPOSURE UNIT RE 270 L
(FOR lw coating plates)

Max size : 820 x 1400mm
for cylinders up to 268mm diameter
230 V / single phase / 50 Hz

15672

Underframe

2055

Leg assembly

1402

19129

Add'l cylinder
For cylinder 240-260mm diameter

11687

\$30816

053159-050401

TELEFAX FROM BASE
1st FLOOR - PRINTING PLATE SYSTEMS
FAX # 616 393-5286

TO: Scott Brown

LOCATION: Heidelberg USA

TELEFAX # 214-506-0476

FROM: Domenic Coppola

DATE: 9-6-94

1 Pages to follow (excluding cover)

If you have any problems or do not receive all of your pages, please notify sender at (616) 393-5248.

COMMENTS:

001590 96451260


nyloflex


The new standard for exposing photopolymer coating plates: RB 270 L round exposing unit.

The newly developed RB 270 L round exposing unit serves for exposing photopolymer coating plates and other photopolymer plate types; different cylinder circumferences permit information transfer from 1:1 negative films without time-consuming and cost-intensive film distortion.

The plus points in the handling ...

- Good accessibility because the exposing cylinder can be pulled out on rails.
- Exposing cylinders are available in

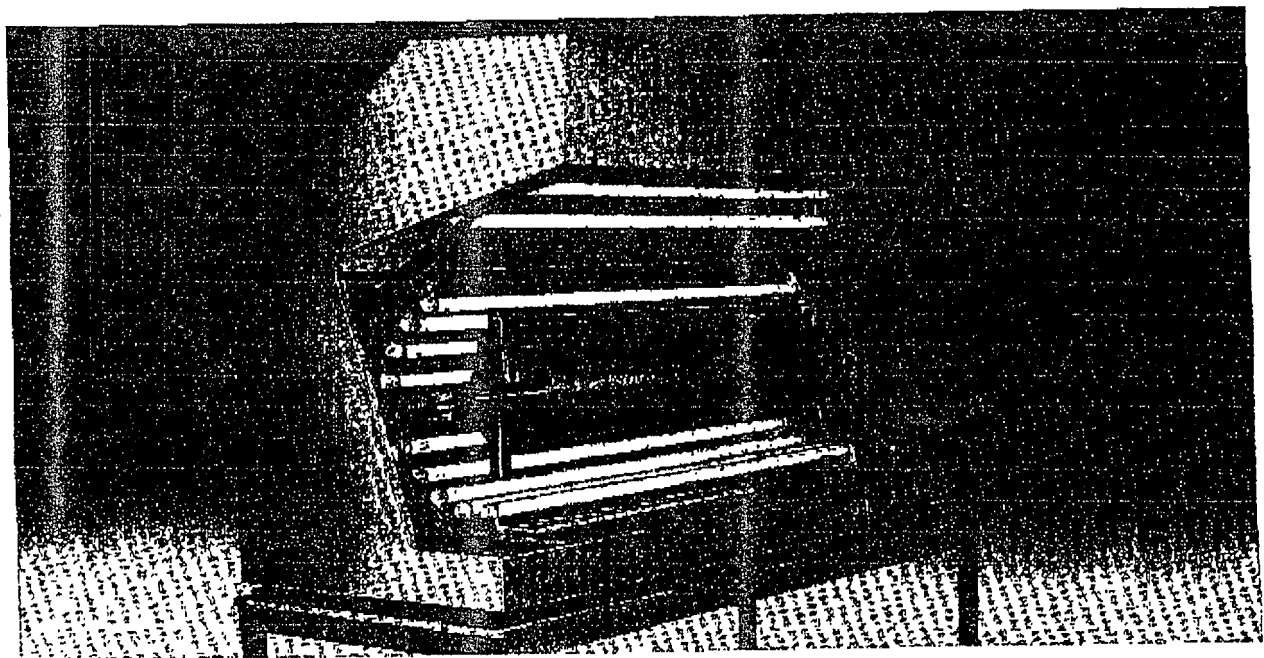
different diameters and widths for exchange as necessary.

- Quick plate mounting with register bar: plate and film can be mounted outside the unit.
- Easy-to-use wraparound vacuum film.

... and in the technical equipment of the new RB 270 L round exposing unit

- Quick build-up of vacuum permits exposing at short intervals.

- Short exposure time due to high-output UV tubes with reflectors.
- Constant temperature due to intensive cooling of the UV tubes.
- Simple tube function check.
- Electronic timer.
- Table-top-unit supporting frame or legs available as extra accessories.
- The design conforms to German and European safety regulations.
- Requiring the use of a conventional register punch.



Printing plates

BASF

Print Plate Sy
H-Milgram 616-392-239

RB 270 L Round exposing unit for coating plates

Maximum effective size*	820 x 1,400 mm ca 2'8½" x 4'7¼"	The round exposing unit is designed for exposure cylinders maximally 270 mm (105/8") diameter. We can inform you about smaller dimensions on request.
Weight of cylinder:	ca 195 kg gross, ca 100 kg net ca 410 lbs. gross, ca 220 lbs. net	
Weight of exposing unit:	ca 415 kg gross, ca 245 kg net ca 915 lbs. gross, ca 540 lbs. net	
Unit dimensions: L x H x D	2,020 x 900 x 820 mm ca 6'7½" x 2'11½" x 2'8½"	
Crate for unit: L x H x D	2,180 x 1,080 x 1,100 mm ca 7'2" x 3'6¼" x 3'7¼"	
Crate for cylinder: L x H x D	2,080 x 580 x 660 mm ca 6'10" x 1'11" x 2'2"	
Power:	230 V, 50 Hz, 16 A, 2.5 kW (3.4 hp)	
Tubes:	20 of type Philips TL 80 W/10 R (150 cm/59½")	

* valid for diameters of 270 mm or 10½"

*Cylinder from HDM
Exposure Processor
Developing sink
cutted*

The information in this document is based on our present knowledge and experience. Due to the multitude of factors influencing the processing and application of our products, it does not release the user from own testing and experimenting. Nor does it imply any legally binding assurance concerning specific properties of the products or the suitability for a particular application. The responsibility of observing any pertinent industrial property rights, laws and regulations rests with the user. Subject to technical changes without notice. Product names marked ® are registered trademarks of BASF.

GFE 5031 01/94

BASF Lacke+Farben AG
Sieglerstraße 25
70469 Stuttgart-F Feuerbach
Germany
Telefon (07 11) 98 16-0
Telefax (07 11) 98 16-8 01
Telex 725 2160

BASF**Printing Plates**

The range of coating plates from BASF

Plate type	nyloflex		nyloprint						nylograv
	FAE 116 L	LC/LW 116	A 73	S 73 E	S 68	WA 1 73	WS 1 73 E	WS 1 58	WSA 58
Thickness (mm/)	1.16/0.048	1.16/0.048	0.73/0.029	0.73/0.029	0.58/0.023	0.73/0.028	0.73/0.028	0.58/0.023	0.52/0.020
Hardness (finished)	Shore A = 70	Shore A = 76	-	-	-	-	-	-	-
Hardness (DIN)	Shore A = 50	Shore A = 56	-	-	-	-	-	-	-
Base (mm/)	Polyester 0.25/0.010	Polyester 0.25/0.010	Aluminium 0.80/0.012	Steel 0.24/0.009	Steel 0.24/0.009	Aluminium 0.30/0.010	Steel 0.24/0.009	Steel 0.24/0.009	Steel 0.80/0.012
Roller depth (mm/)	0.91/0.028	0.91/0.028	0.40/0.016	0.48/0.018	0.32/0.013	0.40/0.018	0.46/0.018	0.32/0.013	max. 45-55 µm in 70 Vcm (180/6) screen
Size	up to 1,350x1,470 (c. 49x58")	up to 1,250x1,470 (c. 49x58")	max. VI	max. II-B	max. V	max. VI	max. V	max. V	
Suitable coatings and inks	Aqueous coatings UV coatings (after testing)	Aqueous coatings UV coatings	Varnishes UV coatings						• Coatings and inks on base of alcohol and ethyl acetate • No coating on water base
Platemaking: • Exposure	Round exposure or flat exposure with shortened film								Round exposure or flat exposure with point light
• CAD/CAM		Cutting via plotter + stripping (LW only)	Step or repeat possible						
• Wash-out	Wash-out systems with nylasolv II or solvents common in trade	Aqueous wash-out medium in brush- or friction-type washers (LW only)	Alcohol washers			Water washers			Continuous-flow friction washer water-washable
Advantages	<ul style="list-style-type: none">• Very good, uniform coating transfer• Very good edge sharpness• 20-80% higher coating quantity than by indirect coating• Reproduction of finest details (spot coating) with LC: 4 nm (0.157) max. dot diameter• High accuracy of register (dimensional stability)		Thicker coating than with offset plates, high gloss, less waste with varnishes or UV coatings, because no demolding solution used. Long run life, especially when using alcohol-washable plates.						<ul style="list-style-type: none">• Fast, flexible and economical plate-making; therefore suitable also for short runs• Environment-compatible processing• Variable cell depth and, therefore, controllable coating transfer
		No ink build-up on plate Resistant to blanket wash-up solutions Suitable for use with aqueous and UV coatings 2 alternatives in platemaking: a) Conventionally with film and water wash-out b) CAD/CAM processing - no film, no wash-out, therefore no processing equipment required							
Special features									Even cell depths of more than 50 µm achievable, meaning higher coating transfer than by other processes

The information in this document is based on our present knowledge and experience. Due to the multitude of factors influencing the processing and application of our products, it does not release the user from own testing and experimenting. Nor does it imply any legally binding assurance concerning specific properties of the products or the suitability for a particular application. The responsibility of observing any pertinent industrial property rights, laws and regulations rests with the user. Subject to change without notice. Product names marked ® are registered trademarks of BASF.

GRF 5011 06/93

BASF Lacke+Farben AG
 Sieglestraße 25
 70469 Stuttgart-Feuerbach
 Germany
 Telefon (07 11) 98 16-0
 Telefax (07 11) 98 16-801
 Telex 725 2160

BASF

Printing Plates

October 17, 1994

Southwest Region

Heidelberg USA, Inc.

1801 Royal Lane

Suite 1012

Dallas, TX 75229

Phone 214-506-7000, Fax 214-506-0476

Jerry Williamson
Jesse Williamson
Williamson Printing Corporation

Dear Jerry and Jesse:

On Friday, October 14, after our picture taking ceremony, questions were raised regarding the future installation of 8 color presses and the LYL double coater machine. As of today October 17, we have been in contact with the factory and enclosed are answers and the possible solutions to your concerns.

1. Delivery of the 102 S LYL (double coater) barring no production problems has been moved up in the schedule to leave the factory the end of December, for delivery to Williamson's floor in January.
2. A demonstration will be scheduled at Interglobe, Inc. in Montreal, Canada along with a company, Olympic Packaging in Madison, Wisconsin, to witness spot coating with register requirements. Dates to be determined as soon as possible.
3. Delivery of an 8 color Drupa or pre-Drupa machine. Dates are as follows: Pre-Drupa, one machine delivery early January. Drupa machines as of today are exfactory, May or June and every month that goes by pushes it back in the schedule. I urge you to make a commitment, subject to your inspection.
4. A private and confidential presentation of Drupa Technology to Williamson is set for the week of 12/10/94 in Heidelberg. Times and visits are already in place.
5. Companies that have experience in making relief plates for spot coating:

Alabama Engraving	Chicago Litho Plate
David Kaetz	Joe Yazzo
1-800-524-2135	708/858-8900
	<u>Please note:</u> Vast experience with Heidelberg Speedmasters.
6. Heidelberg Factory uses the round exposure BASF unit for demonstration purposes for printers around the world and cannot be without this unit.



Williamson Printing Corporation
October 17, 1994

7. You had indicated the six to eight week delivery from BASF on developing equipment for the making of coating plates, for spot coating, was not acceptable. We can assure you, if an order is placed with BASF, Heidelberg will use as much clout as possible to speed up this delivery time. Williamson must place the order as soon as possible, before we can put pressure on BASF.

8. Contacts for Interglobe, Inc. and Olympic Packaging.

Interglobe
Roger Belair
Montreal, Canada
514/328-7070

Olympic Packaging
Gary Adrian
Madison, Wisconsin
608/246-1133

Gentlemen, our companies have worked hard toward establishing a partnership beneficial to each. Please know we need to communicate whenever there are concerns and we can assure you both that a professional response will always be available.

Best Regards,



Bob Boyer

cc: Hans Peetz-Larsen
Wolf Hager
Ian Lyons
John Dowey
Bill Davis, Williamson
Woody Dixon, Williamson
Bob Emerick, Williamson

TELEPHONE

October 21, 1994

Southwest Region

Heidelberg USA, Inc.

1801 Royal Lane

Suite 1012

Dallas, TX 75229

Phone 214-506-7000, Fax 214-506-0476

Mr. Jerry Williamson
Mr. Jesse Williamson
Williamson Printing Corporation
6700 Denton Drive
Dallas, TX 75235

Re: Demonstration of Double Tower

Date of Demonstration: Thursday, November 3, 1994, at 9:00 a.m.

Location: Montreal Canada at a company called Interglobe,
their address is as follows.

Interglobe
4475 Blvd. des Grandes Praires
St. Leonard, Quebec
514/328-7070
Roger Belair, Director
Contact: Carole Jalbert

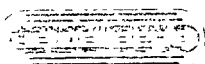
We have secured this date and would appreciate it if you would get the film, paper specification and coating requirements to Mike Morgan at your earliest convenience.

Please let Mike know, as soon as possible, the number of people from Williamson who will be attending; so we can coordinate flight and hotel reservations.

Bob Boyer
Regional Manager

BB/bw

cc: Bill Davis
Bob Emerick
Jim Johnson





Southwest Region

FLIGHT
ITINERARY FOR
WILLIAMSON DEMO IN MONTREAL
WEEK OF 11-02-94
ATTENDANTS

Heidelberg USA, Inc.
1801 Royal Lane
Suite 1012
Dallas, TX 75229
Phone 214 506 7000
Fax 214 506 0476

Jerry Williamson

November 02

1:30 p.m. depart DFW - American flight #2350
Arrive Chicago/Ohare 3:44 p.m., Wed. November 02

November 02

4:40 p.m. depart Chicago/Ohare - American flight #1200
Arrive Montreal/Dorvl 7:41 p.m.

November 03

4:15 p.m. depart Montreal/Dorvl - American flight # 452
Arrive Chicago/Ohare 5:35 p.m. Thur. November 3rd

November 03

6:00 p.m. depart Chicago/Ohare - American flight # 2249
Arrive Dallas/FT. Worth 8:30 p.m.

November 02

Hotel Information

Delta Montreal
475 President Kennedy Ave
Montreal Quebec H3A 1J7 514-286-1986
Confirmation # 139904 01 nt/s

Nesse Williamson

November 02

1:14 p.m. depart DFW - Delta flight #1214
Arrive Cincinnati 5:21 p.m., Wednesday November 2nd

November 02

6:26 p.m. depart Cincinnati - Delta flight #3749
Arrive Montreal/Dorvl 8:40 p.m.

November 03

5:05 p.m. depart Montreal/Dorvl - Delta flight #333
Arrive Dallas/FT. Worth 10:09 p.m. Thurs. November 3rd

November 02

Hotel information

Delta Montreal
475 President Kennedy Ave
Montreal Quebec H3A 1J7 514-286-1986
Confirmation # 102051 01 nt/s

Bill Davis

November 02 1:14 p.m. depart DFW - Delta flight #1214
Arrive Cincinnati 5:21 p.m., Wednesday November 2nd

November 02 6:26 p.m. depart Cincinnati - Delta flight #3749
Arrive Montreal/Dorval 8:40 p.m.

November 03 5:05 p.m. depart Montreal/Dorval - Delta flight #333
Arrive Dallas/FT. Worth 10:09 p.m. Thurs. November 3rd

November 02
Hotel Information Delta Montreal
475 President Kennedy Ave
Montreal Quebec H3A 1J7 514-286-1986
Confirmation # 102051 01 nt/s

Jim Johnson

November 02 1:30 p.m. depart DFW - American flight #2350
Arrive Chicago/Ohare 3:44 p.m., Wednesday November 2nd

November 02 4:40 p.m. depart Chicago/Ohare - American flight #1200
Arrive Montreal/Dorval 7:41 p.m.

November 03 4:15 p.m. depart Montreal/Dorval - American flight #452
Arrive Chicago/Ohare 5:35 p.m., Thurs. November 3rd

November 03 6:00 p.m. depart Chicago/Ohare - American flight #2249
Arrive Dallas/FT. Worth 8:30 p.m.

November 02
Hotel Information Delta Montreal
475 President Kennedy Ave
Montreal Quebec H3A 1J7 514-286-1986
Confirmation # 103048 01 nt/s

Date of Demonstration: Thursday, November 3, 1994, at 9:00 a.m.
Interglobe
4475 Blvd. Des Grandes Prairies
St. Leonard, Quebec # 514-328-7070
Roger Belair, Director
Contact: Carole Jalbert

1064390 96/STEEB

TABLE 9.1

F



October 26, 1994

Press Marketing

Telefax to: Jerry Williamson, CEO
Jesse Williamson, President
Williamson Printing Co.

Heidelberg USA, Inc.

From: John Dowey

1000 Gutenberg Drive

Kennesaw, GA 30144

Phone 404 419 8500

Subject: *Pre DRUPA Double Coater Press*

Fax 404 419 6625

Dear Jerry and Jesse:

Mr. Bob Boyer brought your request for the Heidelberg factory to possibly have the DRUPA innovations of running register on the coating units and automatic register in-line, fitted to your Speedmaster CD102S+LYL. This machine is presently under construction and we hope that it will leave the factory in late December.

We regret to inform you that these features cannot be adapted to the present design due to several mechanical and electronic changes, which Mr. Boyer confidentially briefed you on. These options are only available on the DRUPA design machine which would be available in during the third quarter of 1995. They cannot be retrofitted to the existing design.

We confirm that it is now possible to retrofit the coating clamps that allow manual register adjustments and precise mounting of spot coating plates. Thus these could be fitted to the coating units of your existing presses, as well as the December pre-DRUPA CD102S+LYL

We look forward to meeting with you here in Heidelberg during the week of December 10 to demonstrate the chambered doctor blade system for coating, and give you a private showing of the DRUPA design at the factory as well as a customer installation here in Germany.

Regards,

John Dowey
Marketing Director/Speedmaster

cc: Hans Peetz-Larsen
Wolf Hager
Mike Morgan
Scott Brown
Reginald Rettig, HDM/Germany

TO6050-96/5760

THE NEW YORK PUBLIC LIBRARY

G



Southwest Region

Heidelberg USA, Inc
1801 Royal Lane
Suite 1012
Dallas, TX 75229
Phone 214 506 7000
Fax 214 506 0476

November 8, 1994

Jerry and Jesse Williamson
Williamson Printing Corporation
6700 Denton Drive
Dallas, Texas 75235

Dear Jerry and Jesse,

Pursuant to our conversations regarding the special plate clamps for our coating tower that facilitate the use of Cyrel or other flexo type plates to be mounted and registered, and the Chambered Doctor System for the coating tower, please note the attached information from our Factory.

I highly recommend that you place an order immediately for the special plate clamps so as to expedite factory shipment and installation on your Seven Color press for evaluation.

It is also my recommendation that in conjunction with our trip to Germany on December 10, 1994 to evaluate the Drupa CD Technology, we arrange a demonstration of the Chambered Doctor System. Upon your review and evaluation we can then proceed with your order for the system with the noted approximate delivery and installation times.

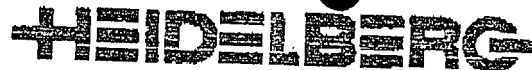
As always, it is a pleasure to work with you and your fine group of associates. I look forward to our trip to Germany and to continuing to build and strengthen our partnership.

Sincerely,

Bob Boyer
Regional Manager
Heidelberg USA, Inc.

cc: Bill Davis
Bob Emerick
Jim Johnson

TO: JERRY AND JESSE WILLIAMSON



November 7, 1994

Corporate

Fax to: Bob Boyer
Fax: 708-390-8914

Heidelberg USA, Inc.
1000 Gutenberg Drive
Kennesaw, GA 30144
Phone 404 419 8500
Fax 404 419 8912

From: John Dowe
Phone: 404-419-8628
Fax: 404-419-6608

Subject: Williamson CD102S+L SN 538 723

Dear Bob:

We have checked on price and availability of the special coating unit clamps and chambered doctor blade system.

- 1) Special clamps which allow CYREL or other flexo-type plates to be mounted and registered, have a delivery time of 6-8 weeks X-factory. We are in communication with the factory and will try to improve upon this.

Installed price - \$9,700 per coating unit

- 2) The chambered doctor system availability is roughly the same as the coating clamps. Again, we will try to improve the situation.

Installed price - \$67,500

Please let me know how you wish to proceed with this very important customer.

Regards,

John Dowe

cc: Kurt Vogt

136050-9625760

0315796 0000901

H

IMPORTANT TODAY

WEEK 3

1995

JANUARY 17
TUESDAY

TIME	SCHEDULE	ACTION LIST
7 AM	CHECK <input checked="" type="checkbox"/> MEMO-RY*	PEOPLE TO CONTACT
	GERMANY	
8		✓ BILL SHLYER 352-1122
		✓ TOM MCARTNEY 604-0496
9		
10		
11		
12 NOON		THINGS TO DO-BUY
1		
2		
3		
4		
5		
6 EVE'G		PLACES TO GO
7		
8		
SUMMARY REVIEW DAY MONEY		
CHECK TOMORROW TOTAL		

ORDER No 061-125Y-95

00013796-000901

18 JANUARY
WEDNESDAY

1 IMPORTANT TODAY
9
9
5 WEEK 3

TIME SCHEDULE ACTION LIST

A
BC ✓

7 AM

CHECK
MEMO-RY:

GERMANY

PEOPLE TO CONTACT

1. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12. 1. 2. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12.

8

9

10

11

12 NOON

THINGS TO DO-BUY

1

2

3

4

5

6 EVE'G

PLACES TO GO

M

7

8

SUMMARY

REVIEW DAY

MONEY

TOTAL

CHECK TOMORROW

IMPORTANT TODAY

WEEK 3

1
9
9
5

JANUARY 19
THURSDAY

| TIME | SCHEDULE | ACTION LIST |
|---------------------------------|---------------------|-------------------|
| 7 AM | CHECK ✓
MEMO-RY: | PEOPLE TO CONTACT |
| | GERMANY | |
| 8 | | Jesse's BIRTHDAY |
| | | FRIDAY! |
| 9 | | |
| 10 | | |
| 11 | | |
| 12 NOON | | THINGS TO DO/BUY |
| 1 | | |
| 2 | | |
| 3 | | |
| 4 | | |
| 5 | | |
| 6 EVE'G | | PLACES TO GO |
| 7 | | |
| 8 | | |
| SUMMARY REVIEW DAY MONEY | | |
| TOTAL | | |
| CHECK TOMORROW | | |

ORDER No 061-125Y-95

20 JANUARY
FRIDAY

1 IMPORTANT TODAY
9
9
5 WEEK 3

TIME SCHEDULE ACTION LIST

| TIME | SCHEDULE | ACTION LIST |
|---------|-----------------------------|-------------------|
| 7 AM | CHECK ✓
MEMO-RY: GERMANY | PEOPLE TO CONTACT |
| 8 | | |
| 9 | | |
| 10 | | |
| 11 | | |
| 12 NOON | | THINGS TO DO-BUY |
| 1 | | |
| 2 | | |
| 3 | | |
| 4 | | |
| 5 | | |
| 6 EVE'G | | PLACES TO GO |
| 7 | | |
| 8 | | |

| SUMMARY | REVIEW DAY | MONEY |
|----------------|------------|-------|
| | | |
| | | |
| | | |
| CHECK TOMORROW | | TOTAL |

IMPORTANT TODAY

WEEK 3

1995

JANUARY 21
SATURDAY

| TIME | SCHEDULE | ACTION LIST | A
BC |
|----------------|--------------------------------|-------------------|---------|
| 7 AM | CHECK ✓
MEMO-RY®
GERMANY | PEOPLE TO CONTACT | |
| 8 | | | |
| 9 | | | |
| 10 | | | |
| 11 | | | |
| 12 NOON | | THINGS TO DO/BUY | |
| 1 | | | |
| 2 | | | |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| 6 EVE'G | | PLACES TO GO | |
| 7 | | | |
| 8 | | | |
| SUMMARY | | | |
| REVIEW DAY | | MONEY | |
| | | | |
| CHECK TOMORROW | | | TOTAL |

ORDER No 061-125Y-95

TO 5007 96457600

22 JANUARY
SUNDAY

1
9
5
IMPORTANT TODAY
WEEK 3

| TIME | SCHEDULE | ACTION LIST | A
BC ✓ |
|----------------|-----------------------|-------------------|-----------|
| 7 AM | CHECK ✓
MEMO-RY* | PEOPLE TO CONTACT | |
| 8 | Fly back
to Dallas | | |
| 9 | 10:00 | | |
| 10 | | | |
| 11 | | | |
| 12 NOON | | THINGS TO DO-BUY | |
| 1 | | | |
| 2 | | | |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| 6 EVE'G | | PLACES TO GO | |
| 7 | | | |
| 8 | | | |
| SUMMARY | | | |
| REVIEW DAY | | MONEY | |
| | | | |
| | | TOTAL | |
| CHECK TOMORROW | | | |

10510 2647E90

D

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re the Reissue Application of:

BILL L. DAVIS and JESSE S. WILLIAMSON

For Reissue of U. S. Patent 5,630,363

Issued May 20, 1997

Serial No. 08/515,097

Filing Date: May 20, 1999

Serial No.: 09/315,796

For: **COMBINED LITHOGRAPHIC/
FLEXOGRAPHIC PRINTING
APPARATUS AND PROCESS**



Group Art Unit: 2854

Examiner: S. Funk
J. Hilten

SUPPLEMENTAL DECLARATION OF JOHN W. BIRD

To: The Honorable Commissioner of
Patents and Trademarks
Washington, D.C. 20231

Sir:

1. I am the same John W. Bird who executed a Declaration on December 11, 1999,
and reaffirm the statements made therein.

2. Attached hereto as Exhibit A are notes taken from various days of my monthly
"Pocket Day Timer(s)" for August 1994 through May 2, 1995:

- ** (A) August 18, 1994;
- * (B) August 29, 1994;
- (C) September 12, 1994;
- ** (D) October 5, 1994;
- * (E) November 14, 1994;
- * (F) November 15, 1994;
- (G) November 18, 1994;
- ** (H) November 21, 1994;
- (I) December 20, 1994;
- (J) January 4, 1995;
- (K) January 30, 1995;
- ** (L) February 9, 1995;
- (M) February 11, 1995;
- * (N) February 13, 1995;
- (O) February 15, 1995;
- ** (P) February 24, 1995;
- (Q) March 1, 1995;
- * (R) March 7, 1995;

* (S) March 10, 1995
* (T) April 4, 1995
** (U) April 6, 1995;
* (V) April 25, 1995;
** (W) May 2, 1995;

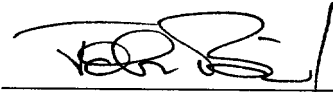
From my day-timer, I recall having a number of meetings at Williamson and, at other times, telephone conferences, sometimes with both Bill Davis and Jesse Williamson (marked "***" above), and sometimes with Bill Davis (marked "**"), following the revelation to me by Steven Baker of Printing Research, in late July 1994 of the Davis-Williamson process [what became the '363] see paragraph 10 of my prior declaration. The unasterisked pages may have some relevance.

3. In these meetings and conferences, which started on or about August 18, 1994, Bill Davis and/or Jesse Williamson conveyed to me details of the process they wanted implemented by a modified "rack-back" device to go upstream, together with tests they wanted run in the fall of 1994, end-of-press at the two-color experimental test press at Printing Research.

4. Specifically, among other things, they discussed (a) the resolution requirements for their flexographic plates, (b) requirements for anilox rollers, including linescreening count ranges and minimums, the availability of anilox rollers having their desired features, (c) the WIMS process (now U.S. Pat. 5,370,976), (d) the problems with the printing of metallics / whites / opaques / encapsulated essences / and various other coatings with WIMS' '976, (e) their desire that the flexographic plates be mounted to the blanket cylinder, (f) their uses of and requirements for flexographic inks, and (g) half-tone printing, all using the new process. These matters were discussed in various meetings in August 1994, and ending, as I recall, in very late 1994.

5. The information which was conveyed to me by Bill Davis and Jesse Williamson, at the dates indicated above, often came in meetings where other printing problems of Williamson Printing Corporation were also discussed, as well as at social outings. I took this information and passed it on to various PRI personnel in order to help them design the coating device suitable to accomplish Davis-Williamson's desired process. At various times, I spoke

The undersigned Declarant stated further that all statements made herein of Declarant's own knowledge are true, and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code.



John W. Bird

4.3.00

Date:

DECLARATION

Exhibit "A"

Exhibit "A"

TPS 95257650

| THURSDAY | | |
|---------------------------|------------------|--------------------------------|
| Wk 33 • Day 230, 135 Left | | |
| AUGUST 18, 1994 | | |
| DIARY AND WORK RECORD | | |
| TIME | NAME OF PROJECT | DESCRIPTION |
| 8 | | |
| 9 | | |
| 10 | Williamson Ptg. | Bill Davis |
| 11 | Vespe Williamson | Bob Enrick. |
| 12 | AB II | Within 4 weeks. |
| 1 | | Remove SB lawsuit. HD/ES. |
| 2 | | Arrange meeting Bill/Bob/Heid* |
| 3 | | Heid - Bob Beya* |
| 4 | | |
| 5 | | |

TOP SECRET

| MONDAY | |
|---------------------------|-----------------------------|
| Wk 35 • Day 241, 124 Left | |
| AUGUST 29, 1994 | |
| DIARY AND WORK RECORD | |
| TIME | NAME OR PROJECT |
| 8:00 | Allente' <u>Rodger Meir</u> |
| 9:00 | ② HV/AB II on everything |
| 10:00 | ③ as all others plus UV. |
| 11:00 | Exhaust + STD of IR. |
| 12:00 | |
| 13:00 | |
| 14:00 | 2.45. - Williamson |
| 15:00 | Bill Davis. |
| 16:00 | 3 102+L+Y+LX * |
| 17:00 | triple tower |
| | |
| | |
| | |

APPOINTMENTS & SCHEDULED EVENTS

TO BE DONE TODAY (ACTION LIST)

o color fastech
Hi Ace

EXPENSE & REIMBURSEMENT RECORD:[illegible]

106000-9545160

| WEDNESDAY | | 31 |
|--------------------------|--------------------------|-----------------|
| Wk 40 • Day 278, 87 Left | | OCTOBER 5, 1994 |
| DIARY AND WORK RECORD | | |
| TIME | NAME | PROJECT |
| 8 | | |
| 9 | | |
| 10 | Willow Pt. | |
| 11 | Terse W. / Bill Davis | |
| 12 | Bob Enck / Bill Gonzales | |
| 1 | | |
| 2 | | |
| 3 | | |
| 4 | | |
| 5 | | |

11/14/94 09:00

MONDAY
NOVEMBER 14, 1994
APPOINTMENTS & SCHEDULED EVENTS

TIME NAME PLACE SUBJECT

TO BE DONE TODAY (ACTION LIST)

- Calls - Klearfold.
215-343-9300
1. Write to Brian Burton.
2. Sales conference visit
Trade/Williamson.
3. TV extension.

EXPENSE & REIMBURSEMENT RECORD:

Item Where? Duration? To whom? Reimbursed? Amount
What? Duration? What? Paid? By whom?

Bill Davis

TUESDAY ~~7-50-438-4192~~
 NOVEMBER 15, 1994
 APPOINTMENTS & SCHEDULED EVENTS

| TIME | NAME | PLACE | SUBJECT |
|------|--------------------------------|---------|---------|
| | Patterson Press | | |
| | Heid Sam | 5 color | |
| | 28* - 35, 600 max | | |
| | 6 Camps each side | | |
| | mostly in 22, 23 | | |
| | TO BE DONE TODAY (ACTION LIST) | | |
| | ANDERSON | | |
| | KIRK | | |
| | RICE. | | |
| | Passano | | |
| | Pressure very critical | | |
| | bounce can occur | | |
| | at 15000 sp. can | | |
| | bury bounce | | |

EXPENSE & REIMBURSEMENT RECORD:

| Date | Where? | Amount | By whom? | Amount |
|-------|-----------|--------|----------|--------|
| What? | Duration? | What? | What? | What? |
| | | | | |

Bill Davis, 214-904-2100
 Ed / Woreen / Linda Mc

TOP SECRET

| Wk 46 • Day 322, 43 Left | | FRIDAY
NOVEMBER 18, 1994 | 30 |
|--------------------------|----------------------|-----------------------------|-----|
| DIARY AND WORK RECORD | | | |
| HRS | NAME OR PROJECT | DESCRIPTION | TOT |
| 8 | 3.16. 342-4740 | Terry Stocklick | |
| 9 | Kennedy hunting unit | Tim Scott / Bishop | |
| 10 | 5.3 - 27-25.5 | | |
| 11 | 1.00 Heidelberg USA. | | |
| 12 | | | |
| 1 | | | |
| 2 | | | |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| 6 | | | |

FORM 96-0000

MONDAY
NOVEMBER 21, 1994
APPOINTMENTS & SCHEDULED EVENTS

TIME NAME PLACE SUBJECT

TO BE DONE TODAY (ACTION LIST)

Performance 319,1000
Williams on P.C-9042
3012 Firmament

700 Package

EXPENSE & REIMBURSEMENT RECORD:

Item Where? When? Duration? Cost? Reimbursed? Amount
What? Duration? What? When? By whom?

MONDAY
Wk 47 • Day 325, 40 Left
NOVEMBER 21, 1994

DIARY AND WORK RECORD

| TIME OF PROJECT | DESCRIPTION |
|-----------------|--|
| 8:30 | Jack Stoughton
Ray Heumanns |
| 9:00 | |
| 10:00 | |
| 11:00 | |
| 12:00 | Bill Davis |
| 1:30 | Bill Davis / Jesse Williams
Terry Bitten Training |
| 2:00 | |
| 3:00 | Ray late performance
66163 - 5-V Dams |
| 4:00 | 6 |
| 5:00 | |
| 7:11 | ETD. JACK STOUGHTON
FLT #1469 DELTA. |

0900-9999

| TUESDAY | | 31 |
|--------------------------|-----------------|-------------------|
| Wk 51 • Day 354, 11 Left | | DECEMBER 20, 1994 |
| DIARY AND WORK RECORD | | |
| HRS | NAME OR PROJECT | DESCRIPTION |
| 8
0800 | WILLIAMSON PTG. | |
| 9
0900 | | |
| 10
1000 | | |
| 11
1100 | | |
| 12
1200 | | |
| 1
1300 | | |
| 2
1400 | | |
| 3
1500 | | |
| 4
1600 | | |
| 5
1700 | | |
| | | |

0001 0000 0000 0000

| WEDNESDAY | | 31 |
|--------------------------|-----------------|-------------------|
| Wk 51 • Day 355, 10 Left | | DECEMBER 21, 1994 |
| DIARY AND WORK RECORD | | |
| PS | NAME OF PROJECT | DESCRIPTION |
| 8 | 0800 | WILLIAMSON Ptg. |
| 9 | 0900 | |
| 10 | 1000 | |
| 11 | 1100 | |
| 12 | 1200 | |
| 1 | 1300 | |
| 2 | 1400 | |
| 3 | 1500 | |
| 4 | 1600 | |
| 5 | 1700 | |
| | | |
| | | |
| | | |

TOP SECRET

| WEDNESDAY
JANUARY 4, 1995 | | 3 |
|------------------------------|----------------------|-------------|
| Wk 1 • Day 4, 361 Left | | |
| DIARY AND WORK RECORD | | |
| HR | NAME OR PROJECT | DESCRIPTION |
| 8 | | |
| 9 | | |
| 10 | | |
| 11 | | |
| 12 | | |
| 1 | AGI Wayne Fox | |
| 2 | Mike Curtis | |
| 3 | Metallic/fluorescent | |
| 4 | Hartman Steinberg | |
| 5 | Toronto | |
| 6 | Dave Deffen | |
| 7 | 416-438-1622 | |
| 8 | <u>Metallic</u> | |
| 9 | | |
| 10 | | |
| 11 | | |
| 12 | | |

106030 9625760

| THURSDAY | | 31 |
|-------------------------|-----------------|---|
| Wk 2 • Day 12: 353 Left | | JANUARY 12, 1995 |
| DIARY AND WORK RECORD | | |
| HRS | NAME OR PROJECT | DESCRIPTION |
| 8 | | Kansas City. |
| 9 | | Burd & Fletcher ^{Weekend} 2 st |
| 10 | | Midland Litho.
Cancelled. |
| 11 | | |
| 12 | | |
| 1 | | |
| 2 | | St Louis Litho. |
| 3 | | 314-352-1300 |
| 4 | | Russ Kunge |
| 5 | | Joe Stein |
| 6 | | Very interested w/ to
match at least 90% of bronze |
| 7 | | |
| 8 | | Chicago. |
| 9 | | 9:00 Call Frank 301-942-8572 |

106050-96257E60

| MONDAY | | 31 |
|-------------------------|-----------------|------------------|
| Wk 5 • Day 30, 335 Left | | JANUARY 30, 1995 |
| DIARY AND WORK RECORD | | |
| PS | NAME OR PROJECT | DESCRIPTION |
| 8 | | |
| 9 | | |
| 10 | | |
| 11 | | |
| 12 | | |
| 1 | | |
| 2 | 30 Williamson | g. G. |
| 3 | | |
| 4 | | |
| 5 | | |
| | | |
| | | |
| | | |

| SUNDAY | MONDAY | TUESDAY | WEDNESDAY |
|--------------------|-----------------|---------|-----------|
| | | | 1 |
| | LURE & FLETCHER | | |
| | | | D |
| 5 | 6 | 7 | 8 |
| <u>WILLIAMS ON</u> | | | |
| 12 | 13 | 14 | 15 |
| ADVANCED
TIBER | | | |
| 19 | 20 | 21 | 22 |
| ADVANCED
TIBER. | | | |
| 26 | 27 | 28 | |
| January | | | |
| S | M | T | W |
| 1 | 2 | 3 | 4 |
| 5 | 6 | 7 | 8 |
| 9 | 10 | 11 | 12 |
| 13 | 14 | 15 | 16 |
| 17 | 18 | 19 | 20 |
| 21 | 22 | 23 | 24 |
| 25 | 26 | 27 | 28 |
| 29 | 30 | 31 | |

Wk 6 • Day 40, 325 Left

THURSDAY
FEBRUARY 9, 1995

28

DIARY AND WORK RECORD
PROJECT _____

| DIARY AND WORK RECORD | | NAME OR PROJECT | DESCRIPTION |
|-----------------------|------|----------------------------------|-------------|
| 1 | 0800 | Call Bill Davis / W. O. O'Connor | |
| 2 | 0900 | Bob Sweet quote 2 lamp | |
| 3 | 1000 | and 4 over 4 'old' CV | |
| 4 | 1100 | 26" / 26" | |
| 5 | 1200 | | |
| 6 | 1300 | | |
| 7 | 1400 | | |
| 8 | 1500 | | |
| 9 | 1600 | | |
| 10 | 1700 | | |

FORM 862-5 FEB 60

Wk 6 • Day 42, 323 Left

SATURDAY
FEBRUARY 11, 1995

28

DIARY AND WORK RECORD

| HRS | NAME OR PROJECT | DESCRIPTION | TOTAL |
|-----|---------------------|-------------|-------|
| 8 | | | |
| 9 | 00 - HD/Williamson. | | |
| 10 | | | |
| 11 | | | |
| 12 | | | |
| 1 | | | |
| 2 | | | |
| 3 | | | |
| 4 | | | |
| 5 | | | |
| | 30 miles | | |

041590-05001

| WEDNESDAY | | 28 |
|--------------------------|-------------------|----------------------------|
| FEBRUARY 15, 1995 | | |
| Wk. 7 • Day 46, 319 Left | | |
| DIARY AND WORK RECORD | | |
| HRS | NAME OR PROJECT | DESCRIPTION |
| 8
0800 | Vent-A-Hood order | Touch pad - tlV on LYL |
| 9
0900 | Schedule LYL | MD Both samples |
| 10
1000 | Wolstenholme | visiting April 11 onwards. |
| 11
1100 | 30 Bill Davis | |
| 12
1200 | | |
| 1
1300 | | |
| 2
1400 | | |
| 3
1500 | | |
| 4
1600 | | |
| 5
1700 | | |

| REFS | NAME | PLACE | SUBJECT |
|------|------|-------|---------|
|------|------|-------|---------|

Silver Wolstenholme
How much?
Gold

TO BE DONE TODAY (ACTION LIST)

EXPENSE & REIMBURSEMENT RECORD:

| Item
What? | Where?
Duration? | Purpose-Who
What involved? | To whom
Paid? | Reimbursed?
By whom? | Amount |
|---------------|---------------------|-------------------------------|------------------|-------------------------|--------|
|---------------|---------------------|-------------------------------|------------------|-------------------------|--------|

| Sampling site | | Date of collection | | Temperature (°C) | | pH | | Dissolved oxygen (mg/l) | | Total dissolved solids (mg/l) | | Total suspended solids (mg/l) | | Total phosphorus (mg/l) | | Total nitrogen (mg/l) | | Ammonia nitrogen (mg/l) | | Nitrate nitrogen (mg/l) | | Nitrite nitrogen (mg/l) | | Chlorophyll <i>a</i> (µg/l) | | Chlorophyll <i>b</i> (µg/l) | | Chlorophyll <i>c</i> (µg/l) | | Chlorophyll <i>d</i> (µg/l) | | Chlorophyll <i>e</i> (µg/l) | | Chlorophyll <i>f</i> (µg/l) | | Chlorophyll <i>g</i> (µg/l) | | Chlorophyll <i>h</i> (µg/l) | | Chlorophyll <i>i</i> (µg/l) | | Chlorophyll <i>j</i> (µg/l) | | Chlorophyll <i>k</i> (µg/l) | | Chlorophyll <i>l</i> (µg/l) | | Chlorophyll <i>m</i> (µg/l) | | Chlorophyll <i>n</i> (µg/l) | | Chlorophyll <i>o</i> (µg/l) | | Chlorophyll <i>p</i> (µg/l) | | Chlorophyll <i>q</i> (µg/l) | | Chlorophyll <i>r</i> (µg/l) | | Chlorophyll <i>s</i> (µg/l) | | Chlorophyll <i>t</i> (µg/l) | | Chlorophyll <i>u</i> (µg/l) | | Chlorophyll <i>v</i> (µg/l) | | Chlorophyll <i>w</i> (µg/l) | | Chlorophyll <i>x</i> (µg/l) | | Chlorophyll <i>y</i> (µg/l) | | Chlorophyll <i>z</i> (µg/l) | | Chlorophyll <i>aa</i> (µg/l) | | Chlorophyll <i>ab</i> (µg/l) | | Chlorophyll <i>ac</i> (µg/l) | | Chlorophyll <i>ad</i> (µg/l) | | Chlorophyll <i>ae</i> (µg/l) | | Chlorophyll <i>af</i> (µg/l) | | Chlorophyll <i>ag</i> (µg/l) | | Chlorophyll <i>ah</i> (µg/l) | | Chlorophyll <i>ai</i> (µg/l) | | Chlorophyll <i>aj</i> (µg/l) | | Chlorophyll <i>ak</i> (µg/l) | | Chlorophyll <i>al</i> (µg/l) | | Chlorophyll <i>am</i> (µg/l) | | Chlorophyll <i>an</i> (µg/l) | | Chlorophyll <i>ao</i> (µg/l) | | Chlorophyll <i>ap</i> (µg/l) | | Chlorophyll <i>aq</i> (µg/l) | | Chlorophyll <i>ar</i> (µg/l) | | Chlorophyll <i>as</i> (µg/l) | | Chlorophyll <i>at</i> (µg/l) | | Chlorophyll <i>au</i> (µg/l) | | Chlorophyll <i>av</i> (µg/l) | | Chlorophyll <i>aw</i> (µg/l) | | Chlorophyll <i>ax</i> (µg/l) | | Chlorophyll <i>ay</i> (µg/l) | | Chlorophyll <i>az</i> (µg/l) | | Chlorophyll <i>ba</i> (µg/l) | | Chlorophyll <i>bb</i> (µg/l) | | Chlorophyll <i>bc</i> (µg/l) | | Chlorophyll <i>bd</i> (µg/l) | | Chlorophyll <i>be</i> (µg/l) | | Chlorophyll <i>bf</i> (µg/l) | | Chlorophyll <i>bg</i> (µg/l) | | Chlorophyll <i>bh</i> (µg/l) | | Chlorophyll <i>bi</i> (µg/l) | | Chlorophyll <i>bj</i> (µg/l) | | Chlorophyll <i>bk</i> (µg/l) | | Chlorophyll <i>bl</i> (µg/l) | | Chlorophyll <i>bm</i> (µg/l) | | Chlorophyll <i>bn</i> (µg/l) | | Chlorophyll <i>bo</i> (µg/l) | | Chlorophyll <i>bp</i> (µg/l) | | Chlorophyll <i>bq</i> (µg/l) | | Chlorophyll <i>br</i> (µg/l) | | Chlorophyll <i>bs</i> (µg/l) | | Chlorophyll <i>bt</i> (µg/l) | | Chlorophyll <i>bu</i> (µg/l) | | Chlorophyll <i>bv</i> (µg/l) | | Chlorophyll <i>bw</i> (µg/l) | | Chlorophyll <i>bx</i> (µg/l) | | Chlorophyll <i>by</i> (µg/l) | | Chlorophyll <i>bz</i> (µg/l) | | Chlorophyll <i>ca</i> (µg/l) | | Chlorophyll <i>cb</i> (µg/l) | | Chlorophyll <i>cc</i> (µg/l) | | Chlorophyll <i>cd</i> (µg/l) | | Chlorophyll <i>ce</i> (µg/l) | | Chlorophyll <i>cf</i> (µg/l) | | Chlorophyll <i>cg</i> (µg/l) | | Chlorophyll <i>ch</i> (µg/l) | | Chlorophyll <i>ci</i> (µg/l) | | Chlorophyll <i>cj</i> (µg/l) | | Chlorophyll <i>ck</i> (µg/l) | | Chlorophyll <i>cl</i> (µg/l) | | Chlorophyll <i>cm</i> (µg/l) | | Chlorophyll <i>cn</i> (µg/l) | | Chlorophyll <i>co</i> (µg/l) | | Chlorophyll <i>cp</i> (µg/l) | | Chlorophyll <i>cq</i> (µg/l) | | Chlorophyll <i>cr</i> (µg/l) | | Chlorophyll <i>cs</i> (µg/l) | | Chlorophyll <i>ct</i> (µg/l) | | Chlorophyll <i>cu</i> (µg/l) | | Chlorophyll <i>cv</i> (µg/l) | | Chlorophyll <i>cw</i> (µg/l) | | Chlorophyll <i>cx</i> (µg/l) | | Chlorophyll <i>cy</i> (µg/l) | | Chlorophyll <i>cz</i> (µg/l) | | Chlorophyll <i>da</i> (µg/l) | | Chlorophyll <i>db</i> (µg/l) | | Chlorophyll <i>dc</i> (µg/l) | | Chlorophyll <i>dd</i> (µg/l) | | Chlorophyll <i>de</i> (µg/l) | | Chlorophyll <i>df</i> (µg/l) | | Chlorophyll <i>dg</i> (µg/l) | | Chlorophyll <i>dh</i> (µg/l) | | Chlorophyll <i>di</i> (µg/l) | | Chlorophyll <i>dj</i> (µg/l) | | Chlorophyll <i>dk</i> (µg/l) | | Chlorophyll <i>dl</i> (µg/l) | | Chlorophyll <i>dm</i> (µg/l) | | Chlorophyll <i>dn</i> (µg/l) | | Chlorophyll <i>do</i> (µg/l) | | Chlorophyll <i>dp</i> (µg/l) | | Chlorophyll <i>dq</i> (µg/l) | | Chlorophyll <i>dr</i> (µg/l) | | Chlorophyll <i>ds</i> (µg/l) | | Chlorophyll <i>dt</i> (µg/l) | | Chlorophyll <i>du</i> (µg/l) | | Chlorophyll <i>dv</i> (µg/l) | | Chlorophyll <i>dw</i> (µg/l) | | Chlorophyll <i>dx</i> (µg/l) | | Chlorophyll <i>dy</i> (µg/l) | | Chlorophyll <i>dz</i> (µg/l) | | Chlorophyll <i>ea</i> (µg/l) | | Chlorophyll <i>eb</i> (µg/l) | | Chlorophyll <i>ec</i> (µg/l) | | Chlorophyll <i>ed</i> (µg/l) | | Chlorophyll <i>ee</i> (µg/l) | | Chlorophyll <i>ef</i> (µg/l) | | Chlorophyll <i>eg</i> (µg/l) | | Chlorophyll <i>eh</i> (µg/l) | | Chlorophyll <i>ei</i> (µg/l) | | Chlorophyll <i>ej</i> (µg/l) | | Chlorophyll <i>ek</i> (µg/l) | | Chlorophyll <i>el</i> (µg/l) | | Chlorophyll <i>em</i> (µg/l) | | Chlorophyll <i>en</i> (µg/l) | | Chlorophyll <i>eo</i> (µg/l) | | Chlorophyll <i>ep</i> (µg/l) | | Chlorophyll <i>eq</i> (µg/l) | | Chlorophyll <i>er</i> (µg/l) | | Chlorophyll <i>es</i> (µg/l) | | Chlorophyll <i>et</i> (µg/l) | | Chlorophyll <i>eu</i> (µg/l) | | Chlorophyll <i>ev</i> (µg/l) | | Chlorophyll <i>ew</i> (µg/l) | | Chlorophyll <i>ex</i> (µg/l) | | Chlorophyll <i>ey</i> (µg/l) | | Chlorophyll <i>ez</i> (µg/l) | | Chlorophyll <i>fa</i> (µg/l) | | Chlorophyll <i>fb</i> (µg/l) | | Chlorophyll <i>fc</i> (µg/l) | | Chlorophyll <i>fd</i> (µg/l) | | Chlorophyll <i>fe</i> (µg/l) | | Chlorophyll <i>ff</i> (µg/l) | | Chlorophyll <i>fg</i> (µg/l) | | Chlorophyll <i>fh</i> (µg/l) | |
|---------------|--|--------------------|--|------------------|--|----|--|-------------------------|--|-------------------------------|--|-------------------------------|--|-------------------------|--|-----------------------|--|-------------------------|--|-------------------------|--|-------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------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|---------------|--|--------------------|--|------------------|--|----|--|-------------------------|--|-------------------------------|--|-------------------------------|--|-------------------------|--|-----------------------|--|-------------------------|--|-------------------------|--|-------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|-----------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------------------|--|------------------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09450-9645000

Wk 8 • Day 55, 310 Left

FRIDAY
FEBRUARY 24, 1995

28

DIARY AND WORK RECORD

| HRS | NAME OR PROJECT | DESCRIPTION | TIME |
|--|--|---|------|
| 8
12
24
36
0800 ⁴⁸ | | | |
| 9
12
24
36
0900 ⁴⁸ | Williamson Ptz | | |
| 10
12
24
36
1000 ⁴⁸ | Ed Emek / Bill Davis
Jesse Williamson | after | |
| 11
12
24
36
1100 ⁴⁸ | | Drying on impression 1/45 min
Nothing showing on densitometer
Wet Trap / Dry Trap / HV Trap | |
| 12
12
24
36
1200 ⁴⁸ | | Lowish definite advantage.
Mechanical shutter for edge. | |
| 1
12
24
36
1300 ⁴⁸ | | 7 color every unit.
Hvon L46 only. | |
| 2
12
24
36
1400 ⁴⁸ | | | |
| 3
12
24
36
1500 ⁴⁸ | | | |
| 4
12
24
36
1600 ⁴⁸ | | | |
| 5
12
24
36
1700 ⁴⁸ | | | |

0001-96-000000

Wk 9 • Day 60 305 Left

WEDNESDAY
MARCH 1, 1995

31

DIARY AND WORK RECORD

| PS | NAME OR PROJECT | DESCRIPTION | TIME |
|----|---------------------------------|---------------------------------------|------|
| 8 | | | |
| 9 | Advanced Litho. Tullius Domates | Needs to look at E2 | |
| 10 | metallic application | a sap. | |
| 11 | | He continues to want to work with E2. | |
| 12 | | Buckin got great future. | |
| 1 | Terry Meyers - GAC | Need to come to Dallas. | |
| 2 | | | |
| 3 | Ron Sory - Bofors | Heidelberg Egypt. | |
| 4 | Heid. 74 is of strong interest | over next 12 months. | |
| 5 | | | |
| | | | |
| | | | |

APPOINTMENTS & SCHEDULED EVENTS

| DATE | NAME | PLACE | SUBJECT |
|------|------|-------|---------|
|------|------|-------|---------|

① Venta - food control on delivery?

② 4:1 complete Wednesday.

TO BE DONE TODAY (ACTION LIST)

D1 Charge.

EXPENSE & REIMBURSEMENT RECORD:

| am
vhr? | Where? | How long? | By whom? | How long? | How long? | How long? | How long? |
|------------|--------|-----------|----------|-----------|-----------|-----------|-----------|
| | | | | | | | |

[illegible]

| FRIDAY
MARCH 10, 1995 | | 31 |
|--------------------------|---------------------------|-------------|
| Wk 10 • Day 69. 296 Left | | |
| DIARY AND WORK RECORD | | |
| HR | NAME OR PROJECT | DESCRIPTION |
| 8
24
2800 | Tim Johnson
Bill Davis | |
| 9
24
28
0900 | Bob Enrick. | |
| 10
24
28
1000 | Williamson P.C. | |
| 11
24
28
1100 | delay off get all shots | |
| 12
24
28
1200 | H | |
| 1
24
28
1300 | | |
| 2
24
28
1400 | | |
| 3
24
28
1500 | | |
| 4
24
28
1600 | | |
| 5
24
28
1700 | | |

0621296 0503001

| Wk 14 • Day 94, 271 Left | | TUESDAY
APRIL 4, 1995 | | 30 |
|--------------------------|-----------------------------|--------------------------|------|----|
| DIARY AND WORK RECORD | | | | |
| HRS | NAME OR PROJECT | DESCRIPTION | TIME | |
| 8
0800 | WILIAMSON - MD. BOTH. | | | |
| 9
0900 | DICK MARSHAL
CHUCK GLASS | | | |
| 10
1000 | | | | |
| 11
1100 | | | | |
| 12
1200 | | | | |
| 1
1300 | | | | |
| 2
1400 | | | | |
| 3
1500 | | | | |
| 4
1600 | | | | |
| 5
1700 | | | | |
| | | | | |

APPOINTMENTS & SCHEDULED EVENTS

| RS | NAME | PLACE | SUBJECT |
|----|------|-------|---------|
|----|------|-------|---------|

TO BE DONE TODAY (ACTION LIST)

1. Marking - Coating tower when ~~not~~ coating.
2. Exclusivity: 6 months USA. - 12 months - ~~Ind.~~

EXPENSE & REIMBURSEMENT RECORD:

| Item
What? | Where?
Duration? | Purpose-Who
What involved? | To whom
Paid? | Reimbursed?
By whom? | Amount |
|---------------|---------------------|-------------------------------|------------------|-------------------------|--------|
|---------------|---------------------|-------------------------------|------------------|-------------------------|--------|

106090" 96251200

Wk 14 • Day 96, 269 Left

THURSDAY
APRIL 6, 1995

30

DIARY AND WORK RECORD

| HRS | NAME OR PROJECT | DESCRIPTION | TIN |
|--------------------------|-----------------|---|-----|
| 8 ¹²
0800 | | 400 CFM = 1 ton, | |
| 9 ¹²
0900 | | | |
| 10 ¹²
1000 | | | |
| 11 ¹²
1100 | | | |
| 12 ¹²
1200 | | What is correct an Cox | |
| 1 ¹²
1300 | | | |
| 2 ¹²
1400 | Williamson Fair | Bill Davis
A. EXECUTIVE ?
Jim Johnson | |
| 3 ¹²
1500 | | B. Sample 1 - Lyle - Litchman - red.
C. FIV on #1 PRT - Litchman - red.
D. VISIT - Von Hoffmann
General Contractor | |
| 4 ¹²
1600 | | E. Art Canvas - ACox | |
| 5 ¹²
1700 | | Vesse Williamson.
4:30 Jim Johnson | |

001596-000901

Wk 17 • Day 115, 250 Left

TUESDAY
APRIL 25, 1995

30

DIARY AND WORK RECORD

| HRS | NAME OR PROJECT | DESCRIPTION |
|------------|---------------------------------------|-------------|
| 8
0800 | | |
| 9
0900 | | |
| 10
1000 | Williamson Ag Co. | |
| 11
1100 | Bill Davis / Tim Wilson
Bob Enrick | |
| 12
1200 | Casket Creek | |
| | 24 hrs in a day center | |
| 1
1300 | Bob to run Friday | |
| | Testing Thursday | |
| 2
1400 | Anchor reading white? | |
| | Gold? | |
| 3
1500 | Tramming | |
| 4
1600 | Water. 23 | |
| 5
1700 | | |

TOP SECRET

**TUESDAY
MAY 2, 1995
APPOINTMENTS & SCHEDULED EVENTS**

| HRS | NAME | PLACE | SUBJECT |
|-----|------|-------|---------|
|-----|------|-------|---------|

TO BE DONE TODAY (ACTION LIST)

1. L. H. Hooper. ✓
2. Great Western ✓
3. ~~Graphic Arts Monthly / GATF~~
4. Gross Back.
5. ~~HV 11/2/95/11/2/95~~
6. ~~On order - gold - Bill~~
7. ~~Exclusivity:-~~
8. ~~Timeline - EZ's :-~~
9. Posters/Post Cards. ✓

EXPENSE & REIMBURSEMENT RECORD:

| Item
What? | Where?
Duration? | Purpose-Who
What involved? | To whom
Paid? | Reimbursed?
By whom? | Amount |
|--|---------------------|-------------------------------|------------------|-------------------------|--------|
| Pulled job - fit was problem.
excessive team -
pinholing | | | | | |

0011596-050944

| Wk 18 • Day 122, 243 Left | | TUESDAY
MAY 2, 1995 | | 30 |
|---------------------------|-----------------------|-------------------------|------|----|
| DIARY AND WORK RECORD | | | | |
| HRS | NAME OR PROJECT | DESCRIPTION | TIME | |
| 8 ¹²
0800h | label | | | |
| | Carton | | | |
| 9 ¹²
0900h | Greeting | | | |
| | 1st Period | N. America | | |
| 10 ¹²
1000h | | + AZ, CO. | | |
| | 1st liberation | 90 days | | |
| 11 ¹²
1100h | | to install 1 and 2 yrs. | | |
| 12 ¹²
1200h | | | | |
| 1 ¹²
1300h | 1.30 Jesse W. Olmson. | | | |
| | Bill Davis | | | |
| 2 ¹²
1400h | 300 Anker | take back. | | |
| | leafing silver | Olsen | | |
| 3 ¹²
1500h | | to WPC. | | |
| 4 ¹²
1600h | UV lamps | moved down. | | |
| | PO # 331.5 | 1st down | | |
| 5 ¹²
1700h | | cover | | |
| | UV for 8 color | E2. | | |

(#25)

706007 96 4 11

Exhibit "B"

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 0 741 025 A3

(12)

EUROPEAN PATENT APPLICATION

(88) Date of publication A3:
28.05.1997 Bulletin 1997/22

(51) Int. Cl.⁶: B41F 31/30, B41F 5/24,
B41F 23/08

(43) Date of publication A2:
06.11.1996 Bulletin 1996/45

(21) Application number: 96303136.4

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(84) Designated Contracting States:
DE FR GB IT SE

(30) Priority: 04.05.1995 US 435798

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(54) Retractable inking/coating apparatus having ferris movement between printing units

(57) A retractable in-line inking/coating apparatus (10) selectively applies either spot or overall ink/coating material to a blanket (B) or flexographic plate (P) on a blanket cylinder (34), or spot or overall ink/coating to a flexographic printing plate (P) on a plate cylinder (32) in a rotary offset printing press (12). The inking/coating apparatus is pivotally mounted on a printing unit (22, 24,

26, 28) or dedicated coating unit, and is extendable into and retractable out of an operative inking/coating position by a carriage assembly (58) which is pivotally coupled to the printing unit. Because of the pivotal support provided by a cantilevered support arm (88, 90), the inking/coating apparatus is extended and retracted through a Ferris wheel arc between adjacent printing units.

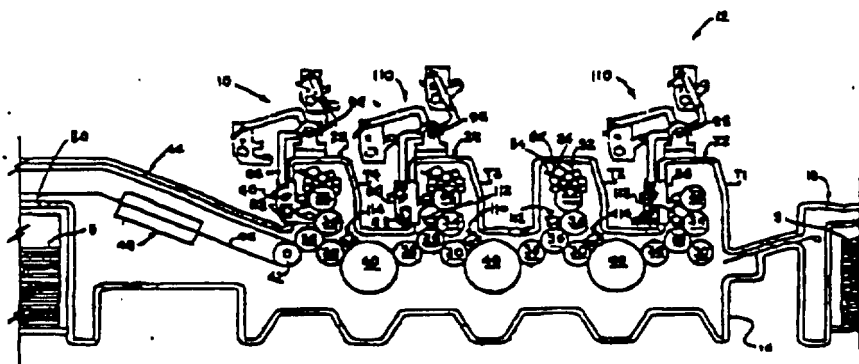


FIG. 1



European Patent
Office

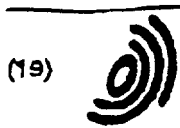
EUROPEAN SEARCH REPORT

Application Number
EP 96 30 3136

| DOCUMENTS CONSIDERED TO BE RELEVANT | | | |
|--|--|---|---|
| Category | Citation of document with indication, where appropriate, of relevant passages | Relevant to claim | CLASSIFICATION OF THE APPLICATION (Int. Cl. 6) |
| X
Y | US 4 841 903 A (BIRD)

* abstract; claims; figure 1 * | 1,15-17
4-6,8,9,
13 | B41F31/30
B41F5/24
B41F23/08 |
| X | US 5 107 790 A (SLIKER ET AL.)
* abstract; claim 1; figures *
* column 2, line 9 - line 22 * | 1,18 | |
| Y | US 5 335 596 A (DEMOORE ET AL.)
* abstract; figures 1-4 *
* column 7, line 32 - line 58 * | 4,5,8,9 | |
| Y | US 4 617 865 A (SWITALL)
* abstract; figures 1-3 *
* column 6, line 9 - line 42 * | 6 | |
| Y | US 4 825 804 A (DIRICO ET AL.)
* abstract; figures 2,3 *
* column 3, line 10 - line 21 * | 13 | |
| A | EP 0 647 524 A (DEMOORE)
* abstract; figures 1,2,5 *
* column 4, line 32 - line 40 * | 15-22 | TECHNICAL FIELDS
SEARCHED (Int. Cl. 6)
B41F |
| A | PAPIER + KUNSTSTOFF VERARBEITER,
vol. 26, no. 6, 1 June 1991,
page 129 XP000232025 "LACKIER-AGGREGAT
FUER SPEEDMASTER-MASCHINEN"
----- | I | |
| The present search report has been drawn up for all claims | | | |
| Place of search
THE HAGUE | | Date of completion of the search
20 March 1997 | Searcher
Hapiö, T |
| <p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone
Y : particularly relevant if combined with another document of the same category
A : technological background
O : non-written disclosure
F : foreign office document</p> <p>T : theory or principle underlying the invention
E : earlier patent document, but published on, or after the filing date
D : document cited in the application
L : document cited for other reasons
A : number of the same patent family, corresponding document</p> | | | |

EP FORM 1200/1-97 (PCT)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 0 741 025 A2

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EUROPEAN PATENT APPLICATION

(43) Date of publication:
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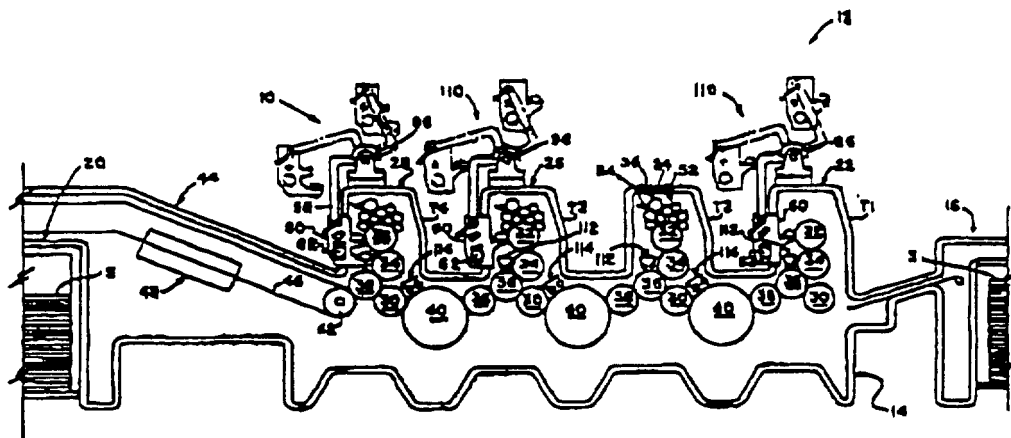


FIG. 1

Description

This invention relates to sheet-fed or web-fed, rotary offset or flexographic printing presses, and more particularly, to a new and improved inking/coating apparatus for the in-line application of printing inks or protective or decorative coatings to sheet or web substrates.

Conventional sheet-fed, rotary offset printing presses typically include one or more printing units through which individual sheets are fed and printed with wet ink. Since the inks used with rotary offset printing presses typically remain wet and tacky for some time after printing, special precautions must be taken to insure that the freshly printed sheets are not marked or smeared as the sheets are transferred from one printing unit to another, and while being conveyed to the sheet delivery stacker. The printed surface of the freshly printed sheet dries relatively slowly and can be smeared during subsequent transfer between printing units. In order to reduce smearing and offsetting, spray powder is applied on the printed sheet.

In some printing applications, offset and smearing are prevented by applying a protective and/or decorative coating over all or a portion of the freshly printed sheets. Various arrangements have been proposed for applying the protective or decorative coating as an in-line operation by using the last printing unit of the press as the coating application unit. However, when such in-line coating is performed, the last printing unit cannot be used to apply ink to the sheets, and can only be used for the coating operation. Thus, while coating with these types of in-line coating apparatus, the press loses the capability of printing its full range of colors since the last printing unit is converted to a coating unit.

It will be appreciated that the time required to reconfigure a press for coating or non-coating is non-productive and costly. Accordingly, there is a need for an in-line coating apparatus that minimizes the time to clean-up from one printing run and set-up and run the next job. Where consecutive jobs require the same type of coating, particularly blanket coating, it may not be necessary to clean-up the coater between jobs. However, the coating material cannot be allowed to dry on the rollers. Therefore, especially when switching from blanket to spot coating or vice versa, or if there is a delay between jobs, it is necessary to wash-up the coater after each job is completed.

In addition, coater wash-up is necessary when switching between different coating compositions, such as aqueous and ultra violet (UV) curable coatings. Such coating materials are not interchangeable, and consequently, the coater must be washed between applications of different coating media.

The foregoing limitations are overcome, according to the present invention, by a retractable, in-line inking/coating apparatus which is mounted on a printing unit for pivotal, Ferris wheel movement between an operative inking/coating position and a retracted, overhead idle position. The inking/coating apparatus

includes an applicator head which, is positioned in alignment with either the plate cylinder or the blanket cylinder by a carriage assembly which includes a cantilevered support arm. The support arm is pivotally coupled between the inking/coating head and the printing unit tower. This cantilevered, pivotal mounting arrangement allows the inking/coating unit to be used between two printing units, as well as on the last printing unit of the press.

In the preferred embodiment, the applicator head includes vertically spaced pairs of cradle members with one cradle pair being adapted for supporting a metal or ceramic coating roller in alignment with a blanket cylinder, and the other cradle pair supporting a resilient anilox coating roller in alignment with the plate cylinder, respectively, when the carriage assembly is in the operative position. Because of the cantilevered, pivotal support provided by the support arm, the applicator head can be lifted and lowered through an arc, similar to Ferris wheel movement, in the limited space between adjacent printing units. When fully retracted, the applicator head and carriage assembly are lifted to an elevated, retracted overhead position, preferably an overhead position overlying the printing unit tower, thus providing complete access to the interstation space and the printing unit cylinders without causing the printing unit to lose its printing capability. The inking/coating applicator roller of the applicator head can be inspected, cleaned or replaced and the doctor blade assembly can be washed-up automatically while the inking/coating apparatus is in the retracted position.

When the inking/coating apparatus is used in combination with a flexographic printing plate and aqueous ink or aqueous coating, the water component of the aqueous ink or coating on the freshly printed sheet is evaporated by a high velocity, hot air interstation dryer and a high volume heat and moisture extractor assembly so that the freshly printed ink or coating is completely dry before the sheet is printed on the next printing unit. This quick drying flexographic printing/coating arrangement permits a base coat of ink, for example opaque white or metallic ink (gold, silver or other metallics) to be applied in the first printing unit, and then overprinted by a lithographic process on the next printing unit.

Exemplary embodiments of the present invention are illustrated in the drawing figures wherein:

FIGURE 1 is a schematic side elevational view of a sheet-fed, rotary offset printing press having inking/coating apparatus embodying the present invention;

FIGURE 2 is a perspective view of the printing press of FIGURE 1 in which a dual head inking/coating apparatus is in the operative coating position and a single head coater is in a retracted, overhead position;

FIGURE 3 is an enlarged simplified perspective view showing one side of the single head ink-

ing/coating apparatus of FIGURE 1 in the operative position;

FIGURE 4 is a simplified side elevational view showing the dual head inking/coating apparatus in the operative coating position for spot or overall coating from the blanket position;

FIGURE 5 is a simplified side elevational view showing the single head inking/coating apparatus in the operative coating position for spot or overall coating from the plate position; and,

FIGURE 6 is a simplified side elevational view of the dual head inking/coating apparatus of FIGURE 4, partially broken away, which illustrates the hydraulic drive assembly and doctor blade assembly.

As used herein, the term "processed" refers to various printing methods which may be applied to either side of a substrate, including the application of UV-curable and aqueous inks and/or coatings. The term "substrate" refers to sheet or web material. Also, as used herein, the term "waterless printing plate" refers to a printing plate having non-image surface areas which are hydrophobic and also having image surface areas which are hydrophilic, wherein the non-image surface areas are characterized by a surface tension value which is less than the surface tension of aqueous ink, and the image surface areas are characterized by a surface tension value which is greater than the surface tension of aqueous ink. "Flexographic" refers to flexible printing plates having a relief surface which is wettable by aqueous ink or aqueous coating material.

As shown in the exemplary drawings, the present invention is embodied in a new and improved in-line inking/coating apparatus 10, for applying inks or protective and/or decorative coatings to sheets or webs printed in a sheet-fed or web-fed, rotary offset or flexographic printing press, herein generally designated 12. In this instance, as shown in FIGURE 1, the inking/coating apparatus 10 is installed in a four color printing press 12, such as that manufactured by Heidelberger Druckmaschinen AG of the Federal Republic of Germany under its designation Heidelberg Speedmaster 102V. The press 12 includes a press frame 14 coupled at one end, herein the right end, to a sheet feeder 16 from which sheets, herein designated S, are individually and serially fed into the press, and at the opposite end, with a sheet delivery stacker 20 in which the freshly printed sheets are collected and stacked. Interposed between the sheet feeder 16 and the sheet delivery stacker 20 are four substantially identical rotary offset printing units 22, 24, 26 and 28 which can print different color inks onto the sheets as they are transferred through the press 12. The printing units are housed within printing towers T1, T2, T3 and T4 formed by side frame members 14, 15.

As illustrated, the printing units 22, 24, 26 and 28 are substantially identical and of conventional design. The first printing unit 22 includes an in-feed transfer cyl-

inder 30, a plate cylinder 32, a blanket cylinder 34 and an impression cylinder 36, all supported for rotation in parallel alignment between the press side frames 14, 15. Each of the first three printing units 22, 24 and 26 have an interunit transfer cylinder 38 disposed to transfer the freshly printed sheets from the adjacent impression cylinder to the next printing unit via an interstation transfer cylinder 40. The last printing unit 28 is shown equipped with a delivery cylinder 42 which guides each freshly printed sheet 18 as it is transferred from the last impression cylinder 36 to a delivery conveyor system, generally designated 44, to the sheet delivery stacker 20.

The delivery conveyor system 44 as shown in FIGURE 2 is of conventional design and includes a pair of continuous delivery gripper chains 46, only one of which is shown carrying at regular spaced locations along the chains, laterally disposed gripper bars having gripper fingers for gripping the leading edge of a freshly printed sheet 18 after it leaves the nip between the delivery cylinder 42 and impression cylinder 36 of the last printing unit 28. As the leading edge is gripped by the grippers, the delivery chains 46 pull the freshly printed sheet away from the impression cylinder 36 and deliver the freshly printed sheet to the sheet delivery stacker 20.

Prior to reaching the delivery sheet stacker, the freshly printed and/or coated sheets S pass under a delivery dryer 48 which includes a combination of infrared thermal radiation, high velocity hot air flow and heat and moisture extraction for drying the ink and/or the protective/decorative coating on the freshly printed sheets.

In the exemplary embodiment shown in FIGURE 1, the first printing unit 22 is equipped with a flexographic printing plate, and does not require an inking roller train or a dampening system. If an ink roller train is mounted on the first printing unit, the form rollers are retracted and locked off when the printing unit goes on impression. Flexographic aqueous ink is supplied by the inking/coating unit 110. The remaining printing units 24, 26 and 28 are equipped for lithographic printing and include an inking apparatus 50 having an inking roller train 52 arranged to transfer ink from an ink fountain 54 to the plate cylinder 32. This is accomplished with the aid of a fountain roller 56 and a doctor roller. The fountain roller 56 projects into the ink fountain 54, whereupon its surface is wetted with printing ink Q. The printing ink Q is transferred intermittently to the inking roller train 52 by the doctor roller. The inking roller train 52 supplies printing ink Q to the image area of a printing plate P mounted on the plate cylinder 32.

The printing ink Q is transferred from the printing plate P to an ink receptive blanket B which is mounted on the blanket cylinder 34. The inked image carried on the blanket B is transferred to a sheet S as the sheet is transferred through the nip between the impression cylinder 36 and the blanket B.

The inking roller arrangement 52 illustrated in FIGURE 1 is exemplary for use in combination with lithographic ink printing plates. It will be understood that

dampening rollers (not illustrated) will be in direct engagement with the lithographic plate P, but are not used in combination with the flexographic plate of printing unit 22.

Referring now to FIGURE 4, FIGURE 5 and FIGURE 6, the in-line inking/coating apparatus 10 includes a carriage assembly 58 which supports an applicator head 60. The applicator head 60 includes a hydraulic motor 62, a lower gear train 64, an upper gear train 65, an applicator roller 66 and a doctor blade assembly 68. The external peripheral surface of the applicator roller 66 is inserted into wetting contact with liquid coating material or ink contained in a reservoir 70. The reservoir 70 is continuously supplied with ink or coating which is circulated through the reservoir 70 from an off-press source by a pump (not illustrated). The hydraulic motor 62 drives the applicator roller 66 synchronously with the plate cylinder 32 and the blanket cylinder 34 in response to an RPM control signal from the press drive (not illustrated) and a feedback signal developed by a tachometer 72. While a hydraulic drive motor is preferred, an electric drive motor can be used.

The applicator roller 66 is preferably a fluid metering anilox roller which transfers measured amounts of printing ink or coating material onto the printing plate or blanket. The surface of an anilox roller is engraved with an array of closely spaced, shallow depressions referred to as "cells". Ink or coating material from the reservoir 70 flows into the cells as the anilox roller turns through the reservoir. The transfer surface of the anilox roller is scraped with a doctor blade 73 to remove excess ink or coating. The ink or coating remaining on the anilox roller is the measured amounts contained within the cells.

The applicator roller 66 is cylindrical and may be constructed in various diameters and lengths, containing cells of various sizes and shapes. The volumetric capacity of an anilox roller is established during manufacturing and is dependent upon the selection of cell size, shape and number of cells per unit area. Depending upon the intended application, the cell pattern may be fine (many small cells per unit area) or coarse (fewer larger cells per unit area).

By applying the ink or coating material through the inking/coating applicator head 60, more ink or coating material can be delivered to the sheet S as compared with the inking roller train of a lithographic printing unit. Moreover, color intensity is stronger and more brilliant because the flexographic ink is applied at a much larger film thickness than can be applied by the lithographic process and is not diluted by dampening solution.

The inking/coating applicator head 60 includes side frame members 74, 76 that support the applicator roller 66, gear train 64, gear train 65, doctor blade assembly 68 and the drive motor 62. The applicator roller 66 is supported at opposite ends on a lower cradle formed by a pair of end plates 78, 80 which hold the applicator roller 66 in parallel alignment with the blanket cylinder 34 (FIGURE 5). The side frames 74, 76 are also pro-

vided with an upper cradle formed by a pair of side plates 82, 84 which are vertically spaced with respect to the lower side plates 78, 80. Each cradle has a pair of sockets 79, 81 and 83, 85, respectively, for holding the applicator roller 66 for spot coating or inking engagement against the plate P of the plate cylinder 32 (FIGURE 4) or the blanket B of the blanket cylinder 34.

Preferably, the applicator roller 66 for the upper cradle (plate) position is an anilox roller having a resilient transfer surface. In the dual cradle arrangement, the press operator can quickly change over from blanket inking/coating and plate inking/coating with minimum press down time, since it is only necessary to remove and reposition or replace the applicator roller 66, and wash-up the doctor blade assembly if changing from ink to coating or vice versa. The capability to selectively operate in either the flexographic mode or the lithographic mode and to print or coat from either the plate or blanket position is referred to herein as the "LITHOFLEX" process.

Referring again to FIGURE 2 and FIGURE 3, the applicator head 60 is supported by the carriage assembly 58 in a cantilevered, pivotal arrangement which allows the dual cradle inking/coating apparatus 10 and a single cradle inking/coating apparatus 110 to be used between any two adjacent printing units, as well as used on the first and last printing units of the press. This is made possible by a pair of cantilevered support arms 88, 90 that are pivotally coupled to the side plates 74, 76, respectively, on a pivot shaft 77. Each support arm has a hub portion 88A, 90A, respectively, and an elongated shank portion 88B, 90B, respectively.

The cantilevered support arms are pivotally mounted on the printing tower by pivot blocks 92, 94, respectively. The hub portions 88A, 90A are journaled for rotation on pivot shafts 96, 98, respectively. The pivot blocks 92, 94 are securely fastened to the tower 14D, so that the carriage assembly 58 is pivotally suspended from the pivot shafts 96, 98 in a cantilevered Ferris support arrangement. The shank portions 88B, 90B are pivotally coupled to the pivot shaft 77, so that the carriage assembly 58 and the applicator head 60 are capable of independent rotation with respect to each other and with respect to the pivot shaft 77. By this arrangement, the applicator head 60 is pivotally suspended from the pivot shaft 77, and remains in an upright orientation as the support arms rotate from the operative position to the fully retracted position, and vice versa.

Thus, the cradles 78, 80 and 82, 84 position the applicator roller 66 in vertical and horizontal alignment with the plate cylinder or blanket cylinder when the applicator head is extended to the operative position, for example as shown in FIGURE 4 and FIGURE 5. Moreover, because of the transverse relationship between the hub portion and shank portion of the support arms, the applicator head 60 and carriage assembly 58 are capable of rotating through a Ferris arc without touching the adjacent printing tower. This makes it possible to install the inking/coating apparatus 10 on any intermedi-

ate printing unit tower (T2, T3), and as well as on the first printing unit tower T1 and the last printing unit tower T4. Additionally, when the inking/coating unit 10 is in the operative position, the lateral projection of the applicator head 60 into the interstation space between printing units is minimized. This assures virtually unrestricted operator access to the interstation space between adjacent printing units when the applicator head is engaged in the operative position, and completely unrestricted access when the carriage assembly 58 is retracted.

Rotation of the carriage assembly 58 is counterclockwise from the retracted, idle position (shown in phantom in FIGURE 1) to the operative position (FIGURE 4 and FIGURE 5). The carriage assembly 58 can be adapted for clockwise rotation from the retracted position to the operative position for engagement of the applicator roller to either the plate or the blanket on the dampener side of the tower, assuming that access to the plate and blanket is not restricted by dampener rollers or the like.

Rotational movement of the support arms 88, 90 is assisted by counterweights 100, 102 which are secured to the support arms, respectively, for concurrent rotation with respect to the pivot blocks 92, 94. With the passive assistance of the counterweights, the press operator can easily move the inking/coating assembly 10 from the engaged operative position as shown in FIGURE 4 to the fully retracted, idle position as shown in phantom in FIGURE 1. Preferably, rotation of the carriage assembly 58 is assisted by a torsion spring, electric motor or hydraulic motor.

The inking/coating apparatus 10 is releasably locked into the operative position as shown in FIGURE 4 by releasable latch couplings 103, 105 that secure the support arms 88, 90 to the press side frames 14, 18, respectively, of the printing unit tower T4 in the operative position. Coating engagement of the applicator roller 66 against the blanket cylinder 34 is produced by power actuators, preferably pneumatic cylinders 104, 106 which have extendable/retractable power transfer arms 104A, 106A, respectively. The pneumatic cylinder 104 is pivotally coupled to the support arm 88 by a pivot linkage 108, and the second pneumatic cylinder 106 is pivotally coupled to the support arm 90 by a pivot linkage 109. In response to actuation of the pneumatic cylinders 104, 106, the power transfer arms are retracted. As the transfer arms retract, the inking/coating head 60 is rotated counterclockwise on the pivot shaft 77, thus moving the applicator roller 66 into coating engagement with the blanket cylinder 34.

The pivot linkage 108 includes a bell crank 111 which is mounted for pivotal movement on a pin 113. The pin 113 is supported by a clevis plate 115 which is attached to the support arm 88. One end of the bell crank is pivotally coupled to the actuator arm 104A, and a cam roller 117 is mounted for rotation on its opposite end.

The cam roller 117 is engagable against an adjustable stop 119 which is rigidly secured to the side plate

74. Counterclockwise shifting of the handle H moves a cam follower 121 into a latch pocket 123 of a receiver block 125 as the cam roller 117 is moved into engagement with the adjustable stop 119 in the interlocked, operative position. Referring to FIGURE 4, FIGURE 5 and FIGURE 6, the receiver block 125 is secured to the delivery side of the printing unit tower by machine screws.

When the plate P goes on impression, power is applied to the pneumatic actuator 104 and the power transfer arm 104A retracts, thus causing the bell crank 111 to rotate counterclockwise about the pin 113. The torque applied by the pneumatic actuator 104 is transmitted to the applicator head 60 through the cam roller 117 and the adjustable stop 119. Counterclockwise movement of the applicator head 60 relative to the support shaft 77 carries the applicator roller 66 into engagement with the plate P.

The adjustable stop 119 has a threaded bolt 119A which is engagable with the cam roller 117. The striking point of engagement is preset so that the applicator roller 66 is properly positioned for engagement with the plate P or blanket B in the operative position when the applicator head 60 is interlocked with the press frame 14 and the printing unit goes on impression.

Referring to FIGURE 5, an inking/coating apparatus 110 having a single head is illustrated. The construction of this alternative embodiment is identical in all respects with the dual head arrangement, with the exception that only a single gear train and a single cradle for holding the applicator roller is provided. In both embodiments, the inking/coating head 60 remains upright as it swings through an arc, comparable to the movement of a Ferris wheel. Because of the upright orientation of the inking/coating head 60 as it moves between the extended and retracted positions, the usual platform spacing between printing unit towers provides adequate clearance to permit extension and retraction of the carriage assembly 58 without interference with operator access to the printing units. This is a significant advantage in that it permits the in-line inking/coating apparatus 10 to operate effectively in the interstation space between any adjacent printing units, and without blocking or obstructing access to the cylinders of the printing units when the inking/coating apparatus is in the retracted position (as indicated in phantom in FIGURE 1).

Moreover, when the in-line inking/coating apparatus is in the fully retracted position, the applicator roller 66 is conveniently positioned on the dampener side of the printing unit for inspection, clean-up or replacement. Additionally, the doctor blade assembly is also conveniently positioned for inspection, removal, adjustment or clean-up. Also, the doctor blade reservoir and coating circulation lines can be cleaned while the press is running as well as when the press has been stopped for change-over from one type of ink or coating material to another.

When the inking/coating apparatus is used for applying an aqueous ink or an aqueous coating material, the water component on the freshly printed sheet S is evaporated by a high velocity, hot air interstation dryer and high volume heat and moisture extractor units 112 and 114, as shown in FIGURE 1, FIGURE 4 and FIGURE 5. The dryer/extractor units 112 and 114 are oriented to direct high velocity heated air onto the freshly printed/coated sheets as they are transferred by the interunit and the intermediate transfer cylinders 36, 40. By this arrangement, the freshly printed aqueous ink or coating material is completely dry before the sheet is overprinted in the next printing unit.

The high velocity, hot air dryer and high performance heat and moisture extractor units 112, 114 utilize high velocity air jets which scrub and break-up the moist air level which clings to the surface of each freshly printed sheet. Within each dryer, high velocity air is heated to a high temperature as it flows across a resistance heating element within an air delivery baffle tube. High velocity jets of hot air are discharged through multiple airflow apertures through an exposure zone Z (FIGURE 4 and FIGURE 5) onto the freshly printed/coated sheet S as it is transferred by the transfer cylinder 36 and intermediate transfer cylinder 40, respectively. Each dryer assembly includes a pair of air delivery dryer heads which are arranged in spaced, side-by-side relation as shown in FIGURE 4 and FIGURE 5.

The high velocity, hot moisture-laden air displaced from each freshly printed sheet is extracted from the dryer exposure zone Z and completely exhausted from the printing unit by the high volume extractors. Each extractor head includes a manifold coupled to the dryer heads and draws the moisture, volatiles and high velocity hot air through a longitudinal gap between the dryer heads. According to this arrangement, each printed sheet is dried before it is run through the next printing unit.

The water-based inks used in flexographic printing dry at a relatively moderate drying temperature provided by the interstation high velocity hot air dryers/extractors 112, 114. Consequently, print quality is substantially improved since the aqueous ink is dried at each printing unit before it enters the next printing unit. Moreover, back-trapping on the blanket of the next printing unit is completely eliminated. This interstation drying arrangement makes it possible to print aqueous inks such as metallic ink and opaque white ink at one printing unit, and then overprint at the next printing unit.

This arrangement also permits the first printing unit to be used as a coater in which an aqueous coating is applied to low grade paper, for example recycled paper, to trap and seal in lint, dust, spray powder and other debris and provide a smoother, durable surface that can be overprinted in the next printing unit. The first down coating seals the surface of the low grade, rough substrate and improves overprinted dot definition while preventing strike-through and show-through. A UV-curable

protective and/or decorative coating can be applied over the first down overprinted (aqueous) coating in the last printing unit.

Preferably, the applicator roller 66 is constructed of metal or ceramic when it is used for applying a coating material to the blanket B on the cylinder 34. When the applicator roller 66 is applied to the plate, it is preferably constructed as an anilox roller having a resilient transfer surface for engaging a flexographic printing plate. Suitable resilient roller surface materials include Buna N synthetic rubber and EPDM (terpolymer elastomer).

It will be appreciated that the inking/coating apparatus 10 is capable of applying a wide range of ink types, including fluorescent (Day Glo), pearlescent, metallics (gold, silver and other metallics), glitter, scratch and sniff (micro-encapsulated fragrance), scratch and reveal, luminous, pressure-sensitive adhesives and the like.

The press operator can eliminate the dampener roller assembly altogether, and the inking/coating apparatus 10 can selectively apply aqueous inks and coatings to a flexographic or waterless printing plate and the blanket. Moreover, overprinting of the aqueous inks and coatings can be carried out in the next printing unit since the aqueous inks and coatings are completely dried by the high velocity, hot air interstation dryer and high volume heat and moisture extractor assembly.

The aqueous inks and coatings as used in the present invention contain colored pigments and/or soluble dyes, binders that fix the pigments onto the surface of the printed sheet, and waxes, defoamers and thickeners. Aqueous printing inks predominantly contain water as a solvent, diluent and/or vehicle. The thickeners which are preferred include alginates, starch, cellulose and its derivatives, for example cellulose esters or cellulose ethers and the like. Coloring agents including organic as well as inorganic pigments may be derived from dyes which are insoluble in water. Also, the printing ink may contain water and can be predominantly glycol or the like, with the pigment being bound by an appropriate resin. When metallic inks are printed, the cells of the anilox roller must be appropriately sized to prevent the metal particles from getting stuck within the cells. The cell size is critical, and for metallic gold ink, the anilox roller should have a screen line count in the range of 175-300 lines per inch (69-118 lines per cm).

The inking/coating apparatus 10 can also apply UV-curable inks and coatings. If UV-curable inks and coatings are utilized, ultra-violet dryers/extractors are installed adjacent the high velocity hot air dryer/extractor units 112, 114, respectively.

It will be appreciated that the inking/coating apparatus 10 described herein makes it possible to selectively operate a printing unit in either the flexographic printing mode or the lithographic printing mode, while also providing the capability to print or coat from either the plate or blanket position. The dual cradle support arrangement of the present invention makes it possible to quickly change over from inking/coating at the blanket

cylinder position to inking/coating at the plate cylinder position with minimum press down-time, since it is only necessary to remove and reposition or replace the applicator roller 66 while the printing/inking apparatus is in the retracted position.

Moreover, the press operator may elect to spot or overall coat with aqueous ink/coating from the plate during one job, and then spot and/or overall coat from the blanket during the next job. Since the doctor blade assembly can be flushed and washed-up quickly and the applicator roller can be replaced quickly, it is possible to spot coat or overall coat from the plate position or the blanket position with aqueous inks or coatings during the first press run and then spot coat or overall coat with UV-curable inks or coatings from the plate position or from the blanket position during the next press run. The inking/coating apparatus 10 is completely out of the way in the retracted position; consequently, the doctor blade reservoir and supply lines can be flushed and washed-up by automatic wash-up equipment while the printing unit is printing another job.

The positioning of the applicator head and roller assembly relative to the plate and blanket is repeatable to a predetermined, preset impression position. Consequently, no printing unit adjustment or alteration is required, except for flushing the doctor blade assembly and cleaning or replacing the applicator roller to accommodate a different kind of ink or coating material. Although manual extension and retraction have been described in connection with the exemplary embodiment, extension to the operative position and retraction to a non-operative idle position can be carried out automatically by hydraulic or electric motor servomechanisms.

The Ferris wheel support arrangement allows the inking/coating apparatus to operate effectively in the interstation space between any adjacent printing units, as well as on the first or last printing units of the press, without blocking or obstructing the interstation space or restricting operator access to the cylinders of any of the printing units.

Finally, because the inking/coating apparatus of the present invention is mounted on a printing unit tower and is extendable to the operative position without requiring adjustment or alteration of the printing unit cylinders, it can be used for applying printing ink or coating material to the blanket cylinder of a rotary offset web press, or to the blanket of a dedicated coating unit.

Claims

1. Inking/coating apparatus (10) for use in a printing press (12) of the type having a printing unit (22, 24, 26, 28) on which a plate cylinder (32), a blanket cylinder (34) and an impression cylinder (36) are mounted for rotation, wherein the inking/coating apparatus is characterized by:

an applicator head (60) for applying ink or coating material to a plate (P) mounted on the plate cylinder or to a blanket (B) mounted on the blanket cylinder, either separately or simultaneously when the inking/coating apparatus is in an operative position relative to the plate and blanket cylinders; and,

a carriage assembly (58) for moving the applicator head to the operative position in which the applicator head is disposed laterally adjacent to the plate and blanket cylinders and for moving the applicator head from the operative position to a retracted position in which the applicator head is elevated with respect to the plate and blanket cylinders.

2. Inking/coating apparatus (10) as set forth in claim 1, wherein the carriage assembly (58) is characterized by:

a support arm (88, 90) having a first end portion (88A) constructed for pivotal attachment to the printing unit and having a second end portion (88B) pivotally coupled to the applicator head (60), the applicator head being movable on the support arm to the operative position.

3. Inking/coating apparatus (10) as set forth in claim 1, characterized in that a counterweight (100, 102) is coupled to the carriage assembly.

4. Inking/coating apparatus (10) as set forth in claim 1, wherein the applicator head (60) is characterized by:

a doctor blade assembly (68) having a reservoir (70) for receiving ink or liquid coating material; and,

an applicator roller (66) coupled to the doctor blade assembly in fluid communication with the reservoir, the applicator roller being engagable with a printing plate (P) on the plate cylinder or with a blanket (B) on the blanket cylinder when the applicator head (60) is in the operative position.

5. Inking/coating apparatus (10) as set forth in claim 4, characterized in that the applicator roller (66) is an anilox roller having a resilient transfer surface.

6. Inking/coating apparatus (10) as set forth in claim 1, characterized in that:

a power actuator (104, 106) is movably coupled to the applicator head (60), the power actuator having a power transfer arm (104A, 106A) which is extendable and retractable; and, movement converting apparatus (108) is coupled to the power transfer arm for converting

extension or retraction movement of the power transfer arm into pivotal movement of the applicator head (60) relative to the carriage assembly.

7. Inking/coating apparatus (10) as set forth in claim 6, wherein the movement converting apparatus (108) is characterized by:

a bell crank plate (111) having a first end portion coupled to the power transfer arm and having a second end portion for engaging a stop member;

a stop member (119) secured to the applicator head (60); and,

a clevis plate (115) secured to the carriage assembly (58) and pivotally coupled to the bell crank plate.

8. Inking/coating apparatus (10) as set forth in claim 1, wherein the applicator head (60) is characterized by:

first and second side frame members (74, 76) pivotally coupled to the carriage assembly (58); a doctor blade assembly mounted on the first and second side frame members, the doctor blade assembly including a reservoir (70) for receiving ink or liquid coating material;

a cradle assembly (78, 80), (82, 84) mounted on the first and second side frame members, respectively;

an applicator roller (66) mounted for rotation on the cradle assembly and coupled to the doctor blade assembly for rolling contact with ink or coating material in the reservoir, the applicator roller being engagable with a printing plate (P) on the plate cylinder (32) or with a blanket (B) on the blanket cylinder (34) when the applicator head (60) is in the operative position; and,

a drive motor (62) coupled to the applicator roller for rotating the applicator roller.

9. Inking/coating apparatus (10) as set forth in claim 8, characterized in that:

the cradle assembly (79, 80) has first and second sockets (79, 81) disposed on the first and second side frame members respectively; and, the applicator roller (66) is mounted for rotation on the first and second sockets.

10. Inking/coating apparatus (10) as set forth in claim 8, characterized in that:

the cradle assembly (78, 80), (82, 84) includes first and second sockets (79, 81) disposed on the first and second side frame members, respectively, and third and fourth sockets dis-

posed on the first and second side frame members, respectively; and,

the applicator roller (66) is selectively mountable for rotation on either the first and second sockets or on the third and fourth sockets for applying ink or coating material to either the plate or blanket when the applicator head is in the operative position.

11. Inking/coating apparatus (10) as set forth in claim 1, wherein the applicator head (60) is characterized by:

a first cradle (78, 80) for supporting an applicator roller (66) for engagement with the plate when the inking/coating apparatus is in the operative position; and

a second cradle (82, 84) for supporting an applicator roller (66) for engagement with the blanket (B) when the inking/coating apparatus is in the operative position.

12. Inking/coating apparatus (10) as set forth in claim 1, wherein the carriage assembly is characterized by:

a support arm (88, 90) having a first end portion pivotally coupled to the printing unit (88A, 90A) and having a second end portion (88B, 90B);

a common pivot shaft (77) on which the support arm second end portion and the inking/coating apparatus are pivotally mounted; and,

male and female latch members (103, 105) coupled between the common pivot shaft and the printing unit, with one of the latch members being secured to the common pivot shaft and the other latch member being constructed for attachment onto the printing unit, the latch members being mateable in interlocking engagement when the applicator head (60) is in the operative position.

13. Inking/coating apparatus (10) as set forth in claim 1, wherein the applicator head (60) and the printing unit are characterized by:

male and female latch coupling members (103, 105) mounted on the carriage assembly (58) and on the printing unit for releasably latching the carriage assembly in interlocking engagement with the printing unit when the applicator head is in the operative position.

14. Inking/coating apparatus (10) as set forth in claim 1, wherein the carriage assembly (58) is characterized by an elongated shank portion (88B, 90B) and a hub portion (88A, 90A), the elongated shank portion being pivotally coupled to the applicator head

(60) and the hub portion being constructed for pivotal attachment onto the printing unit.

15. A rotary offset printing press (12) having first and second printing units (22, 24) and the inking/coating apparatus (10) of claim 1 is movably coupled to the first printing unit (22) as set forth in claim 1, characterized by:

a dryer (112) mounted on the first printing unit adjacent the impression cylinder (36) of the first printing unit for discharging heated air onto a freshly printed substrate while the freshly printed substrate is in contact with said impression cylinder.

16. A rotary offset printing press (12) as defined in claim 15, characterized in that:

an extractor (112E) is disposed adjacent the dryer for extracting hot air, moisture and volatiles from an exposure zone (Z) between the dryer and the freshly printed substrate.

17. A rotary offset printing press (12) as defined in claim 15, characterized in that:

an intermediate transfer cylinder (40) is coupled in sheet transfer relation with the impression cylinder (36) of the first printing unit (22); and, an interstation dryer (114) is disposed adjacent the intermediate transfer cylinder for discharging heated air onto a freshly printed or coated substrate after it has been transferred from the impression cylinder of the first printing unit and while it is in contact with the intermediate transfer cylinder (40).

18. A method for rotary offset printing in a printing press (12) of the type including first and second rotary offset printing units (22, 24), and using aqueous or UV-curable printing ink or coating material in the operation of at least the first printing unit, characterized by the following steps performed at each printing unit in succession:

spot or overall coating a plate (P) with aqueous ink/aqueous coating material or UV-curable ink/UV-curable coating material;
spot and/or overall coating a blanket (B) with aqueous ink/aqueous coating material or UV-curable ink or UV-curable coating material;
transferring the printing ink or coating material from the printing plate (P) to the blanket (B);
transferring the inked or coated image from the blanket to a substrate (S) as the substrate is transferred through the nip between the

impression cylinder (36) and the blanket (B); and,

drying the ink or coating material on the freshly printed substrate before the substrate is subsequently processed.

19. A method for rotary offset printing as defined in claim 18, wherein the drying step is characterized by:

discharging high velocity, heated air onto the freshly printed/coated substrate (S) while the freshly printed/coated substrate is in contact with the impression cylinder (36) of the first printing unit (22).

20. A method for rotary offset printing as defined in claim 18, characterized by the steps:

transferring the freshly printed substrate (S) from the first printing unit (22) to an intermediate transfer cylinder (40); and, drying the freshly printed substrate while it is in contact with the intermediate transfer cylinder.

21. A method for rotary offset printing as defined in claim 18, characterized by the step:

extracting hot air, moisture and volatiles from an exposure zone (Z) above the freshly printed/coated substrate (S) while the freshly printed/coated substrate is in contact with the impression cylinder (36).

22. A method for rotary offset printing as defined in claim 18, characterized by the steps:

applying a primer coating of an aqueous coating material or UV-curable coating material to a substrate (S) in the first printing unit (22); and, drying the primer coating on the substrate before the substrate is processed in the second printing unit.

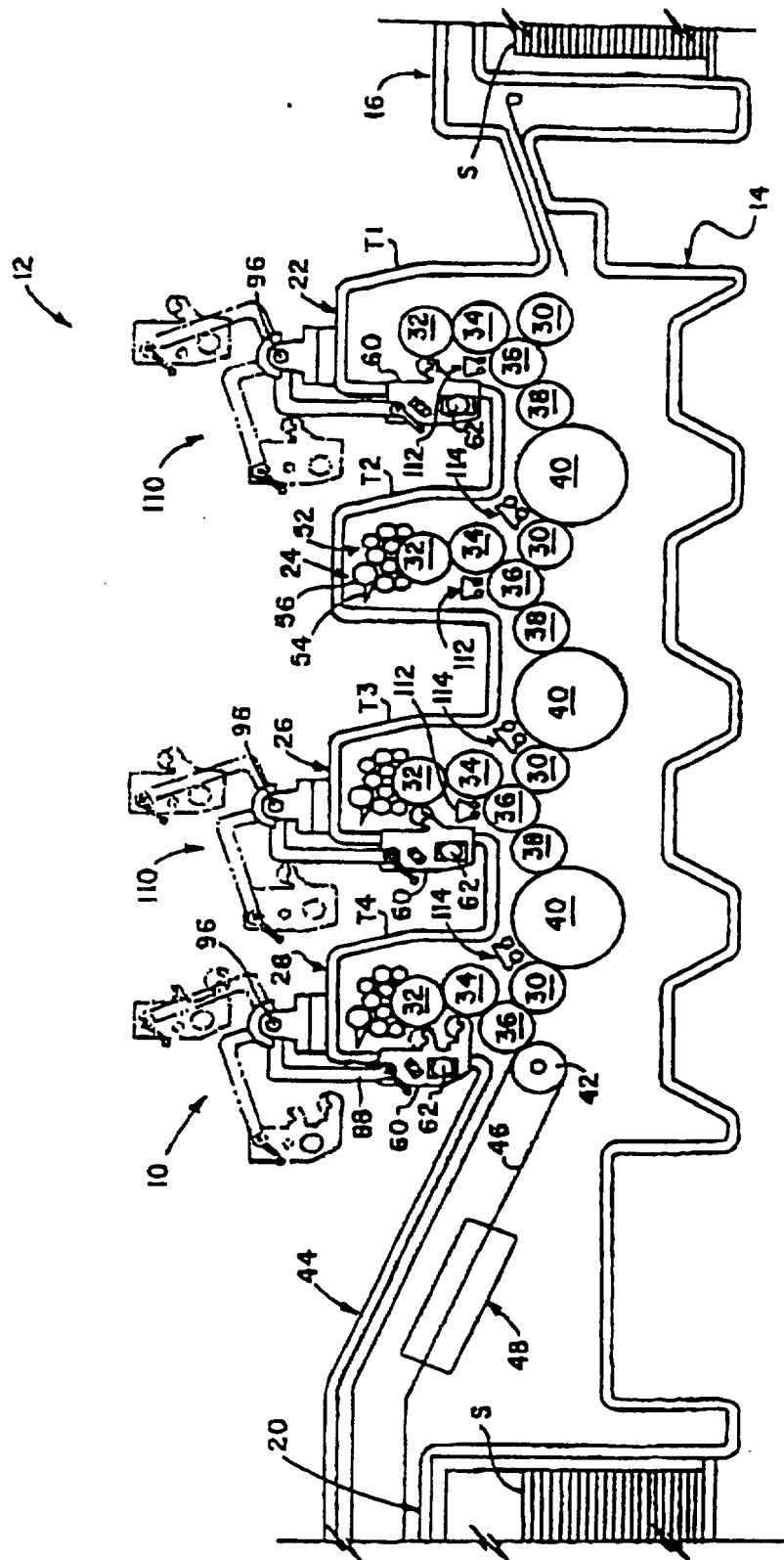


FIG. 1

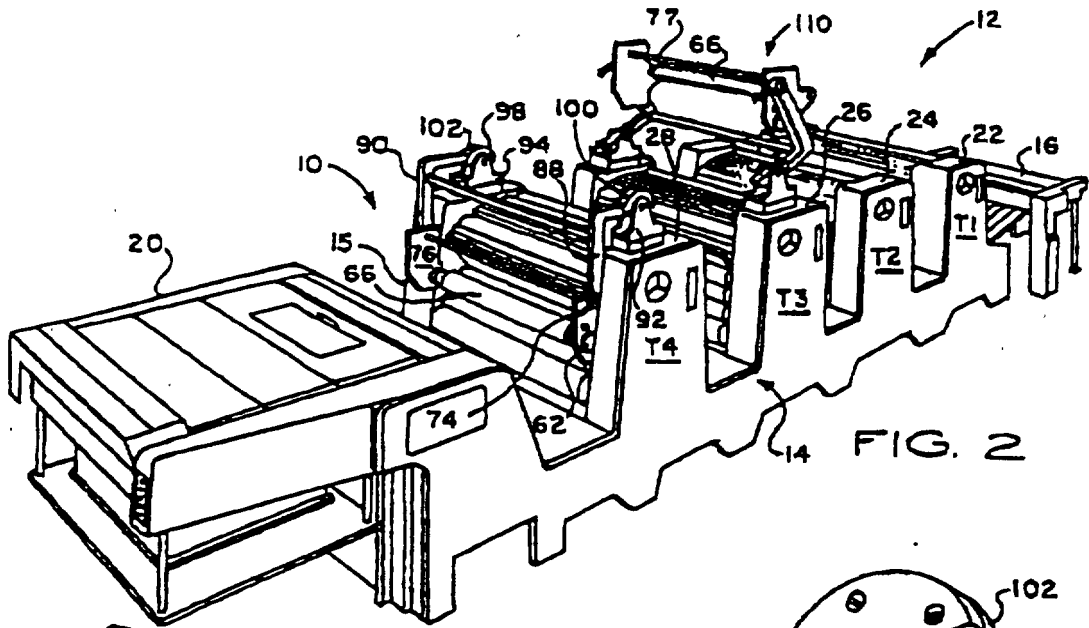


FIG. 2

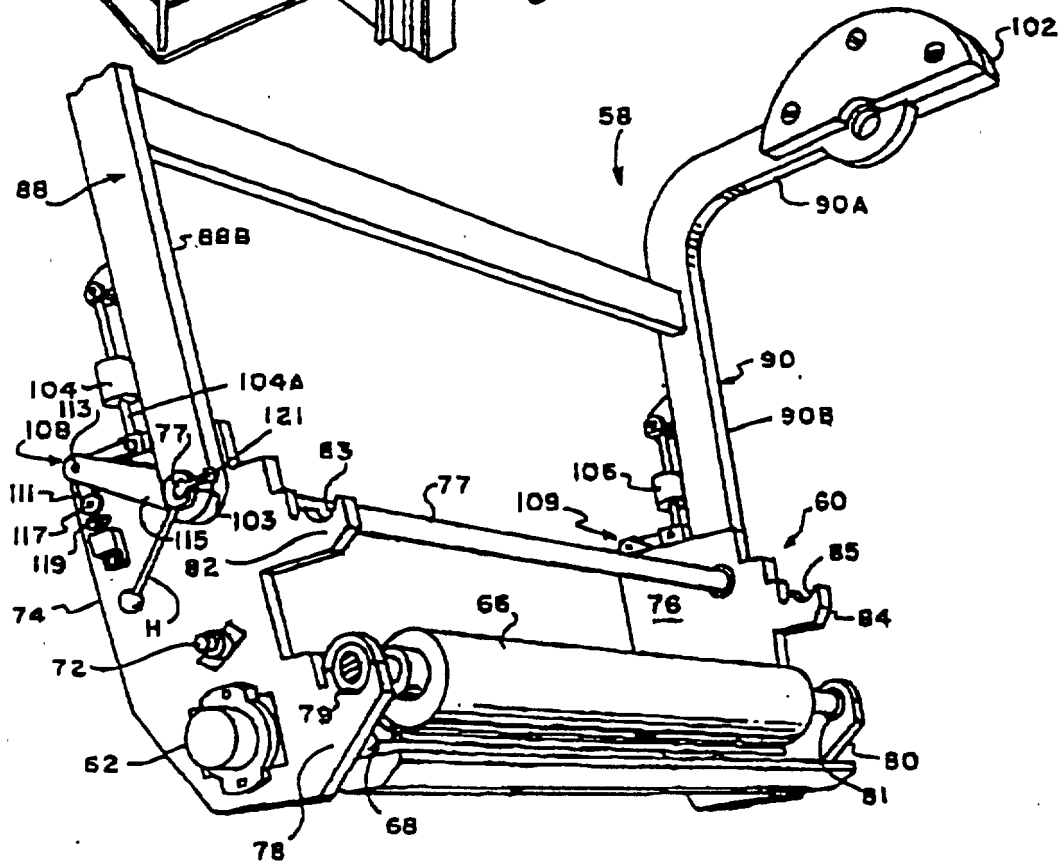


FIG. 3

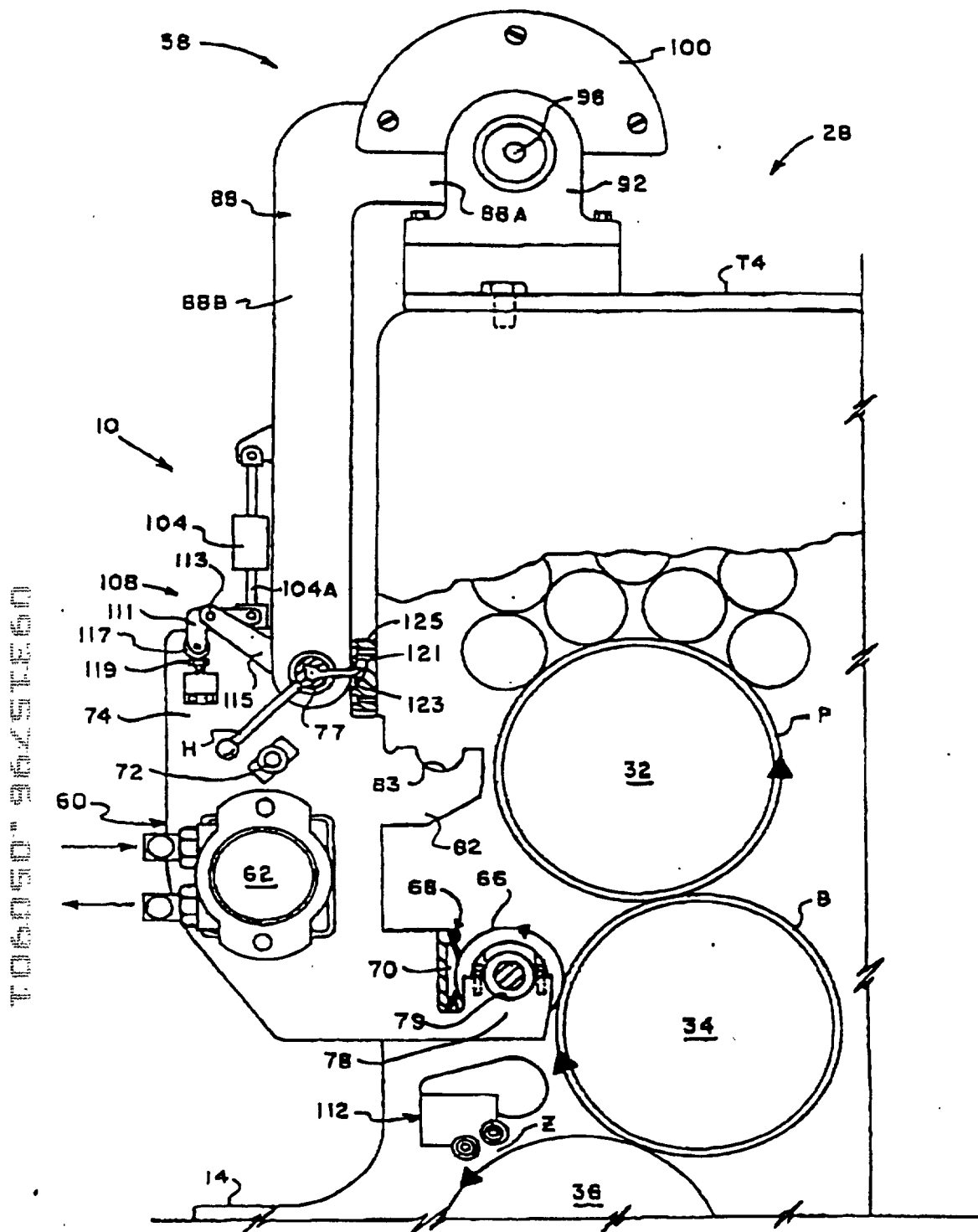
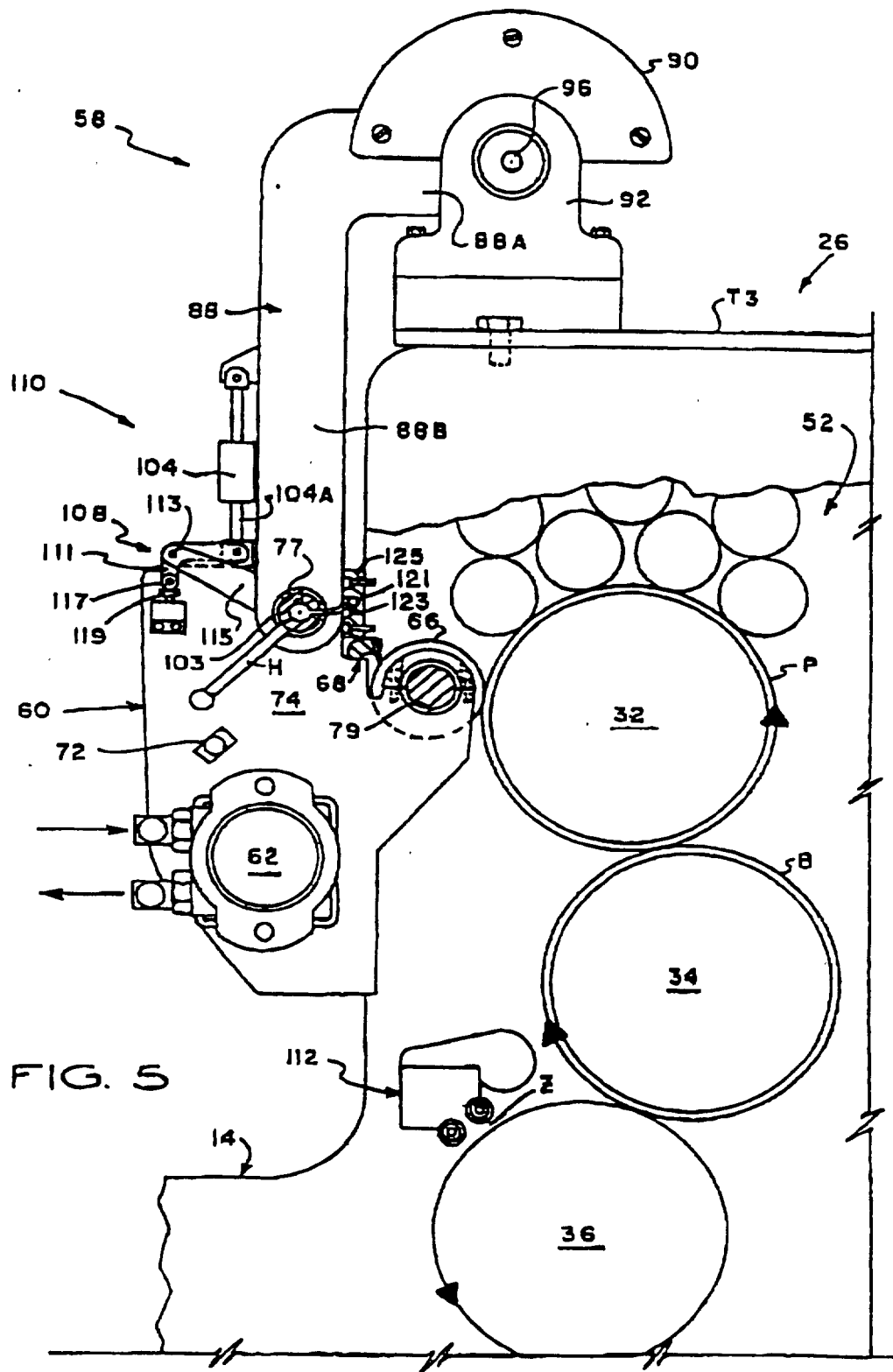


FIG. 4



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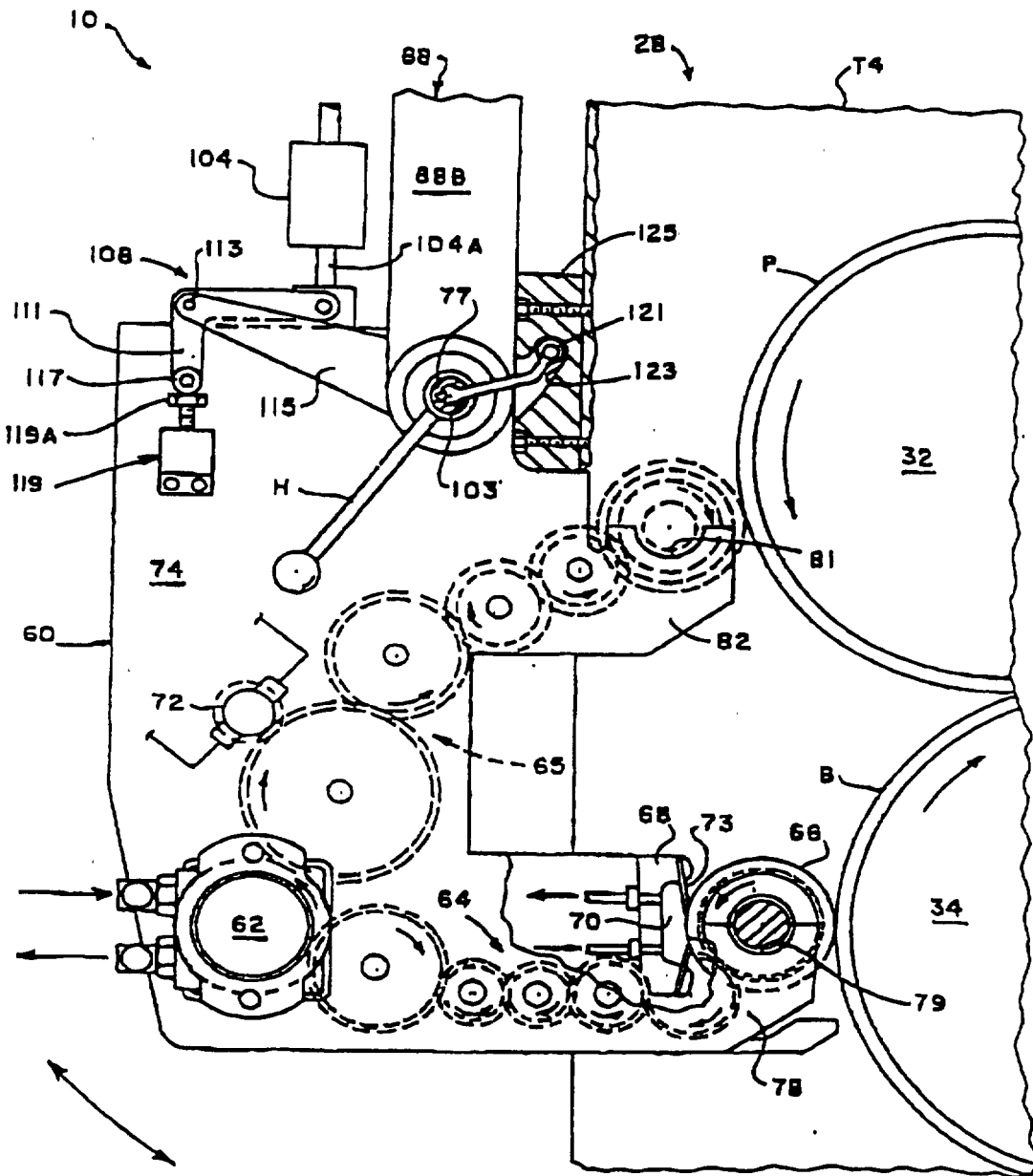


FIG. 6

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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re the Reissue Application of:

BILL L. DAVIS and JESSE S. WILLIAMSON

For Reissue of U. S. Patent 5,630,363

Issued May 20, 1997

Serial No. 08/515,097

Filing Date: May 20, 1999

Serial No.: 09/315,796

For:

**COMBINED LITHOGRAPHIC/
FLEXOGRAPHIC PRINTING
APPARATUS AND PROCESS**



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§ Group Art Unit: 2854
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§ Examiner: S. Funk
§ J. Hilten
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DECLARATION OF STEVE M. GARNER

TO: The Honorable Commissioner of Patents and Trademarks
Washington, D.C. 20231

SIR:

I, Steve M. Garner, declare on my oath the following:

1. "I am over twenty-one (21) years of age, have never been convicted of a felony, and am competent to make this testimony. I am Regional Sales Manager, South Central Region for Harris and Bruno (Central Office: Roseville, California). I reside at 209 Mill Creek Drive, Arlington, Texas 76010. My curriculum vitae is attached hereto as Exhibit A.

2. "I was employed by Printing Research, Inc. ("PRI") from about April of 1994 through March of 2000. From the time I came to work until January 1997, I was Vice President of Sales for PRI, thereafter President through January 1998, and have held various other positions at PRI from January 1998 until my departure at the end of March, 2000.

3. "During the second half of 1994, during my tenure as Vice President of Sales of PRI, John Bird reported to me as Sales Manager. It became known to me during the summer of 1994 that Williamson Printing Corporation ("WPC") was seeking to purchase a number of IR and UV dryers for its new Heidelberg presses, the first of which was scheduled to arrive in late 1994. WPC's investment in a series of offset lithographic presses represented a double

09/315,796-0000

7. In January of 1995, I was in Heidelberg, Germany at the Holiday Inn when Bill Davis came up to me, telling me something about some extraordinary results they had achieved at the plant of Heidelberg Drucksmachinen A.G. demonstrating a flexography step first compared to the older way that they had done it (WIMS), for some Rolex advertisements. I was encouraged by this, but would not know until March 20, 1995 when I saw some tests run at Williamson Printing Corporation how this would perform with PRI anilox coater.

8. In late February 1995, PRI installed our "short-arm" "rack-back" device on one of the coater towers, a new Heidelberg press at WPC. On or about March 20, 1995, I saw some tests run simulating the new process of WPC using the "short-arm" PRI pilot device concerning a middle-age advertisement – involving the Crusader, as I recall – using a flexographic step followed by multiple lithographic steps. Bill Davis and Jim Johnson were in control, giving directions to subordinates concerning the use of flexographic plates, flexographic inks and the negatives.

9. At no time during 1994, 1995, 1996 or 1997 did I ever hear Howard DeMoore, John Bird, Ron Rendleman, or anyone else at PRI ever indicate that the process of using a flexographic step prior to offset lithography was a PRI process or that they invented such a process, or any one of them invented such a process. After becoming aware of the Williamson's WIMS ('976) process, there was never a doubt in my mind that the process of using a flexographic step first originated at WPC. PRI did, however, after DRUPA 95 (starting May 5, 1995), demonstrate to several clients the feasibility of applying a flexographic material as a first down with the idea of overprinting litho in-line. This, of course, could only be demonstrated as multiple passes since PRI had only a 2/c press.

10. In April of 1995, after installation of the experimental pilot "short-arm" device at Williamson, PRI ordered from a local printer – Buchanan Lithographics, as I recall – some brochures concerning a proposed interstation "ferris wheel" or cantilevered "rack-back". Williamson had committed orally to us in February of 1995 to purchase at least one interstation "rack-back" which was currently in design along with the "short-arm", cantilevered device. PRI obtained, as I recall, a firm commitment to go ahead with the construction of the device in May 1995. I recall that as of the DRUPA conference at the start of May 1995, apart from the short-

WPC for a license on the grounds, as I understood at the time, that he had been involved in 1994 through 1995 in the design of the cantilevered "rack-back" device to be used in that process -- in DeMoore's words, he "enabled" them to use the process --, and on that basis, he reasoned he should not have to pay WPC any money.

The undersigned Declarant stated further that all statements made herein of Declarant's own knowledge are true, and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code.

Steve M. Garner

Steve M. Garner

April 6, 2000

Date:

10050-364460

STEVE MART GARNER
209 Mill Creek Drive
Arlington, Texas 76010
(817) 265-8375

EDUCATION: UNIVERSITY OF TEXAS AT ARLINGTON
B.S., Mechanical Engineering (Minor: Chemistry)

MILITARY: U.S. COAST GUARD (Enlisted), Honorable Discharge

BUSINESS EXPERIENCE:

1994 - Present PRINTING RESEARCH, INC., Dallas TX

\$12,000,000 company producing custom designed accelerated drying systems, i.e., infrared, ultraviolet, forced hot air, for the printing and converting industry. Company's original product was an innovative anti-marking system (Super Blue) still utilized on many sheet fed litho presses

'98 - Pres. Sales Director - OEM Accounts

Promote sale of capital equipment to the commercial sheet fed and flexo corrugated printer manufacturers. Obtain vendor certification for companies' products with major OEM accounts.

'97 - '98 President, COO

Assumed President position - duties remained same.

'96 - '97 Executive Vice President, Operations

Assumed overall operational responsibilities with the objective of developing the organization infrastructure to support the growing capital product line. This involved physical plant expansion and technical staffing for engineering, manufacturing and R & D. Continued to oversee the company's marketing programs.

'94 - '96 Vice President, Sales & Marketing

Directed the efforts of the domestic (US and Canada) direct sales group consisting of National Sales Manager, Product Manager, and five regional sales personnel during the expansion of the product line to include capital equipment sales. Responsible for coordinating the activities of the international dealer network in the continuing marketing of the original Super Blue product and the introduction of a new generation product improvement to major OEM's. Oversaw the advertising and trade show activities.

1990 - 1994 SUN GRAPHIC TECHNOLOGIES, Fort Worth TX

U.S. Subsidiary corporation for a Japanese publishing organization. Established in 1990 with the primary objectives of developing, designing and marketing new technology specifically for the Graphic Art Industry.

Vice President

Responsibilities included directing efforts of 10 engineers and technicians in the development and testing of new products for the improvement of printing quality with decreased environmental impact. Developed marketing programs for the sale and distribution of proven products into the domestic and international marketplace. Three patents issued for temperature control systems for offset printing presses.

1986 - 1990 EPIC PRODUCTS CORPORATION, Dallas TX

\$8,000,000 company involved in the design, manufacture and marketing of custom designed equipment for the printing and converting market.

Vice President - Sales & Marketing

Duties involved the direct sale of all products in the U.S. as well as overseeing and coordinating activities of international dealers in both Japan and Europe. Clients were printing and publishing companies as well as OEM accounts. Sales revenues increased an average of 20% per year during tenure.

Steve Mart Garner

Page 2

1986

CONSOLIDATED ENGRAVERS CORPORATION, Charlotte NC

\$25,000,000 company serving the converting, packaging and textile industries in the production of engraved cylinders for printing, coating and embossing.

General Manager, Southwest Plant, Lancaster TX

Responsibilities included regional sales activity and plant production. Facility staffed 25 personnel involved in engraving, manufacturing and electroplating of anilox rollers used in the converting industry. Clients included major packaging operations in the corrugated, paperboard, film and foil industries.

1973 - 1985

DAHLGREN INTERNATIONAL, Dallas TX

\$25,000,000 company manufacturing custom designed equipment for printing and paper converting industry.

'84 - '85

General Manager - Europe

Responsible for the parent company's European operations, which included a sales-service office in Brussels, Belgium and a manufacturing subsidiary in Augsburg, West Germany. The markets served by this operation included printing and publishing companies as well as the major OEMs producing equipment for worldwide distribution.

'82 - '84

Vice-President - Product Development

Responsibilities included management of all engineering groups, i.e., design engineering, production engineering and manufacturing engineering. In addition, coordinated activities related to the evaluation, design and testing of new products.

'78 - '82

Vice-President - Sales

Responsible for company total sales activities, which included five domestic regional sales managers, OEM sales, converting equipment sales, sales-service offices in Europe and Japan. Participated in the development and implementation of marketing plans for all company products, including budgets, projections, forecasts, dealer training, advertising and trade show participation.

'73 - '78

International Marketing Manager

Coordinated sales and marketing activities for company's European Branch office in Brussels, Belgium. In 1975, assumed full managerial responsibility for office, including P & L, Technical Support Staff, and Sales/Marketing expansion. Set up Dealer/Distribution Program in major European countries. During this time, the European branch grew to produce from less than 10% to over 50% of company's total revenue.